



BORING KIT



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Redefining Cutting Technology

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 also offer standard products such as:

- ▶ Boring Kit
- ▶ BCA Finish Boring Bars
- ▶ Micro Bore Unit
- ▶ Adjustable Duo Boring Tools
- ▶ Fine Boring Tools
- ▶ Eccentric Boring Tools
- ▶ Duo Boring Bars
- ▶ Anti-vibration Boring Tools
- ▶ Large Diameter Milling Cutters
- ▶ Spot Face Cutters
- ▶ Side & Face Milling Cutters
- ▶ Chamfer Tools

This catalogue will give you further insights and details about our Boring Kit. For more details of our other standard offerings, please refer to our website (www.renukatoools.in).



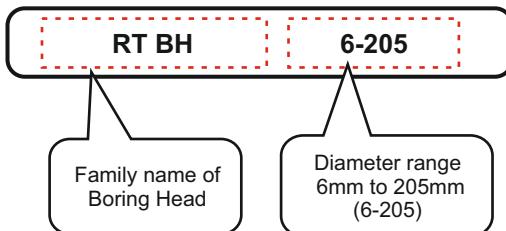
Facts & Advantages

- Used for finish boring application from diameter 6mm to 205mm with a least count of 10 microns radially.
- Available with options of selecting one or many boring bars & different adaptors depending on requirement.
- User friendly & quick assembly & quick adjustment ensures minimum loss time.
- Comes with fine adjustment setting ensuring zero backlash.
- Most economic solution for the complete range of diameters for finish boring application.
- Ideal finish boring tool for tool - room set-ups.
- Apart from standard product range, tailor made boring heads & adaptors are also available on demand.



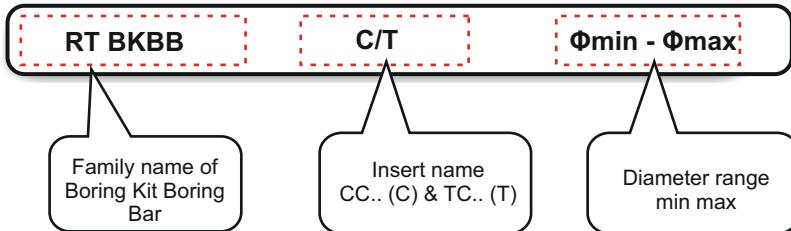
SAMPLE IMAGE

Nomenclature Code Key for Ordering Boring Head for Boring Kit



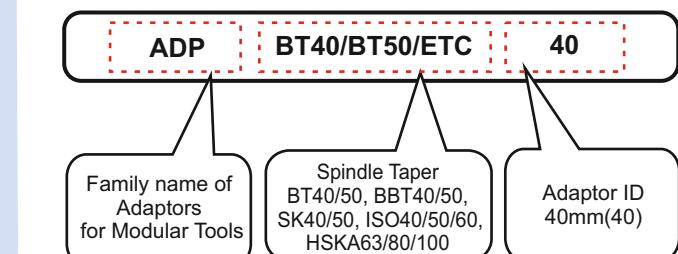
Ordering Example:
1 piece
RT BH 6 - 205

Nomenclature Code Key for Ordering Boring Bars for Boring Kit



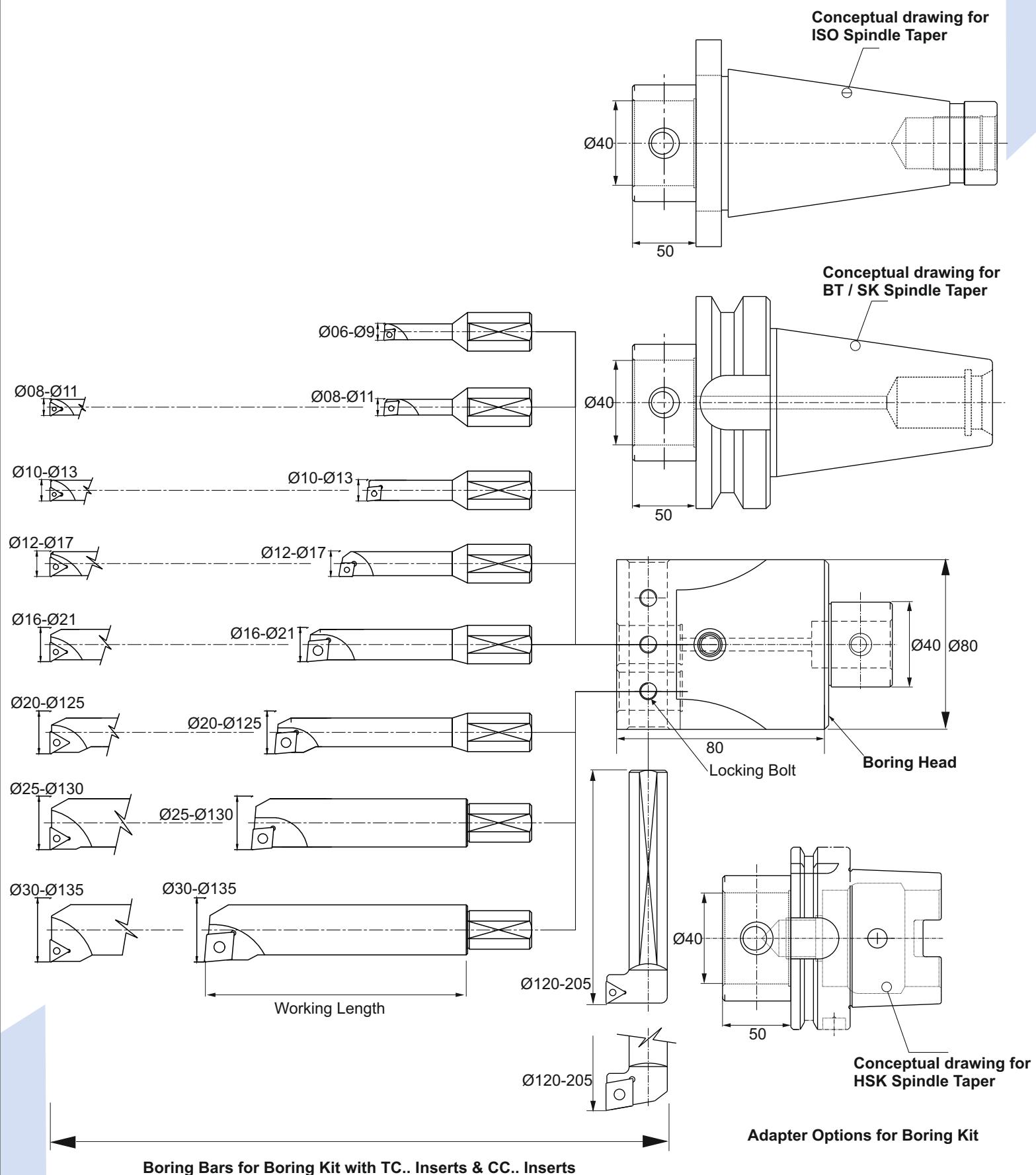
Ordering Example:
1 piece
RT BKBBT 0811

Nomenclature Code Key for Ordering Adaptor



Ordering Example:
1 piece
ADP BT 40 40

Assembly Details - Schematic Drawing



Boring Bars for Boring Kit with TC.. Inserts & CC.. Inserts

Adapter Options for Boring Kit

Boring Head for Boring Kit

| Sr. No | Item Code | Diameter Range | Least Count | Boring Bar Clamping Screw (Qty) | Boring Head Locking Bolt | Allen Keys |
|--------|-------------|----------------|-------------|---------------------------------|--------------------------|------------|
| 1 | RT BH 6-205 | 6-205 | 10 microns | M8 (3) | M10 | 4mm / 8mm |

Notes:

- Spares for Boring Head will be provided along with the Boring Head.
- If required additionally, all spares can be ordered separately as well.
- Required Boring Bars to be ordered separately.



SAMPLE IMAGE

Boring Bars for Boring Kit with TC.. Inserts

| Sr. No | Item Code | Insert | Diameter Range Φmin - Φmax D | Working Length |
|--------|-----------------|-----------|------------------------------------|----------------|
| 1 | RT BKBBT 0811 | TC.. 06T1 | 8-11 | 32 |
| 2 | RT BKBBT 1013 | TC.. 06T1 | 10-13 | 40 |
| 3 | RT BKBBT 1217 | TC.. 0902 | 12-17 | 53 |
| 4 | RT BKBBT 1621 | TC.. 0902 | 16-21 | 68 |
| 5 | RT BKBBT 20125 | TC.. 1102 | 20-125 | 83 |
| 6 | RT BKBBT 25130 | TC.. 1102 | 25-130 | 96 |
| 7 | RT BKBBT 30135 | TC.. 1102 | 30-135 | 115 |
| 8 | RT BKBBT 120205 | TC.. 1102 | 120-205 | 85 |

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



SAMPLE IMAGE

Boring Bars for Boring Kit with CC.. Inserts

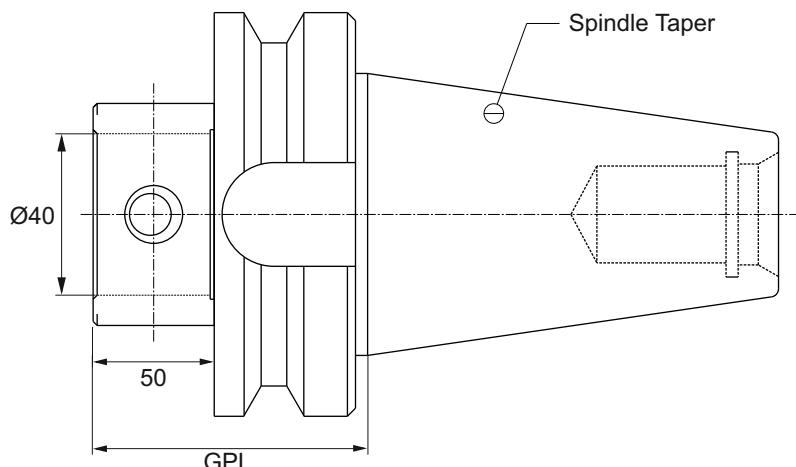
| Sr. No | Item Code | Insert | Diameter Range Φmin - Φmax D | Working Length |
|--------|-----------------|-----------|------------------------------------|----------------|
| 1 | RT BKBBC 0609 | CC.. 0400 | 6-9 | 26 |
| 2 | RT BKBBC 0811 | CC.. 0602 | 8-11 | 32 |
| 3 | RT BKBBC 1013 | CC.. 0602 | 10-13 | 40 |
| 4 | RT BKBBC 1217 | CC.. 0602 | 12-17 | 53 |
| 5 | RT BKBBC 1621 | CC.. 09T3 | 16-21 | 68 |
| 6 | RT BKBBC 20125 | CC.. 09T3 | 20-125 | 83 |
| 7 | RT BKBBC 25130 | CC.. 09T3 | 25-130 | 96 |
| 8 | RT BKBBC 30135 | CC.. 1204 | 30-135 | 115 |
| 9 | RT BKBBC 120205 | CC.. 1204 | 120-205 | 85 |

Notes:

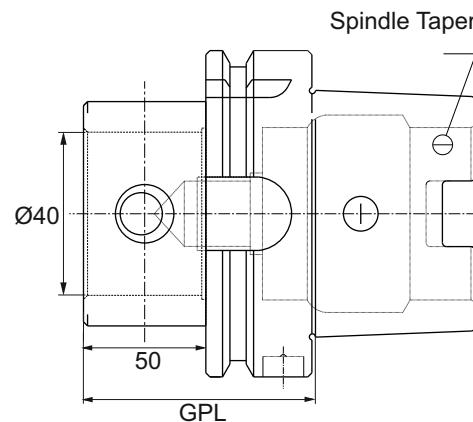
- Insert Screws and Torx keys will be provided along with the Boring Bars. Inserts not included.
- Please refer to page no. 6 for insert spare details.
- If required additionally, all spares can be ordered separately as well.
- Diameter range 'D' calculated considering 0.4mm insert nose radius.
- Maximum recommended material removal is 0.5mm diametrically.
- Customized boring bars can also be provided but will be made to order with lead time of 3-6 weeks.



SAMPLE IMAGE



Conceptual Drawing for BT / BBT / SK / ISO



Conceptual Drawing for HSK

All dimensions are in mm.

| Sr. No | Item Code | Spindle Taper | GPL of Adaptor | Stock |
|--------|----------------|---------------|----------------|-------|
| 1 | ADP BT40 40 | BT40 | 77.0 | ★ |
| 2 | ADP BT50 40 | BT50 | 88.0 | ★ |
| 3 | ADP BBT40 40 | BBT40 | 75.0 | ◆ |
| 4 | ADP BBT50 40 | BBT50 | 85.0 | ◆ |
| 5 | ADP SK40 40 | SK40 | 69.1 | ◆ |
| 6 | ADP SK50 40 | SK50 | 69.1 | ◆ |
| 7 | ADP ISO40 40 | ISO40 | 60.0 | ◆ |
| 8 | ADP ISO50 40 | ISO50 | 62.0 | ◆ |
| 9 | ADP ISO60 40 | ISO60 | 66.0 | ◆ |
| 10 | ADP HSKA50 40 | HSKA50 | 76.0 | ◆ |
| 11 | ADP HSKA63 40 | HSKA63 | 76.0 | ◆ |
| 12 | ADP HSKA80 40 | HSKA80 | 76.0 | ◆ |
| 13 | ADP HSKA100 40 | HSKA100 | 79.0 | ◆ |

Notes:

- Diameter of Adaptor ID for all of the above is 40mm.
- Working Length for all of the above is 50mm.
- Special Adaptor Bolt item code RTABM840 will be provided along with the Adaptors and if required additionally, can be ordered separately as well.
- Customized adaptors for any other 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.



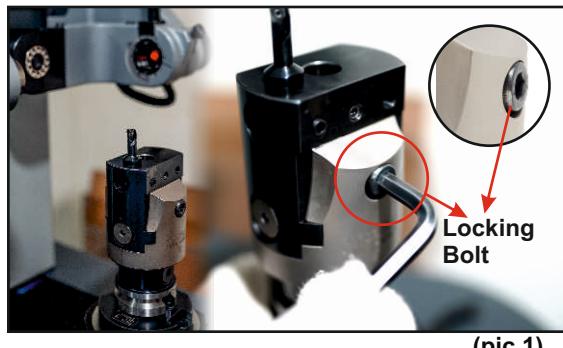
SAMPLE IMAGE

Spare Details

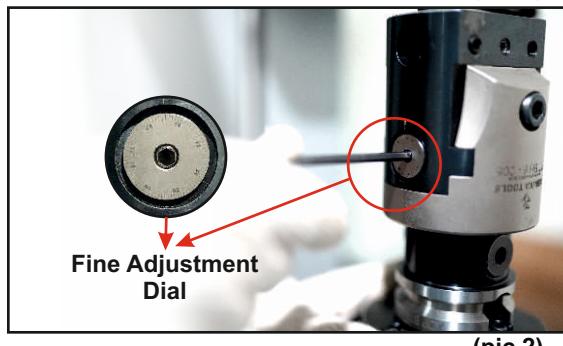
| Sr. no. | INSERT | Insert Screw | Torx |
|---------|------------|------------------|----------|
| 1 | CC.. 0400 | M2 | T-6 |
| 2 | CC.. 0602 | M2.5 | T-7 |
| 3 | CC.. 09T3 | M3.5 | T-15 |
| 4 | CC.. 1204 | M4.5 | T-20 |
| 5 | TC.. 06T1 | M2 | T-6 |
| 6 | TC.. 0902 | M2.2 | T-6 |
| 7 | TC.. 1102 | M2.5 | T-7 |

Operating Instructions for Boring Kit

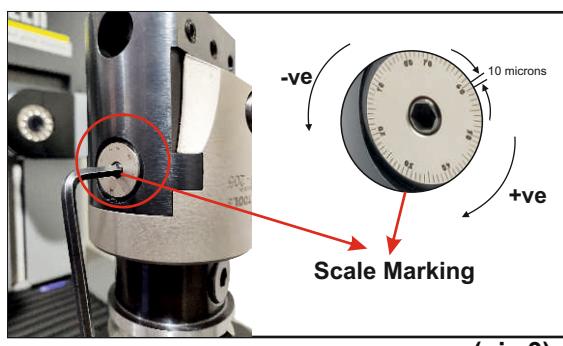
- ▶ The boring head is initially set on minimum mark on the scale.
- ▶ Follow instructions below to assemble the boring kit:
 - a) Clamp the required boring bar on to the boring head with the help of the clamping screws provided with the boring head.
 - b) Clamp the adaptor on to the boring head with the special adaptor bolts provided with the adaptor.
- ▶ Post assembly, measure the exact diameter on the pre-setter or by using a precise dial indicator.
- ▶ In case you wish to adjust the diameter, loosen the Locking Screw of M10 with the provided Allen key of 8mm. (pic 1)
- ▶ Use the fine adjustment dial to set the required diameter. (pic 2)
- ▶ The smallest division is 10 microns and one rotation is 0.75mm radially, adjust accordingly and then recheck if the required size is achieved. (pic 3)
- ▶ If the required diameter is achieved, tighten the locking screw with a torque wrench (recommended) for precise repeatability and to ensure sufficient torque for locking. (pic 1)
- ▶ The tool is now ready to use.
- ▶ It is recommended to dismantle the boring kit and set to minimum after use, if to be stored for long period without use. (pic 4)
- ▶ To avoid damage due to rusting, ensure periodic lubrication.



(pic 1)



(pic 2)



(pic 3)



(pic 4)

Precautionary measures while using Boring Kit

- ▶ Due to constraints in the assembly tolerances, it is recommended that tools, if damaged, are returned to Renuka Tools for assessment/repair in a controlled environment. Commercials for repair can only be determined after detailed assessment of the damaged tool.
- ▶ Please change the locking screws and insert screws ahead in time to avoid accidents.
- ▶ In case of any observed decrease in accuracy over the time of usage, please request Renuka Tools for servicing the tool.
- ▶ Ensure that the locking bolt is loosened before using fine adjustment to avoid internal damage to adjustment mechanism.



OUR OTHER STANDARD PRODUCTS

FINE BORING BARS &
MICRO BORE UNITS



ECCENTRIC FINE BORING TOOLS



BCA BORING BARS



DUO BORING BARS



OUR OTHER CUSTOMIZED PRODUCTS

COMBINATION BORING BARS
ANTI-VIBRATION BORING BARS
SPECIAL CARTRIDGES



U-DRILLS
TREPANNING TOOLS



MILLING CUTTERS



TURNING TOOLS



SPECIAL ADAPTORS



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