

BORING KIT



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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).



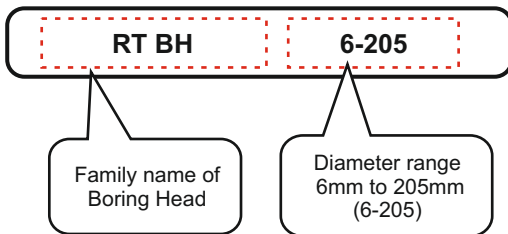
Facts & Advantages

- ▶ Used for 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.



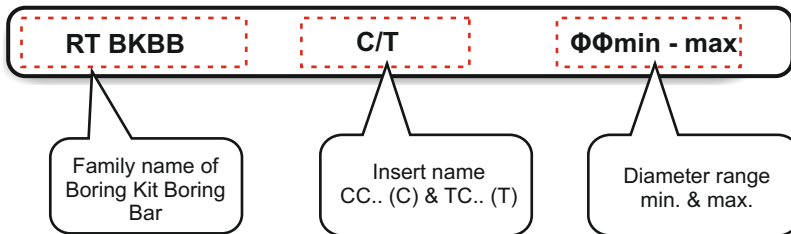
SAMPLE IMAGE

Nomenclature Code Key for Ordering Boring Head for Boring Kit



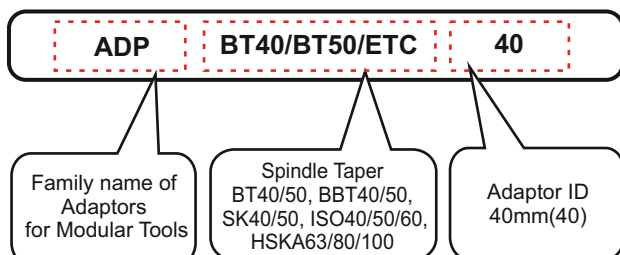
Ordering Example:
1 piece
RT BH 6 - 205

Nomenclature Code Key for Ordering Boring Bars for Boring Kit



Ordering Example:
1 piece
RT BKBBT 0811

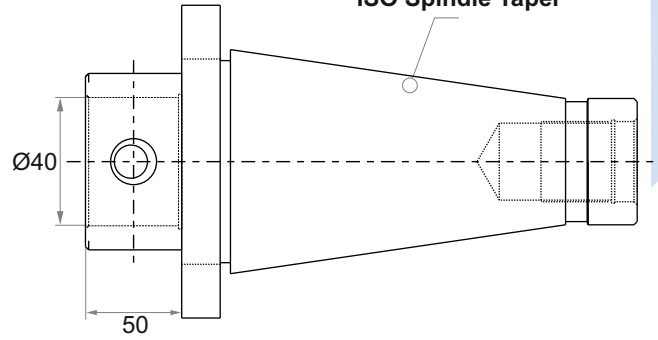
Nomenclature Code Key for Ordering Adaptor



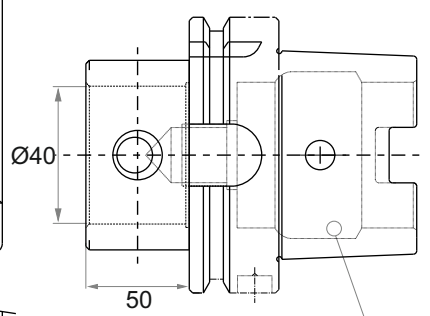
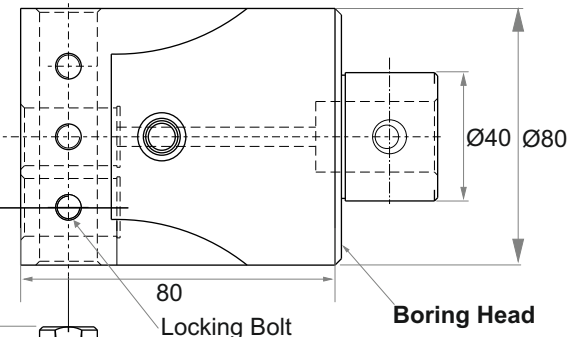
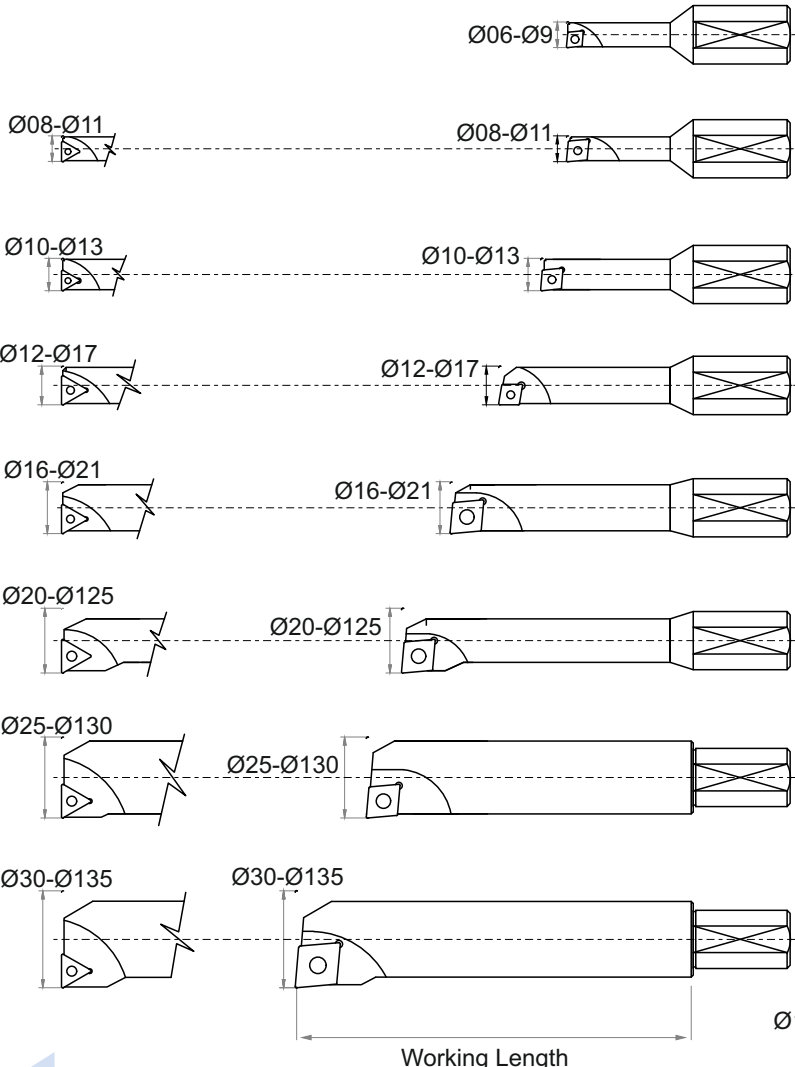
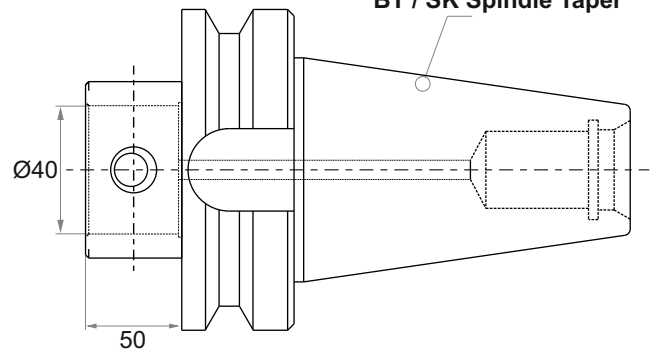
Ordering Example:
1 piece
ADP BT 40 40

Assembly Details - Schematic Drawing

Conceptual drawing for ISO Spindle Taper



Conceptual drawing for BT / SK Spindle Taper



Conceptual drawing for HSK Spindle Taper

Adapter Options for Boring Kit

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

Boring Head for Boring Kit

All dimensions are in mm.

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 for TC.. Inserts

All dimensions are in mm.

Sr. No	Item Code	Insert	Diameter Range $\Phi_{max}\Phi_{min}$ - 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 of the end of the page.



SAMPLE IMAGE

Boring Bars for Boring Kit for CC.. Inserts

All dimensions are in mm.

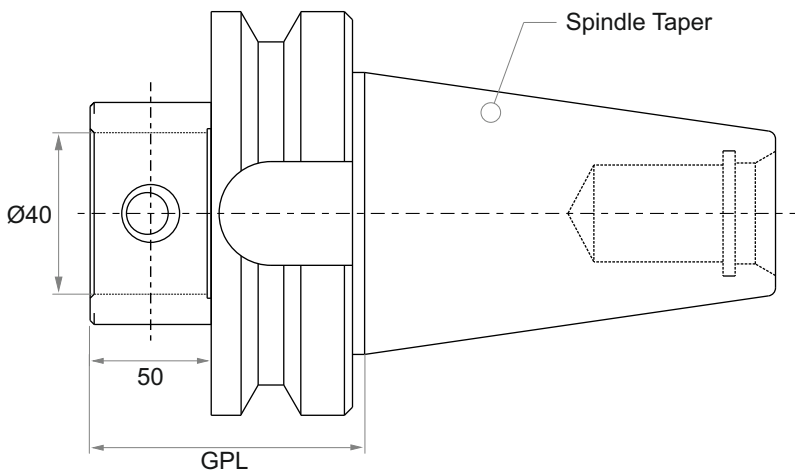
Sr. No	Item Code	Insert	Diameter Range $\Phi_{max}\Phi_{min}$ - D	Working Length
1	RT KBBC 0609	CC.. 0400	6-9	26
2	RT KBBC 0811	CC.. 0602	8-11	32
3	RT KBBC 1013	CC.. 0602	10-13	40
4	RT KBBC 1217	CC.. 0602	12-17	53
5	RT KBBC 1621	CC.. 09T3	16-21	68
6	RT KBBC 20125	CC.. 09T3	20-125	83
7	RT KBBC 25130	CC..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

Notes:

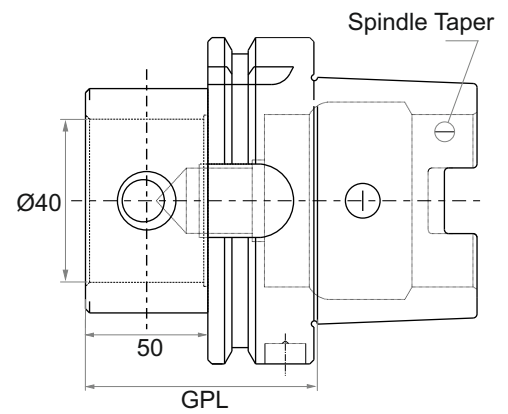
- Insert Screws and Torx keys will be provided along with the Boring Bars. Inserts not included.
- Please refer to page no. 6 for insert spare details.
- If required additionally, all spares can be ordered separately as well.
- Diameter range 'D' calculated considering 0.4mm insert nose radius.
- Maximum 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	◆



SAMPLE IMAGE

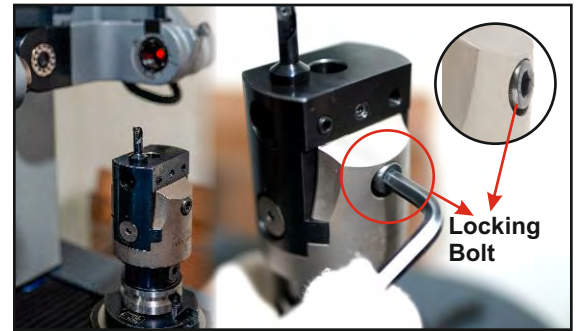
Notes:

- 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.

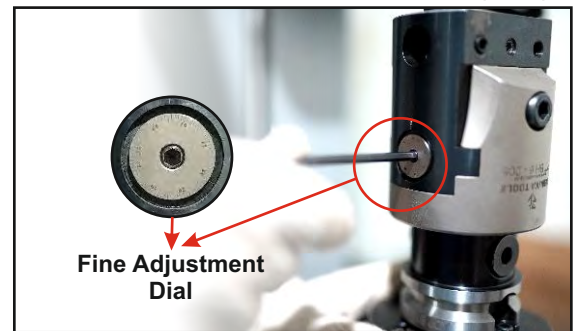
Spare Details

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

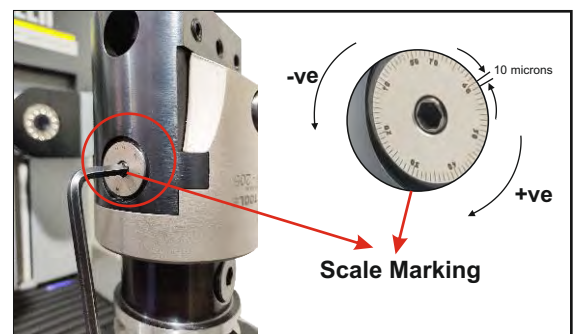
- ▶ The boring head is initially set on minimum mark on the scale.
- ▶ Follow instructions below to assemble the boring kit:
 - a) Clamp the required boring bar on to the boring head with the help of the clamping screws provided with the boring head.
 - b) Clamp the adaptor on to the boring head with 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. Commercial 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 & FINISH BORING CARTRIDGES



DUO BORING BARS



OUR OTHER CUSTOMIZED PRODUCTS

COMBINATION BORING BARS
ANTI-VIBRATION BORING BARS
SPECIAL CARTRIDGES



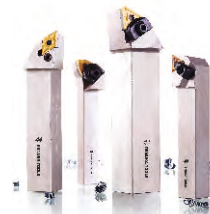
U-DRILLS
TREPANNING TOOLS



MILLING CUTTERS



TURNING TOOLS



SPECIAL ADAPTORS



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