



# DUO BORING BARS



© 2000-2024, Renuka Tools, India. All Rights Reserved. Renuka Tools & the Renuka Tools' logo are registered trademarks of Renuka Tools.



Redefining Cutting Technology

[www.renukatools.in](http://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 plant come with a Zoller and / or Haimer 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 Units / Fine Boring Units
- ▶ Adjustable Boring Tools
- ▶ Turning Tools
- ▶ Eccentric Boring Tools
- ▶ Boring Kit
- ▶ Anti-vibration Boring Tools
- ▶ Milling Cutters
- ▶ Spot Face Cutters
- ▶ Chamfer Tools
- ▶ Special Adaptors

## **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 Duo Boring Bars. For more details of our other standard offerings, please refer to our website ([www.renukatools.in](http://www.renukatools.in)).



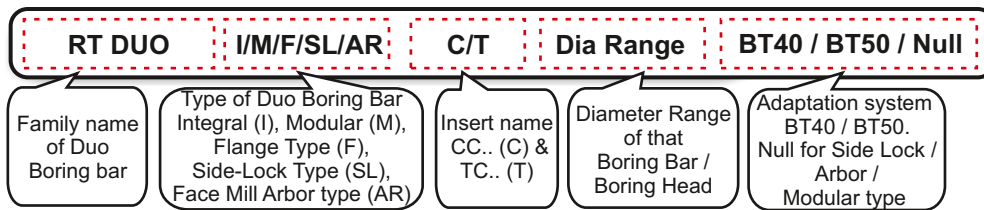
# Adjustable Duo Boring Bars



## Facts & Advantages

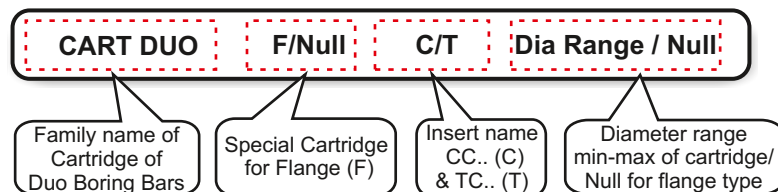
- ▶ Used for Rough Boring application from diameter 20mm to 500mm with scale marked on tool.
- ▶ Available with options of selecting either Integral / Modular / Flange type (for large diameters) / Side-Lock & Face Mill Arbor type depending on the requirement.
- ▶ User friendly, quick assembly & quick 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



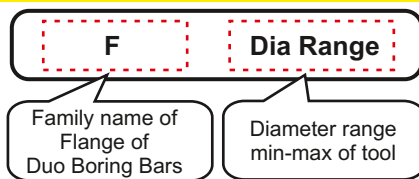
**Ordering Example:**  
1 piece  
RT DUO IT 20-24 BT 40

## Nomenclature Code Key for Ordering Cartridge



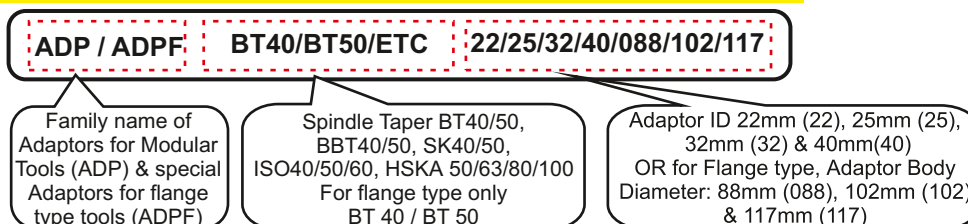
**Ordering Example:**  
1 piece  
CART DUO T 20-24

## Nomenclature Code Key for Ordering Flange



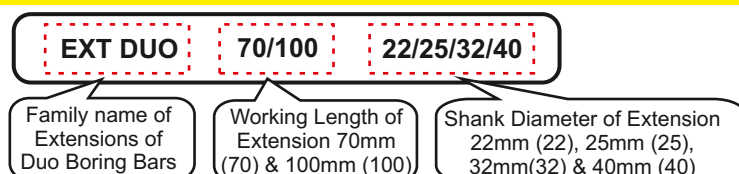
**Ordering Example:**  
1 piece  
F 200-250

## Nomenclature Code Key for Ordering Adaptor



**Ordering Example:**  
1 piece  
ADP BT 40 22

## Nomenclature Code Key for Ordering Extension



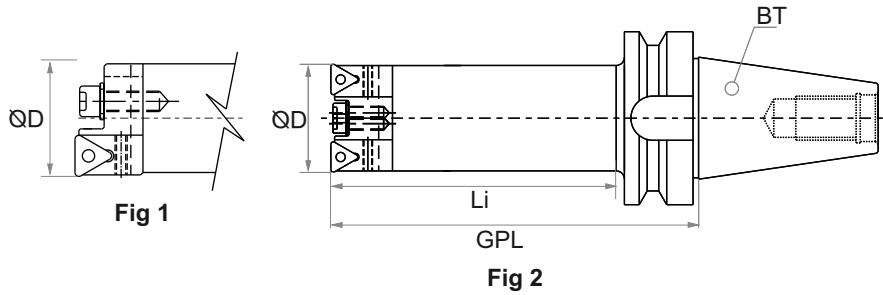
**Ordering Example:**  
1 piece  
EXT DUO 70 22



# Integral Type Duo Boring Bars



## 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	ØD Range	Li	GPL	Flange Mat.	Wt. in KG
Fig 1	1	RT DUO IT 20-24 BT40 / BT50	BT40 / BT50	CART DUO T 20-24	TC..0902	20-24	80	107 / 118	ST / ST	1.2 / 4.0
Fig 2	2	RT DUO IT 24-30 BT40 / BT50	BT40 / BT50	CART DUO T 24-30	TC..0902	24-30	80	107 / 118	ST / ST	1.3 / 4.0
	3	RT DUO IT 29-36 BT40 / BT50	BT40 / BT50	CART DUO T 29-36	TC..1102	29-36	87	114 / 125	ST / ST	1.4 / 4.2
	4	RT DUO IT 36-44 BT40 / BT50	BT40 / BT50	CART DUO T 36-44	TC..1102	36-44	108	135 / 146	ST / ST	1.8 / 4.6
	5	RT DUO IT 43-54 BT40 / BT50	BT40 / BT50	CART DUO T 43-54	TC..1102	43-54	115	142 / 153	ST / ST	2.2 / 5.0
	6	RT DUO IT 53-66 BT40 / BT50	BT40 / BT50	CART DUO T 53-66	TC..1102	53-66	120	147 / 158	ST / ST	2.9 / 5.7
	7	RT DUO IT 65-83 BT40 / BT50	BT40 / BT50	CART DUO T 65-83	TC..16T3	65-83	155	182 / 193	ST / ST	4.5 / 7.3
	8	RT DUO IT 82-103 BT40 / BT50	BT40 / BT50	CART DUO T 82-103	TC..16T3	82-103	206	233 / 244	ST / ST	5.0 / 7.8
	9	RT DUO IT 100-130 BT40 / BT50	BT40 / BT50	CART DUO T 100-130	TC..16T3	100-130	210	237 / 248	ST / ST	5.5 / 10.0
	10	RT DUO IT 125-155 BT40 / BT50	BT40 / BT50	CART DUO T 125-155	TC..16T3	125-155	273	300 / 311	AL / AL	6.5 / 12.5
	11	RT DUO IT 150-205 BT40 / BT50	BT40 / BT50	CART DUO T 150-205	TC..16T3	150-205	273	300 / 311	AL / AL	7.0 / 15.0

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

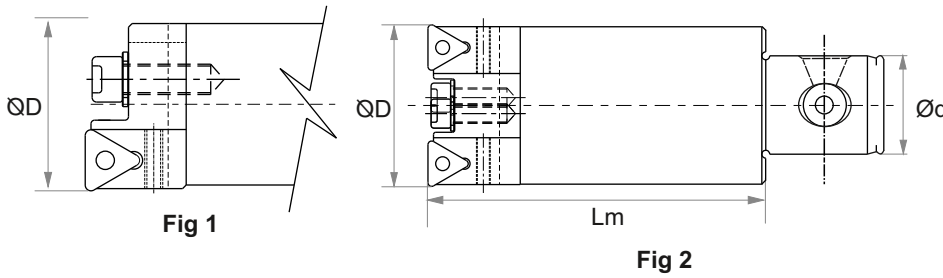
## Integral Type Duo Boring Bar for CC.. Inserts

All dimensions are in mm.

Fig. No	Sr. No	Item Code	Holding Taper	Cartridge Item Code	Insert	ØD Range	Li	GPL	Flange Mat.	Wt. in KG
Fig 1	1	RT DUO IC 20-24 BT40 / BT50	BT40 / BT50	CART DUO C 20-24	CC..0602	20-24	80	107 / 118	ST / ST	1.2 / 4.0
Fig 2	2	RT DUO IC 24-30 BT40 / BT50	BT40 / BT50	CART DUO C 24-30	CC..0602	24-30	80	107 / 118	ST / ST	1.3 / 4.0
	3	RT DUO IC 29-36 BT40 / BT50	BT40 / BT50	CART DUO C 29-36	CC..0602	29-36	87	114 / 125	ST / ST	1.4 / 4.2
	4	RT DUO IC 36-44 BT40 / BT50	BT40 / BT50	CART DUO C 36-44	CC..0602	36-44	108	135 / 146	ST / ST	1.8 / 4.6
	5	RT DUO IC 43-54 BT40 / BT50	BT40 / BT50	CART DUO C 43-54	CC..09T3	43-54	115	142 / 153	ST / ST	2.2 / 5.0
	6	RT DUO IC 53-66 BT40 / BT50	BT40 / BT50	CART DUO C 53-66	CC..09T3	53-66	120	147 / 158	ST / ST	2.9 / 5.7
	7	RT DUO IC 65-83 BT40 / BT50	BT40 / BT50	CART DUO C 65-83	CC..09T3	65-83	155	182 / 193	ST / ST	4.5 / 7.3
	8	RT DUO IC 82-103 BT40 / BT50	BT40 / BT50	CART DUO C 82-103	CC..09T3	82-103	206	233 / 244	ST / ST	5.0 / 7.8
	9	RT DUO IC 100-130 BT40 / BT50	BT40 / BT50	CART DUO C 100-130	CC..09T3	100-130	210	237 / 248	ST / ST	5.5 / 10.0
	10	RT DUO IC 125-155 BT40 / BT50	BT40 / BT50	CART DUO C 125-155	CC..1204	125-155	273	300 / 311	AL / AL	6.5 / 12.5
	11	RT DUO IC 150-205 BT40 / BT50	BT40 / BT50	CART DUO C 150-205	CC..1204	150-205	273	300 / 311	AL / AL	7.0 / 15.0

- 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.
  - In the above table, in the column of flange material, ST stands for Steel, while AL stands for Aluminium.
  - 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	ØD Range	Lm	Max WL	Flange Mat.	Wt. in KG
Fig 1	1	RT DUO MT 20-24	CART DUO T 20-24	NA	22	TC..0902	20-24	80	80	ST	0.4
	2	RT DUO MT 24-30	CART DUO T 24-30	NA	22	TC..0902	24-30	80	80	ST	0.5
Fig 2	3	RT DUO MT 29-36	CART DUO T 29-36	NA	22	TC..1102	29-36	87	87	ST	0.6
	4	RT DUO MT 36-44	CART DUO T 36-44	NA	22	TC..1102	36-44	108	108	ST	1.0
	5	RT DUO MT 43-54	CART DUO T 43-54	EXT DUO 7022/10022	22	TC..1102	43-54	115	245	ST	1.3
	6	RT DUO MT 53-66	CART DUO T 53-66	EXT DUO 7025/10025	25	TC..1102	53-66	120	260	ST	2.0
	7	RT DUO MT 65-83	CART DUO T 65-83	EXT DUO 7025/10025	25	TC..16T3	65-83	155	295	ST	3.8
	8	RT DUO MT 82-103	CART DUO T 82-103	EXT DUO 7032/10032	32	TC..16T3	82-103	206	356	ST	4.6
	9	RT DUO MT 100-130	CART DUO T 100-130	EXT DUO 7040/10040	40	TC..16T3	100-130	210	370	ST	5.5
	10	RT DUO MT 125-155	CART DUO T 125-155	EXT DUO 7040/10040	40	TC..16T3	125-155	273	433	AL	8.5
	11	RT DUO MT 150-205	CART DUO T 150-205	EXT DUO 7040/10040	40	TC..16T3	150-205	273	433	AL	9.0

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	ØD Range	Lm	Max WL	Flange Mat.	Wt. in KG
Fig 1	1	RT DUO MC 20-24	CART DUO C 20-24	NA	22	CC..0602	20-24	80	80	ST	0.4
	2	RT DUO MC 24-30	CART DUO C 24-30	NA	22	CC..0602	24-30	80	80	ST	0.5
Fig 2	3	RT DUO MC 29-36	CART DUO C 29-36	NA	22	CC..0602	29-36	87	87	ST	0.6
	4	RT DUO MC 36-44	CART DUO C 36-44	NA	22	CC..0602	36-44	108	108	ST	1.0
	5	RT DUO MC 43-54	CART DUO C 43-54	EXT DUO 7022/10022	22	CC..09T3	43-54	115	245	ST	1.3
	6	RT DUO MC 53-66	CART DUO C 53-66	EXT DUO 7025/10025	25	CC..09T3	53-66	120	260	ST	2.0
	7	RT DUO MC 65-83	CART DUO C 65-83	EXT DUO 7025/10025	25	CC..09T3	65-83	155	295	ST	3.8
	8	RT DUO MC 82-103	CART DUO C 82-103	EXT DUO 7032/10032	32	CC..09T3	82-103	206	356	ST	4.6
	9	RT DUO MC 100-130	CART DUO C 100-130	EXT DUO 7040/10040	40	CC..09T3	100-130	210	370	ST	5.5
	10	RT DUO MC 125-155	CART DUO C 125-155	EXT DUO 7040/10040	40	CC..1204	125-155	273	433	AL	8.5
	11	RT DUO MC 150-205	CART DUO C 150-205	EXT DUO 7040/10040	40	CC..1204	150-205	273	433	AL	9.0

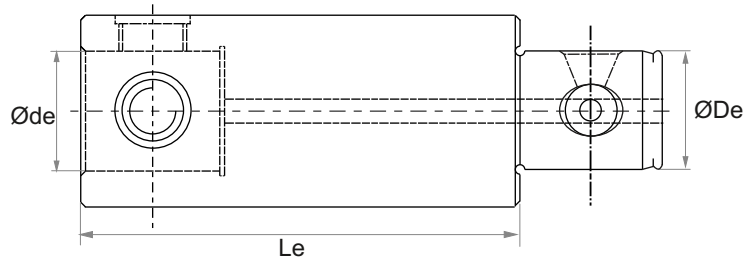
Notes:

- 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'.
- In the above table, in the column of flange material, ST stands for Steel, while AL stands for Aluminium.
- Please ensure that the weight of the complete assembly of Boring Head, Extension and the Adaptor, does not exceed the maximum weight carrying capacity of your machine spindle. Individual weights of Boring Heads, Extensions and Adaptors are mentioned in their respective specification tables.
- 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

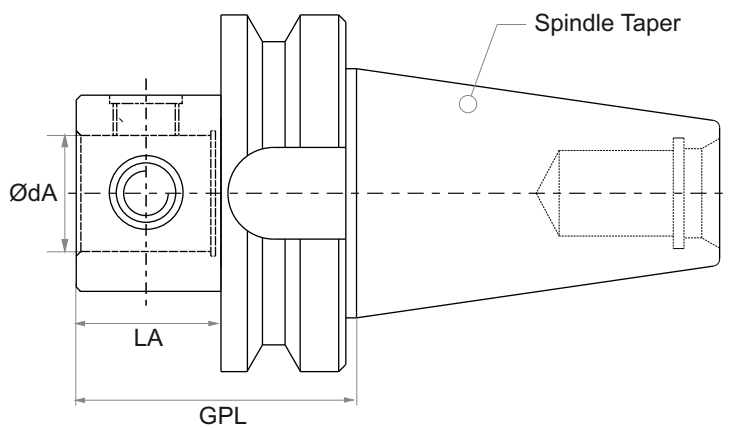
All dimensions are in mm.

Sr no.	Item No.	Working Length of Extension (Le)	Øde	ØDe	Wt. in KG
1	EXT DUO 7022	70	22	22	0.5
2	EXT DUO 10022	100	22	22	1.0
3	EXT DUO 7025	70	25	25	1.1
4	EXT DUO 10025	100	25	25	1.6
5	EXT DUO 7032	70	32	32	2.2
6	EXT DUO 10032	100	32	32	3.0
7	EXT DUO 7040	70	40	40	2.6
8	EXT DUO 10040	100	40	40	3.4

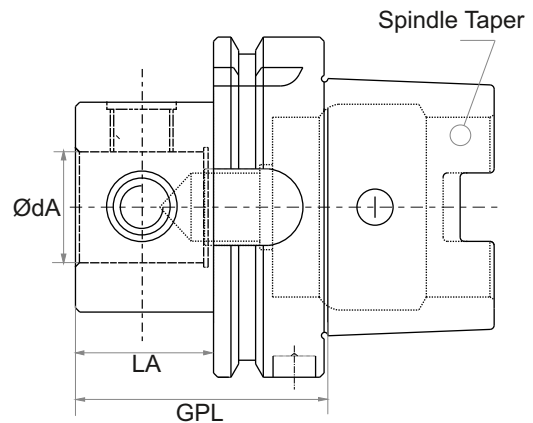


- Notes:
- To order the right extension, please ensure that the shank diameter of the Modular Boring Head 'Ød' should match the diameter of Extension ID 'Øde'.
  - To order the right adaptor, please ensure that the shank diameter of Extension 'Øde' should match the diameter of Adaptor ID 'ØdA'.
  - Please ensure that the weight of the complete assembly of Boring Head, Extension and the Adaptor, does not exceed the maximum weight carrying capacity of your machine spindle. Individual weights of Boring Heads, Extensions and Adaptors are mentioned in their respective specification tables.

## Adaptor Details for Modular Type Duo Boring Bar



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



Conceptual Drawing for HSK Spindle Taper

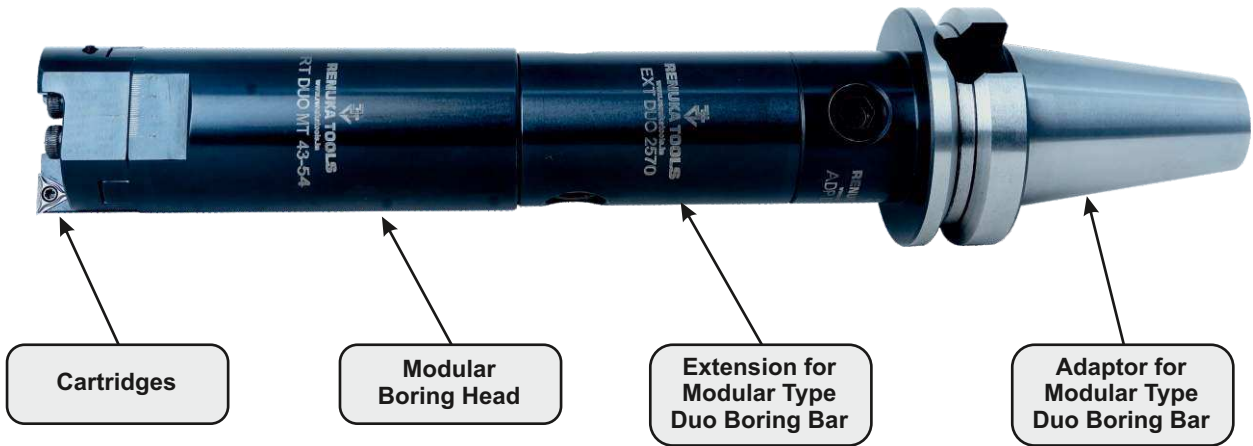
All dimensions are in mm.

Sr. No	Item Code	Spindle Taper	Adaptor ID ØdA	LA	GPL of Adaptor	Adaptor Bolt Item Code	Wt. in KG
1	ADP BT40 22	BT 40	22	30	57.0	RTMAB22	1.3
2	ADP BT40 25	BT 40	25	40	67.0	RTMAB25	1.6
3	ADP BT40 32	BT 40	32	50	77.0	RTMAB32	2.5
4	ADP BT40 40	BT 40	40	60	87.0	RTMAB40	3.3
5	ADP BT50 22	BT 50	22	30	68.0	RTMAB22	4.0
6	ADP BT50 25	BT 50	25	40	78.0	RTMAB25	4.3
7	ADP BT50 32	BT 50	32	50	88.0	RTMAB32	5.1
8	ADP BT50 40	BT 50	40	60	98.0	RTMAB40	5.4
9	ADP HSKA63 22	HSKA 63	22	30	56.0	RTMAB22	1.1
10	ADP HSKA63 25	HSKA 63	25	40	66.0	RTMAB25	1.2
11	ADP HSKA63 32	HSKA 63	32	50	76.0	RTMAB32	1.7
12	ADP HSKA63 40	HSKA 63	40	60	86.0	RTMAB40	2.0

- Notes:
- To order the right adaptor, kindly ensure that the shank diameter of the Modular Boring Head 'Ød' or of Extension ID 'Øde' should match the diameter of Adaptor ID 'ØdA'.
  - Special Adaptor bolts will be provided along with the Adaptors. Can be ordered separately if required additionally.
  - Customized adaptors of any spindle taper other than listed in above table, can also be provided but will be made to order with lead time of 3-6 weeks.
  - Please ensure that the weight of the complete assembly of Boring Head, Extension and the Adaptor, does not exceed the maximum weight carrying capacity of your machine spindle. Individual weights of Boring Heads, Extensions and Adaptors are mentioned in their respective specification tables.

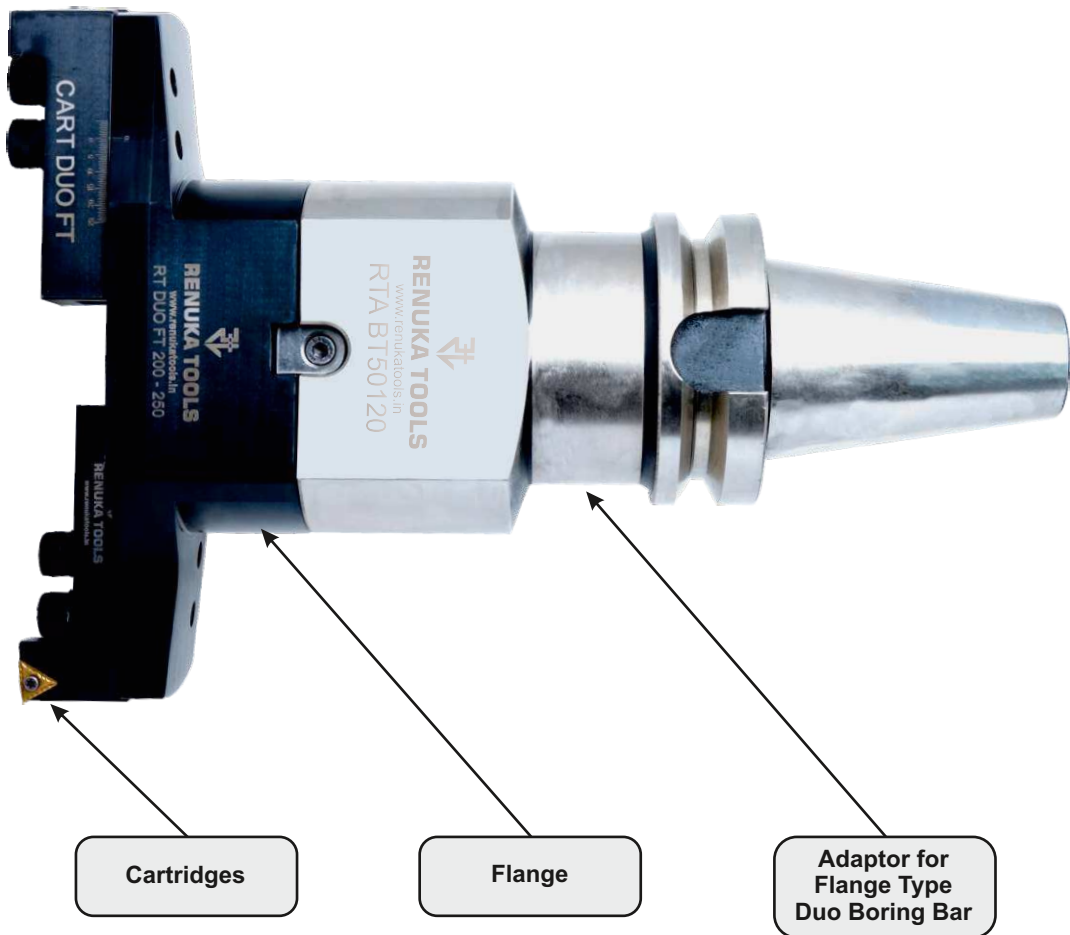
## Modular Type Duo Boring Bars

### Illustrative Image of Complete Assembly

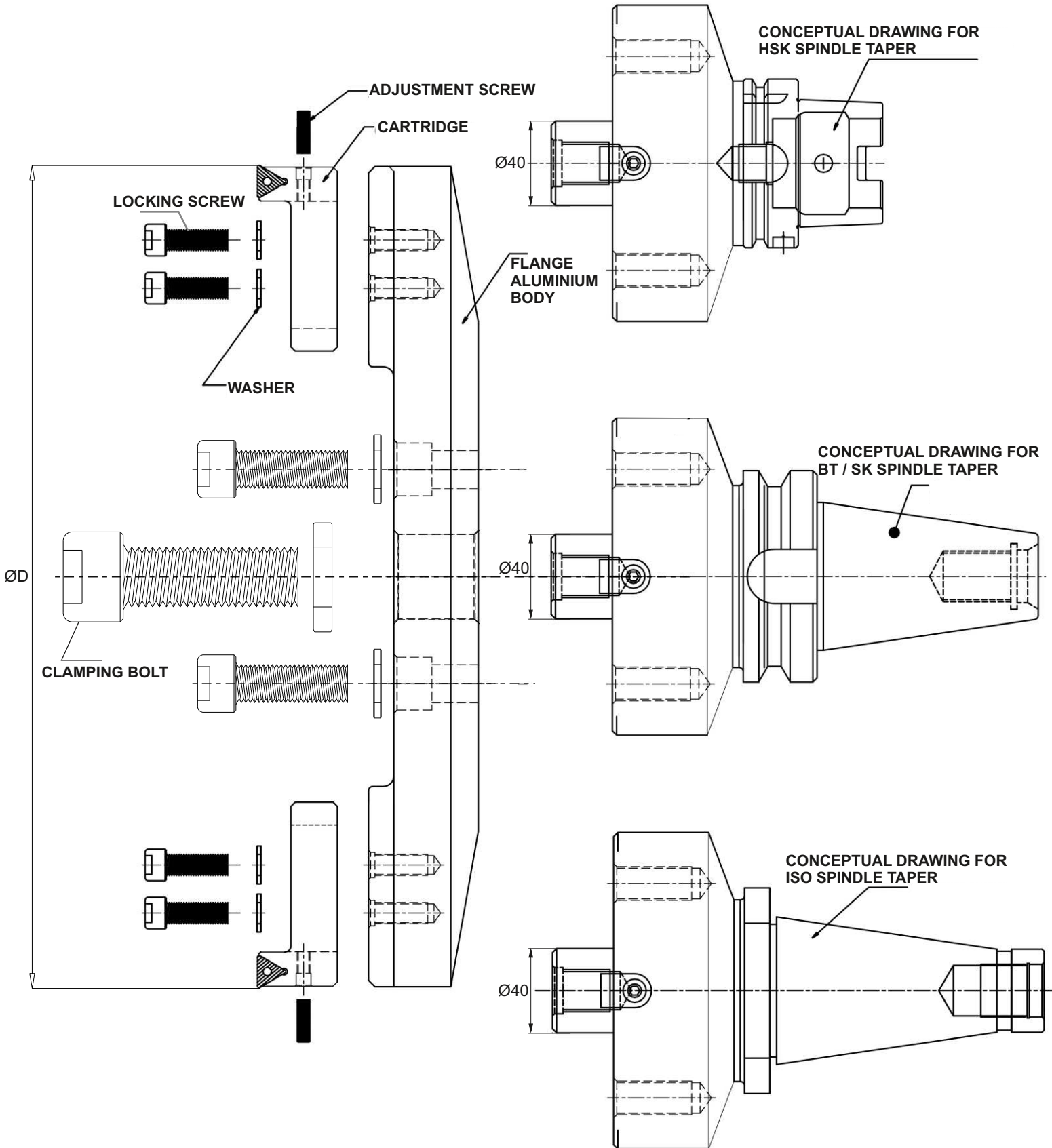


## Flange Type Duo Boring Bars

### Illustrative Image of Complete Assembly



## Assembly Details - Schematic Drawing



ADAPTOR OPTIONS FOR FLANGE TYPE DUO BORING BARS



# 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 Wt. in KG
1	RT DUO FT 200-250 BT 40	F 200-250	ADPF BT40088	200-250	40	88	167	6.7
2	RT DUO FT 200-250 BT 50	F 200-250	ADPF BT50102	200-250	40	102	178	10.7
3	RT DUO FT 250-300 BT 40	F 250-300	ADPF BT40088	250-300	40	88	167	7.3
4	RT DUO FT 250-300 BT 50	F 250-300	ADPF BT50102	250-300	40	102	178	11.3
5	RT DUO FT 300-350 BT 40	F 300-350	ADPF BT40088	300-350	40	88	167	7.8
6	RT DUO FT 300-350 BT 50	F 300-350	ADPF BT50102	300-350	40	102	178	11.8
7	RT DUO FT 350-400 BT 50	F 350-400	ADPF BT50117	350-400	40	117	178	12.5
8	RT DUO FT 400-450 BT 50	F 400-450	ADPF BT50117	400-450	40	117	178	13.1
9	RT DUO FT 450-500 BT 50	F 450-500	ADPF BT50117	450-500	40	117	178	13.8

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.

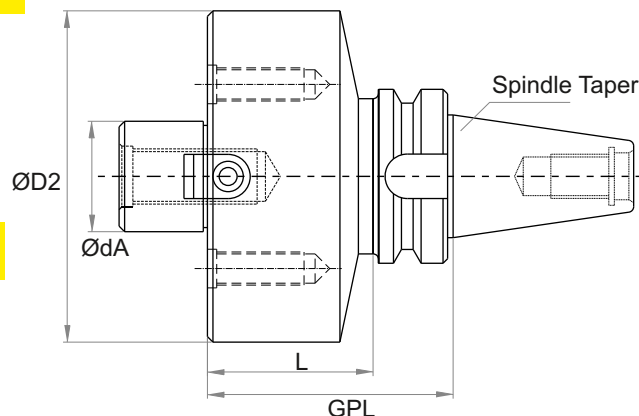
Sr. No	Item Code	Flange Item Code	Adaptor Item Code	D Ømin - Ømax	D1	D2	GPL	Total Tool Wt. in KG
1	RT DUO FC 200-250 BT 40	F 200-250	ADPF BT40088	200-250	40	88	167	6.7
2	RT DUO FC 200-250 BT 50	F 200-250	ADPF BT50102	200-250	40	102	178	10.7
3	RT DUO FC 250-300 BT 40	F 250-300	ADPF BT40088	250-300	40	88	167	7.3
4	RT DUO FC 250-300 BT 50	F 250-300	ADPF BT50102	250-300	40	102	178	11.3
5	RT DUO FC 300-350 BT 40	F 300-350	ADPF BT40088	300-350	40	88	167	7.8
6	RT DUO FC 300-350 BT 50	F 300-350	ADPF BT50102	300-350	40	102	178	11.8
7	RT DUO FC 350-400 BT 50	F 350-400	ADPF BT50117	350-400	40	117	178	12.5
8	RT DUO FC 400-450 BT 50	F 400-450	ADPF BT50117	400-450	40	117	178	13.1
9	RT DUO FC 450-500 BT 50	F 450-500	ADPF BT50117	450-500	40	117	178	13.8

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	Wt. in KG
1	ADPF BT40088	BT 40	40	88	60	89	3.0
2	ADPF BT50102	BT 50	40	102	60	100	6.9
3	ADPF Bt50117	BT 50	40	117	60	100	7.1

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 Bars



## Side lock Type Duo Boring Bar for TC..Inserts

All dimensions are in mm.

Sr. no	Item Code	Cartridge Item Code	Insert	ØD Range	Ød	L Working Length	Wt. in KG
1	RT DUO SLT 20-24	CART DUO T 20-24	TC..0902	20-24	20	80	0.4
2	RT DUO SLT 24-30	CART DUO T 24-30	TC..0902	24-30	25	80	0.6
3	RT DUO SLT 29-36	CART DUO T 29-36	TC..1102	29-36	25	80	0.7
4	RT DUO SLT 36-44	CART DUO T 36-44	TC..1102	36-44	32	80	1.1
5	RT DUO SLT 43-54	CART DUO T 43-54	TC..1102	43-54	32	80	1.3

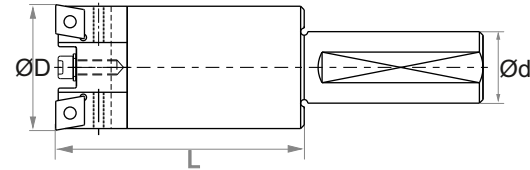


SAMPLE IMAGE

## Side lock Type Duo Boring Bar for CC..Inserts

All dimensions are in mm.

Sr. no	Item Code	Cartridge Item Code	Insert	ØD Range	Ød	L Working Length	Wt. in KG
1	RT DUO SLC 20-24	CART DUO C 20-24	CC..0602	20-24	20	80	0.4
2	RT DUO SLC 24-30	CART DUO C 24-30	CC..0602	24-30	25	80	0.6
3	RT DUO SLC 29-36	CART DUO C 29-36	CC..0602	29-36	25	80	0.7
4	RT DUO SLC 36-44	CART DUO C 36-44	CC..0602	36-44	32	80	1.1
5	RT DUO SLC 43-54	CART DUO C 43-54	CC..09T3	43-54	32	80	1.3

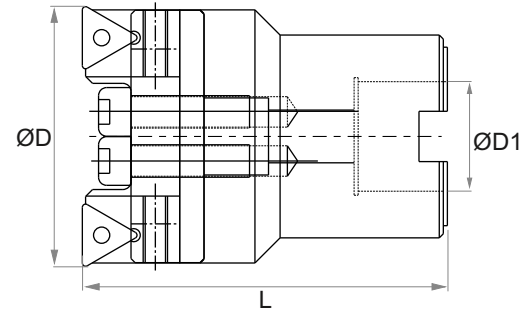


# Arbor Type Duo Boring Bars

## Arbor Type Duo Boring Bar for TC.. Inserts

All dimensions are in mm.

Sr. no	Item Code	Cartridge Item Code	Insert	ØD Range	ØD1	L Working Length
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
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.

Sr. no	Item Code	Cartridge Item Code	Insert	ØD Range	ØD1	L Working Length
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
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 (Refer Fig. 1 on page 4).
- All required spares are supplied with the tools. If required additionally, can be ordered separately as well. Inserts not included.
- Diameter range "D" calculated considering 0.8mm insert nose radius.

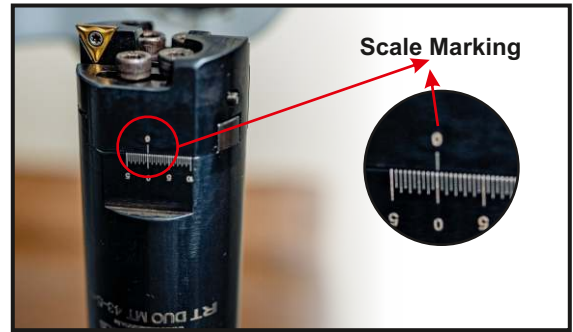
## Spare Details

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

# Operating Instructions for Duo Boring Bars



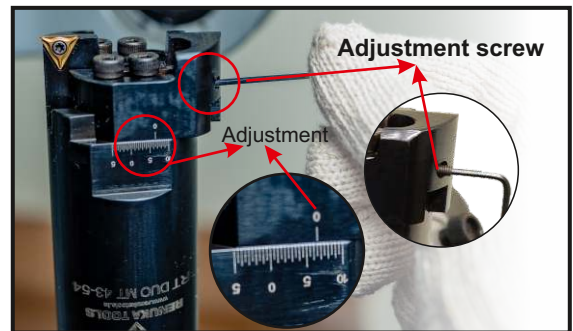
- ▶ Firstly do the complete assembly of the Modular type / Flange type / Side Lock type / Face Mill Arbor type Duo Boring Bar. Post assembly (if required), measure the exact diameter on the pre-setter or by using a precise dial indicator.
- ▶ The boring head is initially set on minimum mark on the scale (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.



Pic. 1



Pic. 2

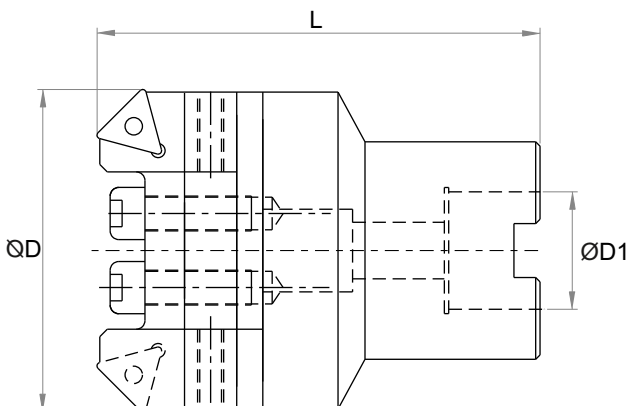


Pic. 3

## Other Applications of Duo Boring Bars

### 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  $\text{ØD} = \text{Ø}8.0\text{mm}$



SAMPLE IMAGE





## OUR OTHER STANDARD PRODUCTS

**MICRO BORE UNITS  
FINE BORING UNITS  
FINE BORING BARS**



**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**



**U-DRILLS  
TREPANNING TOOLS**



**MILLING CUTTERS**



**TURNING TOOLS**



**SPECIAL ADAPTORS**



# **RENUKA TOOLS®**

Gala No.10 & 11, Suvarna Laghu Udyog Yojana,  
Near Truck Terminus, MIDC, Waluj,  
Aurangabad - 431136, Maharashtra, India.

Mobile : (91) 9987224487  
Telephone : (91) 240-2952040 | (91)9423118885/86  
Email : anandmulay@renukatools.in  
info@renukatools.in  
sales@renukatools.in  
Website : www.renukatools.in

Version 24.1