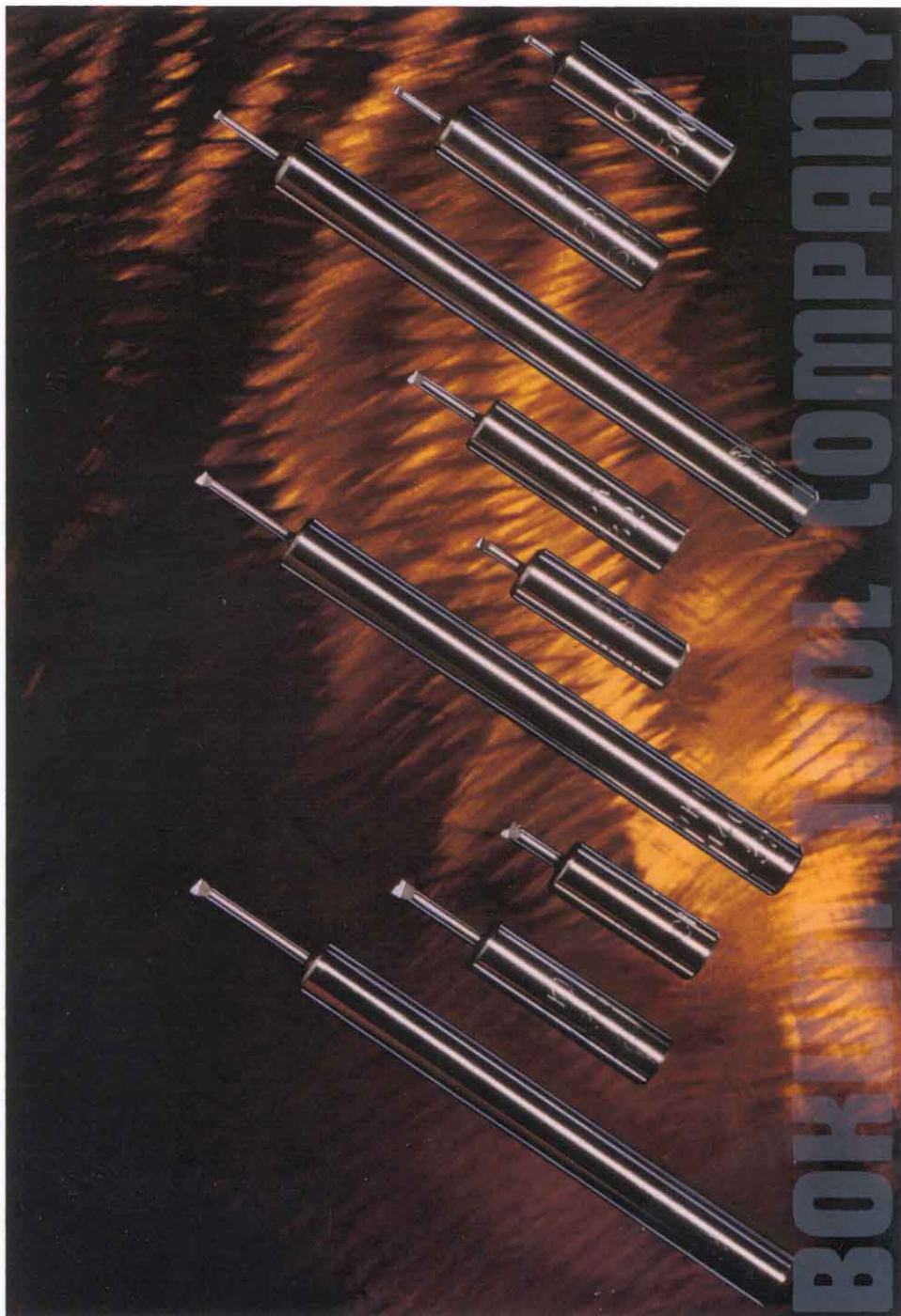


CARBIDE  
NECK  
FOR  
BORING OF  
DEEP SMALL  
HOLES

---

AVAILABLE  
FROM STOCK



Advantages—

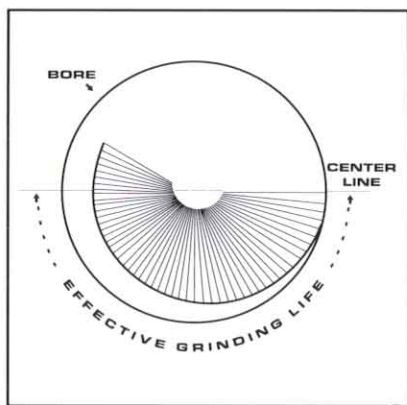
- Precision ground clearance throughout life of tool.
- Shape of cross section remains constant.
- Only necessary to regrind top rake.
- 180° of regrind life.
- Over 125 sizes and styles in stock.
- Produces a superior finish, which could eliminate the need for grinding.

## BOKUM CARBIDE NECK

### BORING TOOLS ADVANTAGES:

Constant Radial and Helical relief is the main principal behind all Bokum Tools. The radial angle on a

Bokum Boring tool is the relief (O.D. relief) on the cutting head. This angle is kept at a constant plus or minus 3 min. of one degree throughout 210°. The helical angle on the Bokum Boring tool is the relief on the front of the tool. The cross hatched section shows the greater back up strength of the Bokum Principle- which results in longer tool life and better finish.



Each blue line represents a regrind. Tool is brought up to center after each regrind.

### FEATURES:

1. Constant radial and helical relief-preground, only necessary to regrind top rake.
2. Short, stubby tools-minimum overhang means greater accuracy.
3. Maximum rigidity-produces round, straight holes.
4. Free cutting-minimum deflection.
5. Ability to hold size with minimum adjustment.
6. Superior finish-possibly eliminating the need for grinding operations.

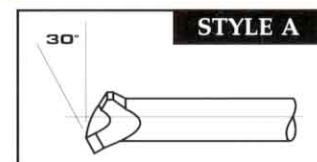
Bokum 'CN' boring tools range from a minimum boring diameter of  $\frac{1}{16}$ " to  $\frac{1}{8}$ ". Shank size range from  $\frac{1}{4}$ " to  $\frac{3}{4}$ ". 8mm, 10mm and 12mm sizes are also available. Because the carbide neck is firmly held in a steel shank, our tools can bore a hole as small as  $\frac{1}{16}$ " in dia. and  $\frac{3}{8}$ " deep while maintaining accuracy of up to .0001".

## BOKUM BORING TOOLS

### COME IN TWO STYLES:

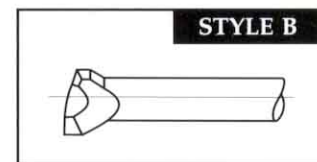
Style "A" for:

1. Heavier cuts.
2. Thru boring.
3. Average finish.



Style "B" for:

1. Best possible finish.
2. Boring, facing, bottoming.
3. Light to medium cuts



### REGRINDING:

Our Boring tools have 180° of effective regrinding life. For every  $\frac{1}{4}$ " of grinding area there are approx. 15 regrinds (assuming average regrind of .015"). This translates into longer tool life at a greater savings than today's inserts. Tools can be reground using our BSC3-16\* resharping fixtures with the use of a surface grinder, or tools can be resharpened at our plant for a nominal cost.

### SPECIAL/ALTERED TOOLING:

Our Engineering department can also design special, or alter existing boring tools, to meet your special requirements. By letting us design the tool to meet your needs, we can help keep your costs down. Here are the benefits of special/modified tooling:

- Altered tools are modified from our standard tools thus minimizing production time.
- Minimal print changes are needed, thus saving special tool designing.
- Tool cost is known in advance for budget and purchasing requirements.
- Altered tooling can be delivered in 2-3 weeks or less from time of order.
- Special tooling can be made to your specifications.
- Any of the dimensions on the following page can be altered to your specifications.
- Special tooling is delivered in 6-8 weeks from time of order.

\* Please contact us or our representative about further information on our BSC3-16 regrinding fixture.