

Boring tools

Type: Vhu, Vhs, Vh, Svn, 205bh, ABH

1.	With which accuracy is possible to bore with heads NAREX?	Mainly with an accuracy of IT7 and higher, only boring head 205 with an accuracy of IT6.
2.	What the smallest slot is possible to bore by heads?	Minimum diameter of boring slot is around 6mm. For smaller diameters firm NAREX MTE does not deliver tools. We can say that the minimum diameter depends on tool not on the head. Head is restricted by revolutions and this way is restricted cutting speed on the tool.
3.	What heads can be used in automatic cycle on NC and CNC machines?	All except universal boring heads Vhu which need direct staff. There are operation during buttoned shog on Vhu. All other operations - boring can be realized on NC and CNC machines.
4.	Is delivered head Vhu 20?	Head Vhu 20 is not produced even delivered, this head is substituted by Vhu 36.
5.	Are provided repairs of head Vhu 32?	Head Vhu 32 is old type and its production was ended 30 years ago. Spare parts are not produced and repairs are not provided.
6.	New modification heads Vhu have new tool equipment, is delivered old original tool equipment as well?	It is delivered only like spare parts and in range which is on the stock. We try to substitute it by new toolss with VBD, which you can find in prospect Innovation change Vhu.
7.	Are given maximum revolutions for boring heads NAREX ?	6.000 rev/min by heads ABH-100 and 250-boring head, 1.500 rev/min for Vhs 5-50, Vhs 10-100 and VH-70, 800 rev/min by Vhu36, Vhs 10-125 and VH-110, 500 rev/min by all other heads
8.	What is difference between boring head and universal boring head?	Boring head is designed only for boring of cylindrical slots. Universal boring head is for operations which need cross tool movement during head turning. This makes possible spotface slots faces and bore taper slots.
9.	Under what conditions can be bored taper slots by head Vhu?	Main condition is that it must be on tight bound axial movement spindle machine with its revolutions. Top angel of taper shank is designed for boring in range 5 - 85°.
10.	How deep can be slots bored?	Usually to the deepness according to heads accessories. There are bars, holders and boring tools. Their length you find in relevant catalogue.
11.	Is it possible to use boring heads on usuall table drills or stand drills?	Boring head needs spindle machine rigidity, table rigidity and clamping of the part. Furthermore needs machine feed with possibility of its switch-off in needed place. If the rigidity is insufficient the boring result is not reliable.
12.	What is use of boring tools set SVn?	SVn is rigid doubletools boring instrument which is designed for boring of molten, rough or blown slots - through or blind. During using finishing tool is possible to finish prebored slot with an accuracy of IT7.
13.	How can be ordered this set SVn?	We recommend you to order this set SVn according to the catalogue (separately parts which are given in catalogue Boring tools on page 17). Variant scheme shows which parts is possible to complete in each from four ranges.
14.	What does it mean for example for range SVn260 - 380?	It is boring tool for range 260-380mm, completed from following parts: arbor work for milling angel heads - part yellow, body 1/2 - part lila, 2pcs shoulder 2/1 - part darkblue, tools equipment - parts light blue.

15.	What does it mean tools equipment SVn 90?	Tools equipment SVn 90 consists of : set of inside corner tools - mark 3/1 + 3/2 set of inside rougher tools - mark 4/1 + 4/2
16.	What does it mean tools equipment SVn 380 and SVn 600?	Tools equipment SVn 380 and 600 consists of: set of inside corner tools - mark 3/1 + 3/2 set of inside rougher tools - mark 4/1 + 4/2 set of outer tools - mark 5/1 + 5/1 set of finishing tools with counterweight - mark 6/1
17.	What is difference between tool 3/1 and 3/2?	There is difference in length - 1mm. For a first time starts tool 3/1 taking off splinter and after boring slot of length 1mm starts working tool 3/2 as well. This tool 3/2 has arranged its depth of splinter different from right tool.
18.	Is it possible to use tools from SVn90 to SVn380?	It is impossible, tools for SVn90 are smaller and have different form.
19.	Why is for range of SVn 150-260 necessary different body than for range of SVn 260-380?	It is because of the clamping need - in first case tool clamping and in second case shoulder clamping.
20.	What does adjust boring diameter on SVn?	Adjusting machine or by measuring of tool extrusion and measuring of boring slot. Tools, shoulders and bodies have on their ground surface mounting between which can be insert for example end gauges.
21.	What is difference between taper shank VK360 and VK801?	Taper shanks VK360 have flange diameter 70mm. Shanks VK801 have flange diameter 110mm. VK360 are designed for Vhu 36, Vh 70, Vhs 50, and Vhs 10-125. Taper shanks VK801 are designed for boring heads Vhu 56 to Vhu 160, Vh 110, Vh 140 and Vhs 40-180. There is also type VK800 R8 but it is designed only for head Vhu 56 and especially for North American market.
22.	Is there assured coolant supply to the insert in fine boring head 205bh?	By boring tools type C,D and E it is assured. By usage of tool units type K and L is coolant supply assured by holders F and G. Tool units type M and N haven't any coolant supply to the insert. For coolant supply can be used through flow in the bottom part of head 205bh.
23.	Is possible to use insert from other producer for boring tools in 205bh?	If you have boring tools type WOHLHAUPTER, then must be used only inserts from WOHLHAUPTER, the reason is special form (inserts are delivered by NAREX MTE s.r.o.). If you have boring tools type ISO TPGT080202 (standard accessories of 205bh), then you can order inserts from whatever producer up to this ISO norm.