

DUO BORING BAR



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Redefining Cutting Technology

www.renukatools.in

Company Profile

Renuka Tools® was founded in the year 2000 in Aurangabad, India with its vision to be the preferred special cutting tools provider. We now successfully cater to both domestic and international markets with our wide range of solutions. We ensure that we remain nimble and agile by continually investing in technology & R&D to stay ahead of time & keep pace with the changing technology in the industry.

Renuka Tools® with its state-of-the-art manufacturing unit manufactures high quality special indexable cutting tools with utmost precision using the latest technology and highly skilled and technical manpower. All cutting tools manufactured at our unit come with a Zoller Report, ensuring that the global export quality standards are met, guaranteeing complete customer satisfaction.

At Renuka Tools®, our core expertise is in manufacturing special customized cutting tools. With over 20 years of technical expertise and continual R&D efforts, we manufacture products such as:

- ▶ Micro Bore Unit
- ▶ Adjustable Boring Tools
- ▶ Fine Boring Tools
- ▶ Eccentric Boring Tools
- ▶ Large diameter Boring Tools
- ▶ Anti-vibration Boring Tools
- ▶ Large Diameter Milling Cutters
- ▶ Spot Face Cutters
- ▶ Side & Face Milling Cutters
- ▶ Chamfer Tools

Why Us - What Differentiates us from Competition

- ▶ We use the best-in-class technology in our state-of-the-art manufacturing facility.
- ▶ We ensure best quality products adhering to global standards.
- ▶ We provide a QC Report along with our tools to certify the quality of the product, which is accepted world-wide.
- ▶ We ensure shortest lead times in manufacturing.
- ▶ All of the above is ensured at lowest possible price.

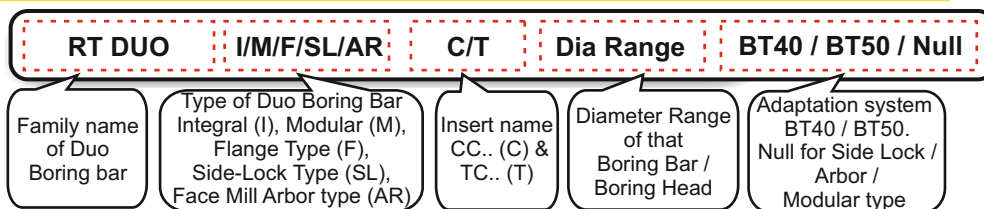
This catalogue will give you further insights and details about our Micro Bore Units. For more details of our other standard offerings, please refer to our website (www.renukatools.in).



Facts & Advantages

- ▶ Used for Rough Boring application from diameter 20mm to 500mm with scale marked on tool.
- ▶ Available with options of selecting either Integral / Modular / Flange type (for large diameters) / Side-Lock & Face Mill Arbor type depending on the requirement.
- ▶ User friendly, quick assembly & quick adjustment ensures minimum loss time.
- ▶ Most robust & heavy duty solution available for maximum material removal in shortest time possible. Around 2-6mm material can be cut diametrically in one pass depending on the size of insert & material of component.
- ▶ Comes with options of adding extensions for deep boring applications in modular type.
- ▶ Most economic solution for the complete range of diameters for Rough Boring applications.
- ▶ Apart from standard product range, tailor made tools & adaptors are also available on demand.

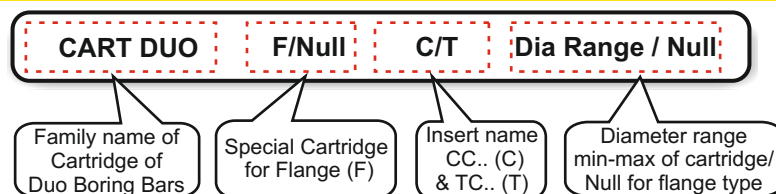
Nomenclature Code Key for Ordering Duo Boring Bar



Ordering Example:

1 piece
RT DUO IT 20-24 BT 40

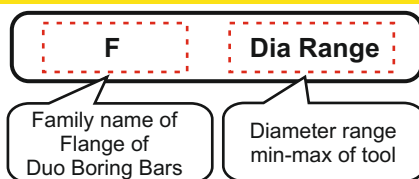
Nomenclature Code Key for Ordering Cartridge



Ordering Example:

1 piece
CART DUO T 20-24

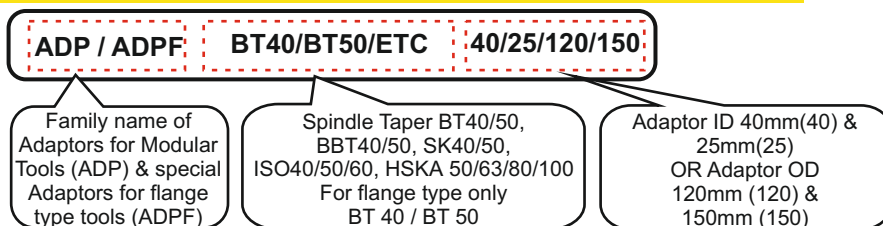
Nomenclature Code Key for Ordering Flange



Ordering Example:

1 piece
F 200-250

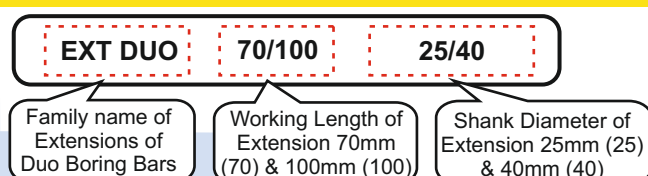
Nomenclature Code Key for Ordering Adaptor



Ordering Example:

1 piece
ADP BT 40 25

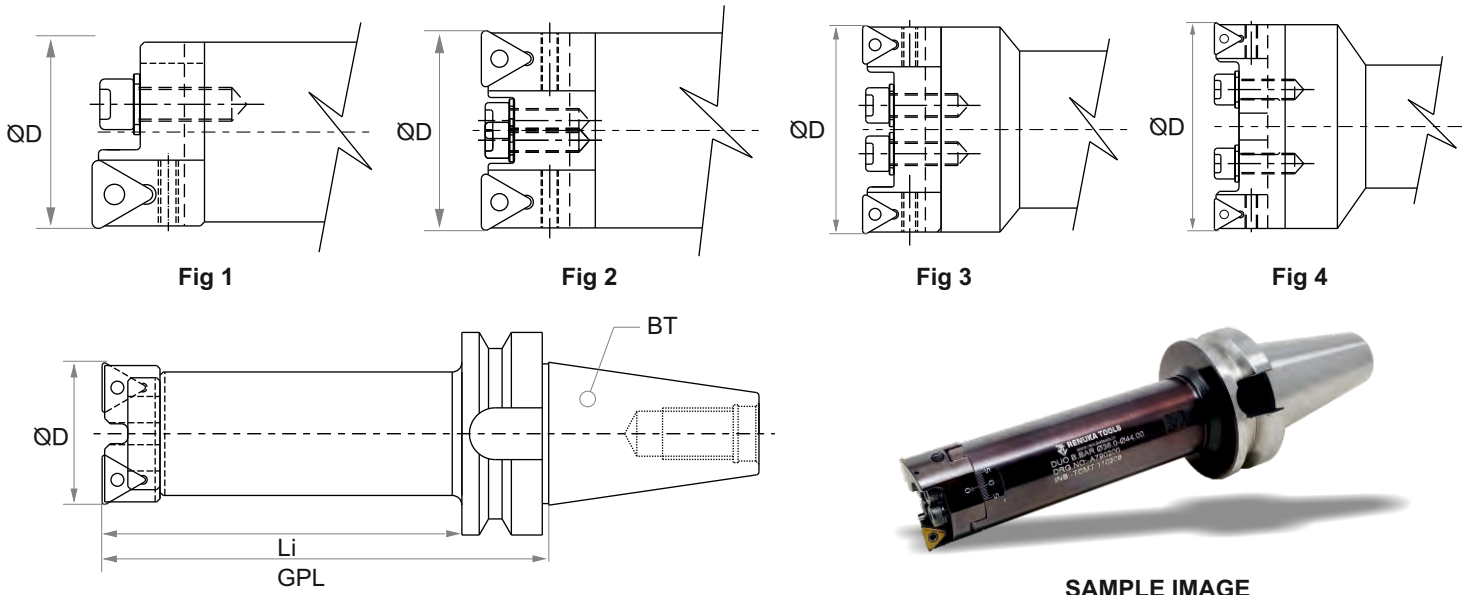
Nomenclature Code Key for Ordering Extension



Ordering Example:

1 piece
EXT DUO 70 25

Integral Type Duo Boring Bar for TC.. Inserts



SAMPLE IMAGE

All dimensions are in mm.

Fig. No	Sr. No	Item Code	Holding Taper	Cartridge Item Code	Insert	D Ømin - Ømax	Li	GPL
Fig 1	1	RT DUO IT 20-24 BT40 / BT50	BT 40 / BT 50	CART DUO T 20-24	TC..0902	20-24	80	107 / 118
Fig 2	2	RT DUO IT 24-30 BT40 / BT50	BT 40 / BT 50	CART DUO T 24-30	TC..0902	24-30	80	107 / 118
	3	RT DUO IT 29-36 BT40 / BT50	BT 40 / BT 50	CART DUO T 29-36	TC..1102	29-36	87	114 / 125
	4	RT DUO IT 36-44 BT40 / BT50	BT 40 / BT 50	CART DUO T 36-44	TC..1102	36-44	108	135 / 146
	5	RT DUO IT 43-54 BT40 / BT50	BT 40 / BT 50	CART DUO T 43-54	TC..1102	43-54	115	142 / 153
Fig 3	6	RT DUO IT 53-66 BT40 / BT50	BT 40 / BT 50	CART DUO T 53-66	TC..1102	53-66	120	147 / 158
Fig 4	7	RT DUO IT 65-83 BT40 / BT50	BT 40 / BT 50	CART DUO T 65-83	TC..16T3	65-83	155	182 / 193
	8	RT DUO IT 82-103 BT40 / BT50	BT 40 / BT 50	CART DUO T 82-103	TC..16T3	82-103	206	233 / 244
	9	RT DUO IT 100-130 BT40 / BT50	BT 40 / BT 50	CART DUO T 100-130	TC..16T3	100-130	210	237 / 248
	10	RT DUO IT 125-155 BT40 / BT50	BT 40 / BT 50	CART DUO T 125-155	TC..16T3	125-155	273	300 / 311
	11	RT DUO IT 150-205 BT40 / BT50	BT 40 / BT 50	CART DUO T 150-205	TC..16T3	150-205	273	300 / 311

Note: Please refer to the notes mentioned at the end of the page.

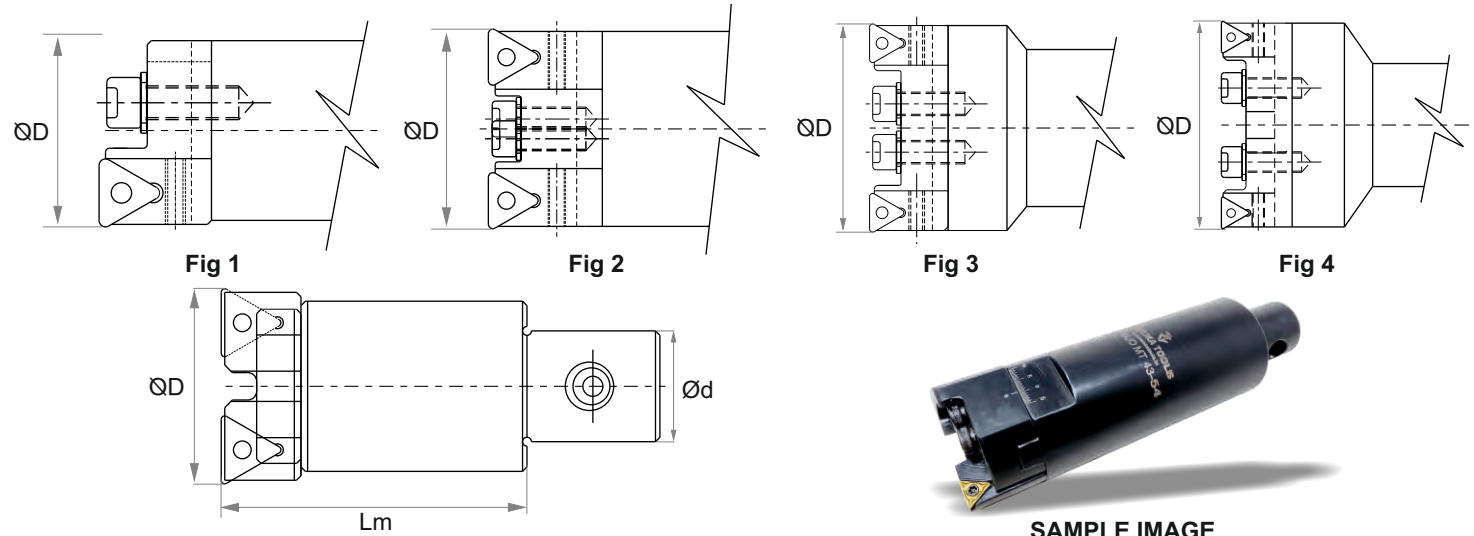
Integral Type Duo Boring Bar for CC.. Inserts

All dimensions are in mm.

Fig. No	Sr. No	Item Code	Holding Taper	Cartridge Item Code	Insert	D Ømin - Ømax	Li	GPL
Fig 1	1	RT DUO IC 20-24 BT40 / BT50	BT 40 / BT 50	CART DUO C 20-24	CC..0602	20-24	80	107 / 118
Fig 2	2	RT DUO IC 24-30 BT40 / BT50	BT 40 / BT 50	CART DUO C 24-30	CC..0602	24-30	80	107 / 118
	3	RT DUO IC 29-36 BT40 / BT50	BT 40 / BT 50	CART DUO C 29-36	CC..0602	29-36	87	114 / 125
	4	RT DUO IC 36-44 BT40 / BT50	BT 40 / BT 50	CART DUO C 36-44	CC..0602	36-44	108	135 / 146
	5	RT DUO IC 43-54 BT40 / BT50	BT 40 / BT 50	CART DUO C 43-54	CC..09T3	43-54	115	142 / 153
Fig 3	6	RT DUO IC 53-66 BT40 / BT50	BT 40 / BT 50	CART DUO C 53-66	CC..09T3	53-66	120	147 / 158
Fig 4	7	RT DUO IC 65-83 BT40 / BT50	BT 40 / BT 50	CART DUO C 65-83	CC..09T3	65-83	155	182 / 193
	8	RT DUO IC 82-103 BT40 / BT50	BT 40 / BT 50	CART DUO C 82-103	CC..09T3	82-103	206	233 / 244
	9	RT DUO IC 100-130 BT40 / BT50	BT 40 / BT 50	CART DUO C 100-130	CC..09T3	100-130	210	237 / 248
	10	RT DUO IC 125-155 BT40 / BT50	BT 40 / BT 50	CART DUO C 125-155	CC..1204	125-155	273	300 / 311
	11	RT DUO IC 150-205 BT40 / BT50	BT 40 / BT 50	CART DUO C 150-205	CC..1204	150-205	273	300 / 311

- Notes:
- For range 20-24, boring bar has one single cartridge only. For others, there are two cartridges.
 - Please refer to page no. 10 for insert spare details.
 - All required spares are supplied with the tools. If required additionally, can be ordered separately as well. Inserts not included.
 - Lead time of 1-2 weeks for all options.
 - Customized boring bars for special diameters can also be provided but will be made to order with lead time of 3-6 weeks.
 - Customized boring bars for other spindle tapers can also be provided but will be made to order with lead time of 3-6 weeks.
 - Diameter range "D" calculated considering 0.8mm insert nose radius.
 - For additional cutting length requirement, customized boring bars with anti-vibration treatment can be tailor made with lead time of 3-6 weeks.

Modular Type Duo Boring Bar for TC..Inserts



SAMPLE IMAGE

All dimensions are in mm.

Fig. No	Sr. No	Item Code	Cartridge Item Code	Extension Item Code	Ød	Insert	D Ømin - Ømax	Lm	Max Working Length
Fig 1	1	RT DUO MT 20-24	CART DUO T 20-24	NA	25	TC..0902	20-24	80	80
	2	RT DUO MT 24-30	CART DUO T 24-30	NA	25	TC..0902	24-30	80	80
Fig 2	3	RT DUO MT 29-36	CART DUO T 29-36	NA	25	TC..1102	29-36	87	87
	4	RT DUO MT 36-44	CART DUO T 36-44	NA	25	TC..1102	36-44	108	108
	5	RT DUO MT 43-54	CART DUO T 43-54	EXT DUO 7025/10025	25	TC..1102	43-54	115	245
Fig 3	6	RT DUO MT 53-66	CART DUO T 53-66	EXT DUO 7025/10025	25	TC..1102	53-66	120	250
	7	RT DUO MT 65-83	CART DUO T 65-83	EXT DUO 7040/10040	40	TC..16T3	65-83	155	305
Fig 4	8	RT DUO MT 82-103	CART DUO T 82-103	EXT DUO 7040/10040	40	TC..16T3	82-103	206	356
	9	RT DUO MT 100-130	CART DUO T 100-130	EXT DUO 7040/10040	40	TC..16T3	100-130	210	360
	10	RT DUO MT 125-155	CART DUO T 125-155	EXT DUO 7040/10040	40	TC..16T3	125-155	273	423
	11	RT DUO MT 150-205	CART DUO T 150-205	EXT DUO 7040/10040	40	TC..16T3	150-205	273	423

Note: Please refer to the notes mentioned at the end of the page.

Modular Type Duo Boring Bar for CC..Inserts

All dimensions are in mm.

Fig. No	Sr. No	Item Code	Cartridge Item Code	Extension Item Code	Ød	Insert	D Ømin - Ømax	Lm	Max Working Length
Fig 1	1	RT DUO MC 20-24	CART DUO C 20-24	NA	25	CC..0602	20-24	80	80
	2	RT DUO MC 24-30	CART DUO C 24-30	NA	25	CC..0602	24-30	80	80
Fig 2	3	RT DUO MC 29-36	CART DUO C 29-36	NA	25	CC..0602	29-36	87	87
	4	RT DUO MC 36-44	CART DUO C 36-44	NA	25	CC..0602	36-44	108	108
	5	RT DUO MC 43-54	CART DUO C 43-54	EXT DUO 7025/10025	25	CC..09T3	43-54	115	245
Fig 3	6	RT DUO MC 53-66	CART DUO C 53-66	EXT DUO 7025/10025	25	CC..09T3	53-66	120	250
	7	RT DUO MC 65-83	CART DUO C 65-83	EXT DUO 7040/10040	40	CC..09T3	65-83	155	305
Fig 4	8	RT DUO MC 82-103	CART DUO C 82-103	EXT DUO 7040/10040	40	CC..09T3	82-103	206	356
	9	RT DUO MC 100-130	CART DUO C 100-130	EXT DUO 7040/10040	40	CC..09T3	100-130	210	360
	10	RT DUO MC 125-155	CART DUO C 125-155	EXT DUO 7040/10040	40	CC..1204	125-155	273	423
	11	RT DUO MC 150-205	CART DUO C 150-205	EXT DUO 7040/10040	40	CC..1204	150-205	273	423

Notes:

- For range 20-24, boring bar has one single cartridge only. For others, there are two cartridges.
- Extension not applicable for range 20mm to 44mm. For others, applicable extensions to be ordered separately.
- Please refer to page no. 10 for insert spare details.
- All required spares are supplied with the tools. If required additionally, can be ordered separately as well. Inserts not included.
- 'Maximum Working Length' includes maximum extension possible along with adaptor working length. i.e. after complete assembly.
- To order the right extension, please ensure that the shank diameter of Boring Head 'Ød' should match the diameter of Extension ID 'Øde'.
- To order the right adaptor, please ensure that the shank diameter of Boring Head 'Ød' should match the diameter of Adaptor ID 'Øda'.
- Lead time of 2-3 weeks for all options.
- Customized boring bars for special diameters can also be provided but will be made to order with lead time of 3-6 weeks.
- Diameter range "D" calculated considering 0.8mm insert nose radius.

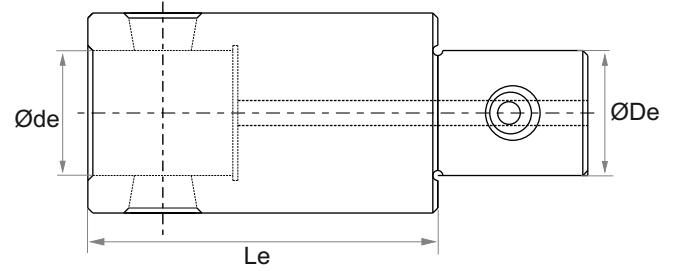
Extension Details for Modular Type Duo Boring Bar

All dimensions are in mm.

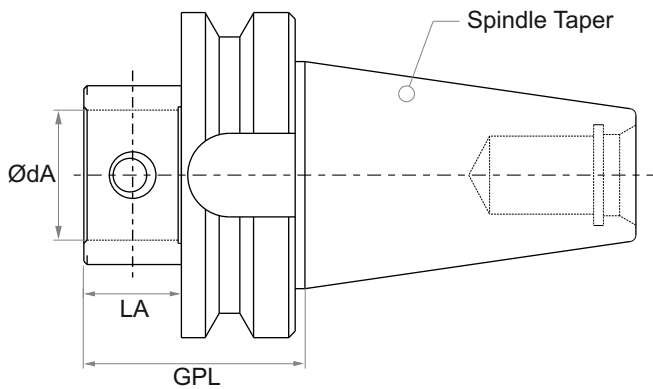
Sr no.	Item No.	Working Length of Extension (Le)	Øde	ØDe
1	EXT DUO 7025	70	25	25
2	EXT DUO 10025	100	25	25
3	EXT DUO 7040	70	40	40
4	EXT DUO 10040	100	40	40

Notes:

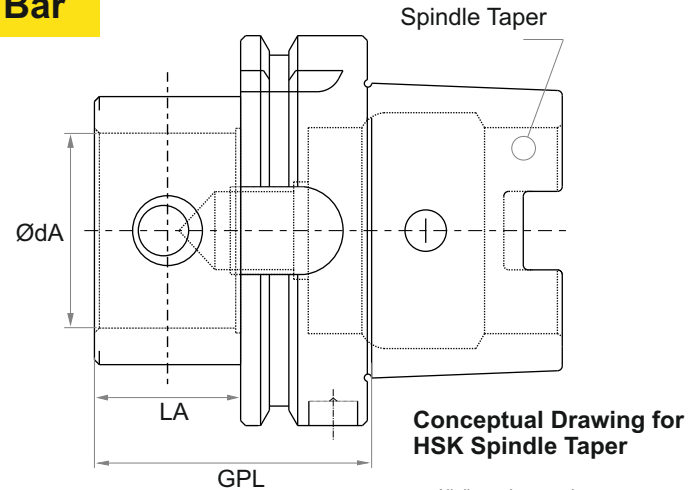
- To order the right extension, please ensure that the shank diameter of Boring Head 'Ød' should match the diameter of Extension ID 'Øde'.
- To order the right adaptor, please ensure that the shank diameter of Extension 'Øde' should match the diameter of Adaptor ID 'ØdA'.



Adaptor Details for Modular Type Duo Boring Bar



Conceptual Drawing for BT / BBT / SK / ISO Spindle Taper



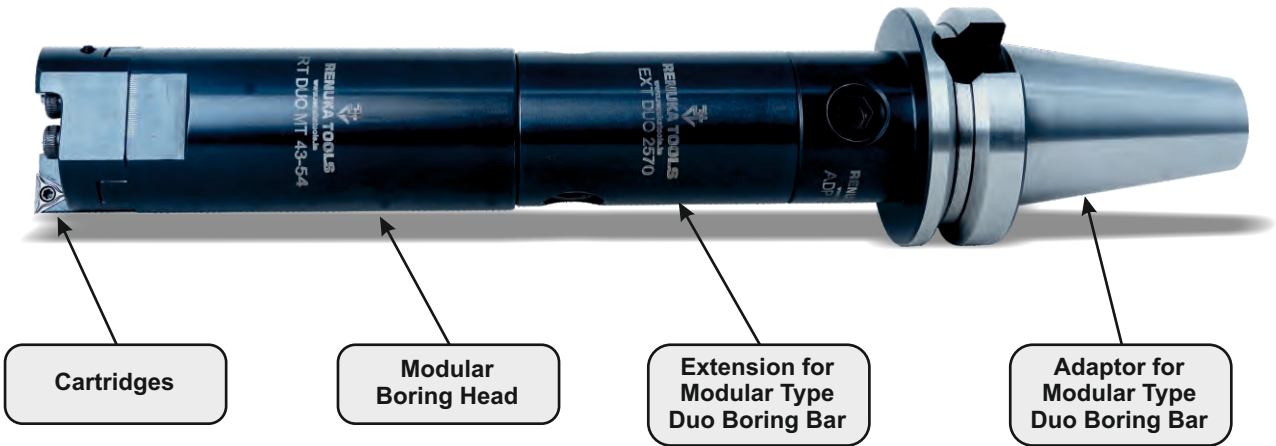
All dimensions are in mm.

Sr. No	Item Code	Spindle Taper	Adaptor ID ØdA	LA	GPL of Adaptor	Adaptor Bolt Item Code	Stock
1	ADP BT40 25	BT 40	25	30	57.0	RTABM825	★
2	ADP BT40 40	BT 40	40	50	77.0	RTABM840	★
3	ADP BT50 25	BT 50	25	30	68.0	RTABM825	★
4	ADP BT50 40	BT 50	40	50	88.0	RTABM840	★
5	ADP BBT40 25	BBT 40	25	30	55.0	RTABM825	◆
6	ADP BBT40 40	BBT 40	40	50	75.0	RTABM840	◆
7	ADP BBT50 25	BBT 50	25	30	65.0	RTABM825	◆
8	ADP BBT50 40	BBT 50	40	50	85.0	RTABM840	◆
9	ADP SK40 25	SK 40	25	30	49.1	RTABM825	◆
10	ADP SK40 40	SK 40	40	50	69.1	RTABM840	◆
11	ADP SK50 25	SK 50	25	30	49.1	RTABM825	◆
12	ADP SK50 40	SK 50	40	50	69.1	RTABM840	◆
13	ADP ISO40 25	ISO 40	25	30	40.0	RTABM825	◆
14	ADP ISO40 40	ISO 40	40	50	60.0	RTABM840	◆
15	ADP ISO50 25	ISO 50	25	30	42.0	RTABM825	◆
16	ADP ISO50 40	ISO 50	40	50	62.0	RTABM840	◆
17	ADP ISO60 25	ISO 60	25	30	46.0	RTABM825	◆
18	ADP ISO60 40	ISO 60	40	50	66.0	RTABM840	◆
19	ADP HSKA50 25	HSKA 50	25	30	56.0	RTABM825	◆
20	ADP HSKA50 40	HSKA 50	40	50	76.0	RTABM840	◆
21	ADP HSKA63 25	HSKA 63	25	30	56.0	RTABM825	◆
22	ADP HSKA63 40	HSKA 63	40	50	76.0	RTABM840	◆
23	ADP HSKA80 25	HSKA 80	25	30	56.0	RTABM825	◆
24	ADP HSKA80 40	HSKA 80	40	50	76.0	RTABM840	◆
25	ADP HSKA100 25	HSKA 100	25	30	59.0	RTABM825	◆
26	ADP HSKA100 40	HSKA 100	40	50	79.0	RTABM840	◆

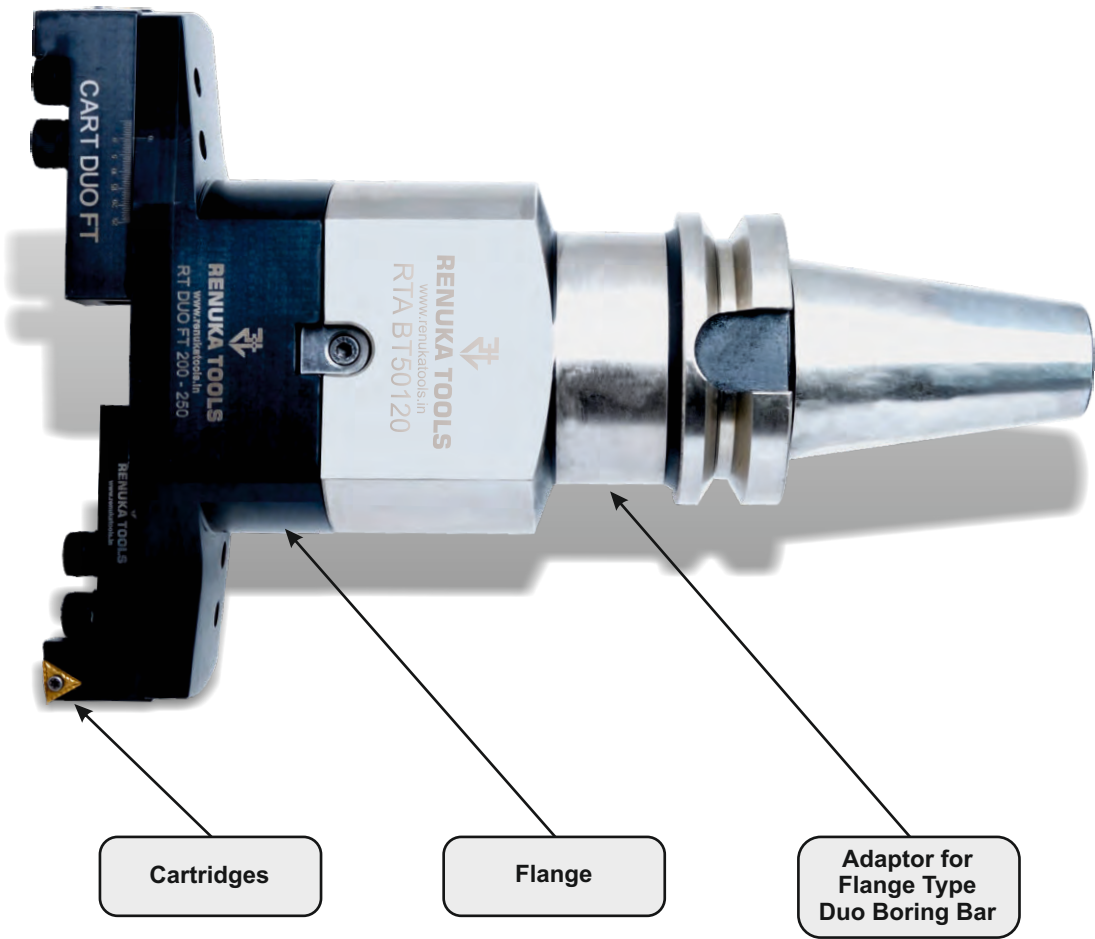
Notes:

- To order the right adaptor, kindly ensure that the shank diameter of Boring Head 'Ød' or of Extension ID 'Øde' should match the diameter of Adaptor ID 'ØdA'.
- Special Adaptor bolt will be provided along with the Adaptors. Can be ordered separately if required additionally.
- Customized adaptors of any spindle taper can also be provided but will be made to order with lead time of 3-6 weeks.
- In the above table, ★ denotes ready in stock and ◆ denotes lead time of 2-3 weeks.

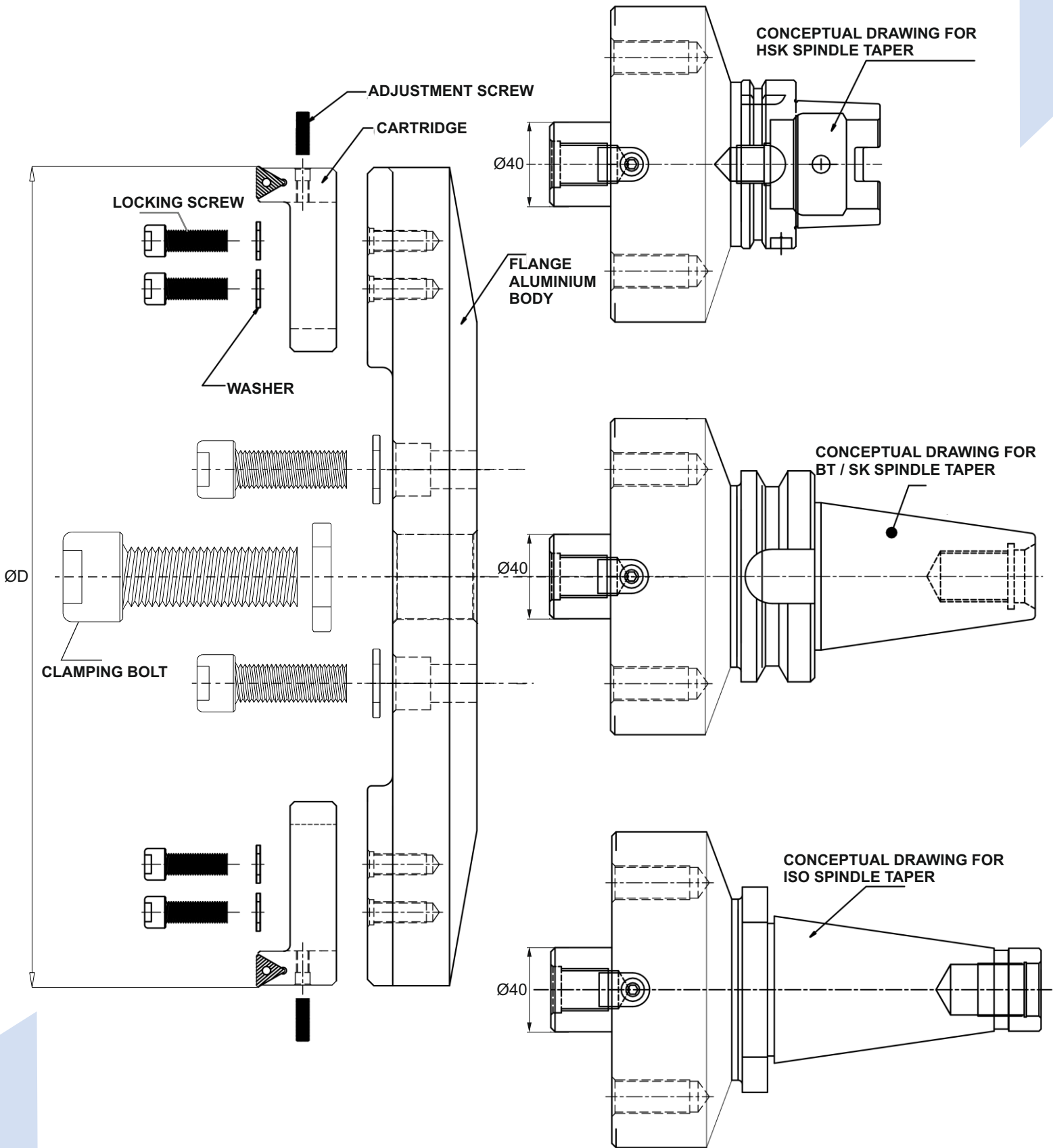
Illustrative Image of Complete Assembly



Illustrative Image of Complete Assembly



Assembly Details - Schematic Drawing



ADAPTOR OPTIONS FOR FLANGE TYPE DUO BORING BARS

Flange Type Duo Boring Bar for TC.. Inserts

All dimensions are in mm.

Sr. No	Item Code	Flange Item Code	Adaptor Item Code	D Ømin - Ømax	D1	D2	GPL	Total Tool Weight
1	RT DUO FT 200-250 BT 40	F 200-250	ADPF BT40120	200-250	40	120	167	4.1Kg
2	RT DUO FT 200-250 BT 50	F 200-250	ADPF BT50120	200-250	40	120	178	5.2Kg
3	RT DUO FT 250-300 BT 40	F 250-300	ADPF BT40120	250-300	40	120	167	4.8Kg
4	RT DUO FT 250-300 BT 50	F 250-300	ADPF BT50120	250-300	40	120	178	5.4Kg
5	RT DUO FT 300-350 BT 40	F 300-350	ADPF BT40150	300-350	40	150	167	5.6Kg
6	RT DUO FT 300-350 BT 50	F 300-350	ADPF BT50150	300-350	40	150	178	6.3Kg
7	RT DUO FT 350-400 BT 40	F 350-400	ADPF BT40150	350-400	40	150	167	6.1Kg
8	RT DUO FT 350-400 BT 50	F 350-400	ADPF BT50150	350-400	40	150	178	7.4Kg
9	RT DUO FT 400-450 BT 40	F 400-450	ADPF BT40150	400-450	40	150	167	7.1Kg
10	RT DUO FT 400-450 BT 50	F 400-450	ADPF BT50150	400-450	40	150	178	8.9Kg
11	RT DUO FT 450-500 BT 40	F 450-500	ADPF BT40150	450-500	40	150	167	7.9Kg
12	RT DUO FT 450-500 BT 50	F 450-500	ADPF BT50150	450-500	40	150	178	9.4Kg

Notes:

- Suitable Inserts for all the above models are TC..16T3.
- Cartridge part number for all above models is CART DUO FT (2nos. in each tool).
- Please also refer to the notes mentioned at the end of the below table.

Flange Type Duo Boring Bar for CC.. Inserts

All dimensions are in mm.

Sr. No	Item Code	Flange Item Code	Adaptor Item Code	D Ømin - Ømax	D1	D2	GPL	Total Tool Weight
1	RT DUO FC 200-250 BT 40	F 200-250	ADPF BT40120	200-250	40	120	167	4.1Kg
2	RT DUO FC 200-250 BT 50	F 200-250	ADPF BT50120	200-250	40	120	178	5.2Kg
3	RT DUO FC 250-300 BT 40	F 250-300	ADPF BT40120	250-300	40	120	167	4.8Kg
4	RT DUO FC 250-300 BT 50	F 250-300	ADPF BT50120	250-300	40	120	178	5.4Kg
5	RT DUO FC 300-350 BT 40	F 300-350	ADPF BT40150	300-350	40	150	167	5.6Kg
6	RT DUO FC 300-350 BT 50	F 300-350	ADPF BT50150	300-350	40	150	178	6.3Kg
7	RT DUO FC 350-400 BT 40	F 350-400	ADPF BT40150	350-400	40	150	167	6.1Kg
8	RT DUO FC 350-400 BT 50	F 350-400	ADPF BT50150	350-400	40	150	178	7.4Kg
9	RT DUO FC 400-450 BT 40	F 400-450	ADPF BT40150	400-450	40	150	167	7.1Kg
10	RT DUO FC 400-450 BT 50	F 400-450	ADPF BT50150	400-450	40	150	178	8.9Kg
11	RT DUO FC 450-500 BT 40	F 450-500	ADPF BT40150	450-500	40	150	167	7.9Kg
12	RT DUO FC 450-500 BT 50	F 450-500	ADPF BT50150	450-500	40	150	178	9.4Kg

Notes:

- Suitable Inserts for all the above models are CC..1204.
- Cartridge part number for all the above mentioned models is CART DUO FC (2nos. in each tool).
- Working length for all the above tools is 140mm.
- Material used for Flange is Aluminium for weight reduction.
- Please refer to page no. 10 for insert spare details.
- All required spares are supplied with the tools. If required, can be ordered separately as well. Inserts not included.
- Lead time of 2-3 weeks for all options.
- Diameter range "D" calculated considering 0.8mm insert nose radius.
- For additional cutting length requirement, customized boring bars with anti-vibration treatment can be tailor made with lead time of 3-6 weeks.

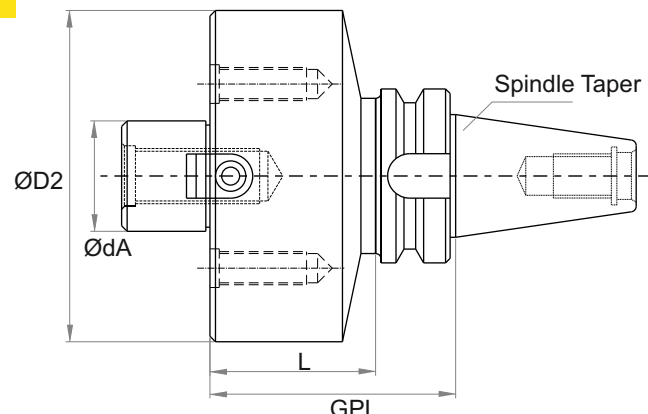
Cartridge Details for Flange Type Duo Boring Bar

Sr. no.	Cartridge Item Code	Insert	Screw	Torx
1	CART DUO FT	TC..16T3	(M3.5)	T-15
2	CART DUO FC	CC..1204	(M4.5)	T-20

Adaptor Details for Flange Type Duo Boring Bar

Sr. no.	Adaptor Item Code	Spindle Taper	Adaptor OD dA	D2	L	GPL of Adaptor
1	ADPF BT40120	BT 40	40	120	60	89
2	ADPF BT40150	BT 40	40	150	60	89
3	ADPF BT50120	BT 50	40	120	60	100
5	ADPF BT50150	BT 50	40	150	60	100

Note: Customized adaptors of any spindle taper can also be provided but will be made to order with lead time of 3-6 weeks



Side lock Type Duo Boring Bar for TC..Inserts

All dimensions are in mm.

Fig. No	Sr. no	Item Code	Cartridge Item Code	Insert	D Ømin - Ømax	d	L Working Length
Fig 1	1	RT DUO SLT 20-24	CART DUO T 20-24	TC..0902	20-24	20	80
	2	RT DUO SLT 24-30	CART DUO T 24-30	TC..0902	24-30	25	80
Fig 2	3	RT DUO SLT 29-36	CART DUO T 29-36	TC..1102	29-36	25	80
	4	RT DUO SLT 36-44	CART DUO T 36-44	TC..1102	36-44	32	80
	5	RT DUO SLT 43-54	CART DUO T 43-54	TC..1102	43-54	32	80

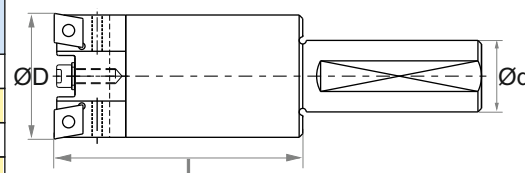


SAMPLE IMAGE

Side lock Type Duo Boring Bar for CC..Inserts

All dimensions are in mm.

Fig. No	Sr. no	Item Code	Cartridge Item Code	Insert	D Ømin - Ømax	d	L Working Length
Fig 1	1	RT DUO SLC 20-24	CART DUO C 20-24	CC..0602	20-24	20	80
	2	RT DUO SLC 24-30	CART DUO C 24-30	CC..0602	24-30	25	80
Fig 2	3	RT DUO SLC 29-36	CART DUO C 29-36	CC..0602	29-36	25	80
	4	RT DUO SLC 36-44	CART DUO C 36-44	CC..0602	36-44	32	80
	5	RT DUO SLC 43-54	CART DUO C 43-54	CC..09T3	43-54	32	80

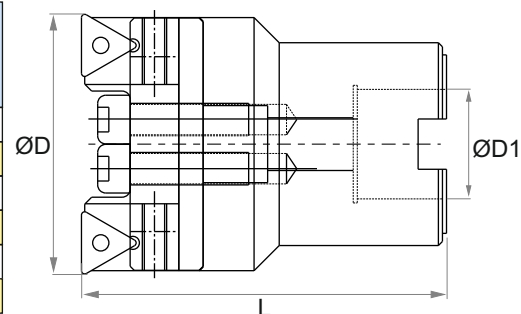


Arbor Type Duo Boring Bar

Arbor Type Duo Boring Bar for TC.. Inserts

All dimensions are in mm.

Fig. No	Sr. no	Item Code	Cartridge Item Code	Insert	D Ømin - Ømax	D1	L Working Length
Fig 3	1	RT DUO ART 53-66	CART DUO T 53-66	TC..1102	53-66	20	90
	2	RT DUO ART 65-83	CART DUO T 65-83	TC..16T3	65-83	22	90
Fig 4	3	RT DUO ART 82-103	CART DUO T 82-103	TC..16T3	82-103	22	100
	4	RT DUO ART 100-130	CART DUO T 100-130	TC..16T3	100-130	27	125
	5	RT DUO ART 125-155	CART DUO T 125-155	TC..16T3	125-155	32	125
	6	RT DUO ART 150-205	CART DUO T 150-205	TC..16T3	150-205	32	125



Arbor Type Duo Boring Bar for CC.. Inserts

All dimensions are in mm.

Fig. No	Sr. no	Item Code	Cartridge Item Code	Insert	D Ømin - Ømax	D1	L Working Length
Fig 3	1	RT DUO ARC 53-66	CART DUO C 53-66	CC..09T3	53-66	20	90
	2	RT DUO ARC 65-83	CART DUO C 65-83	CC..09T3	65-83	22	90
Fig 4	3	RT DUO ARC 82-103	CART DUO C 82-103	CC..09T3	82-103	22	100
	4	RT DUO ARC 100-130	CART DUO C 100-130	CC..09T3	100-130	27	125
	5	RT DUO ARC 125-155	CART DUO C 125-155	CC..1204	125-155	32	125
	6	RT DUO ARC 150-205	CART DUO C 150-205	CC..1204	150-205	32	125



SAMPLE IMAGE

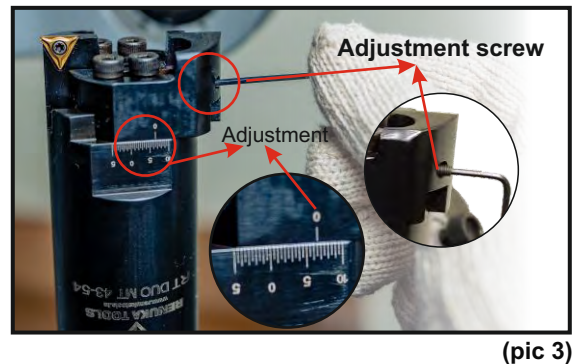
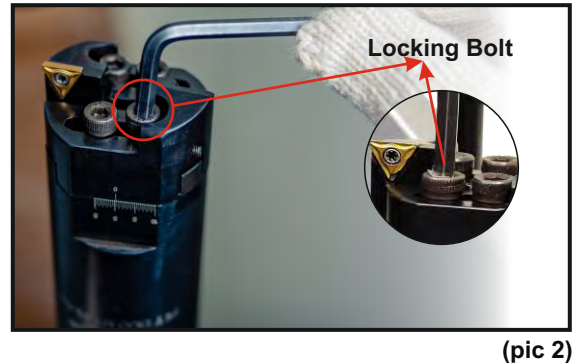
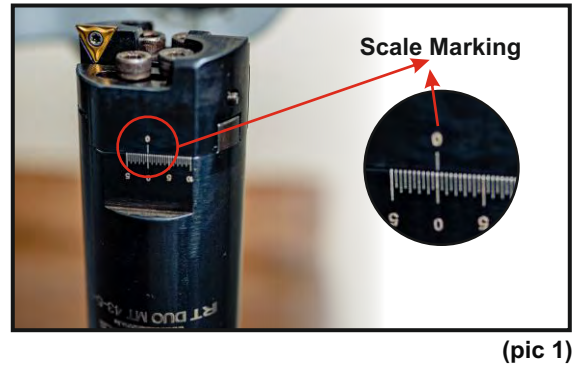
Notes:

- For all the above boring bars, any standard Side-Lock adaptor or Face-Mill adaptor can be used with diameters equal to "ØD" & "ØD1" respectively mentioned above.
- For Range 20-24, boring bar has one single cartridge only. For rest all, there are two cartridges.
- All required spares are supplied with the tools. If required additionally, can be ordered separately as well. Inserts not included.
- Lead time of 1-2 weeks for all options.
- Diameter range "D" calculated considering 0.8mm insert nose radius.

Spare Details

Sr. no.	INSERT	Insert Screw	Torx
1	TC..0902	M2.2	T-6
2	TC..1102	M2.5	T-7
3	TC..16T3	M3.5	T-15
4	CC..0602	M2.5	T-7
5	CC..09T3	M3.5	T-15
6	CC..1204	M4.5	T-20

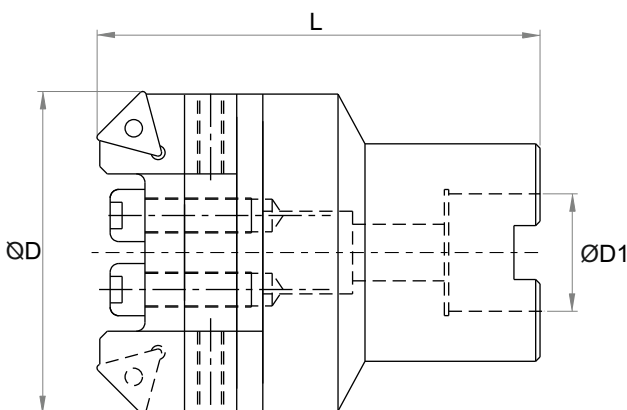
- ▶ Firstly do the complete assembly of the Modular type / Flange type / Side Lock type / Face Mill Arbor type Duo Boring Bar. Post assembly (if required), measure the exact diameter on the pre-setter or by using a precise dial indicator.
- ▶ The boring head is initially set on minimum mark on the scale. (pic 1)
- ▶ In case you wish to adjust the diameter, loosen the Locking Screw of cartridges with the allen key provided and adjust the diameter using grub screws on the side of the tool. (pic 2)
- ▶ Use the scale marking to set the required diameter, adjust accordingly and then recheck if the required size is achieved.(pic 3)
- ▶ If the required diameter is achieved, tighten the locking screws of cartridges with a torque wrench (Recommended) for precise repeatability and to ensure sufficient torque for locking.(pic 2)
- ▶ The tool is now ready to use.
- ▶ It is recommended to dismantle the assembly and set to minimum after use, if to be stored for long period without use. Ensure periodic lubrication to avoid damage due to rusting.
- ▶ Ensure that the locking screw is loosened before using adjustment to avoid internal damage to adjustment mechanism.



Other Applications of Duo Boring Bar

Duo Boring Bar for Chamfering Application

- ▶ Duo Boring Bars can also be used as adjustable chamfering tools by ordering special chamfering cartridges from Renuka Tools®.
- ▶ Lead time of 2-3 weeks.
- ▶ Minimum Diameter $\varnothing D = \varnothing 8.0\text{mm}$



SAMPLE IMAGE



OUR OTHER STANDARD PRODUCTS

FINE BORING BARS & MICRO BORE UNITS



ECCENTRIC FINE BORING TOOLS



BCA BORING BARS & FINISH BORING CARTRIDGES



BORING KIT



OUR OTHER CUSTOMIZED PRODUCTS

**COMBINATION BORING BARS
ANTI-VIBRATION BORING BARS
SPECIAL CARTRIDGES**



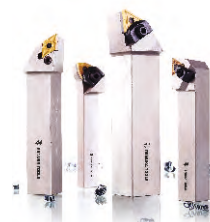
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