ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing

Drilling

Reaming

Burnishing

Threading

Specials

Wohlhaupter®

▶ *BORING*

Rough Machining

WOHLHAUPTER®

SECTION

B10-D

Rough Machining

Wohlhaupter® Rough Machining

Twin Cutters | Chamfering Tools | Grooving Tools | Axial Grooving | Reverse Machining | VolCut

- Diameter Range: 0.768" - 9.645" (19.50 mm - 245.00 mm)

Variety of tooling. Versatile operations.

A versatile range of tools for rough machining includes rough boring, chamfering, reverse machining, circular milling, and axial grooving. The insert holders with various insert pockets as well as height displaced insert holders are able to be easily adjusted for a quick setup process.

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.

This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

⚠ WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

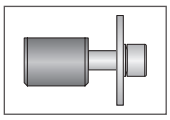
NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

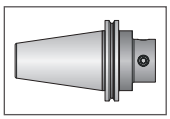
Visit www.alliedmachine.com for the most up-to-date information and procedures.

Applicable Industries

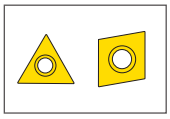
Reference Icons
The following icons will appear throughout the catalog to help you navigate between products.



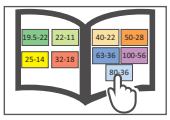
Clamping Elements
For use with insert holders and boring heads



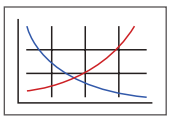
Shanks
A variety of shanks for different machines



Inserts
For use with insert holder boring heads and boring bars using indexable inserts



MVS Connection Color Guide
Detailed instructions and information regarding the MVS connection(s)



Recommended Cutting Data
Speed and feed recommendations for optimum and safe boring

Coolant-Through Option
Indicates that the product is coolant through

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Series	Diameter Range	
	Imperial (inch)	Metric (mm)
Twin Cutters	0.768 - 8.071	19.50 - 205.00
Chamfering	0.748 - 8.504	19.00 - 216.00
Radial Grooving	0.787 - 3.110	20.00 - 79.00
Axial Grooving	0.787 - 8.071	20.00 - 205.00
Reverse Machining	1.142 - 9.646	29.00 - 245.00

Roughing Tools
ROUGH MACHINING

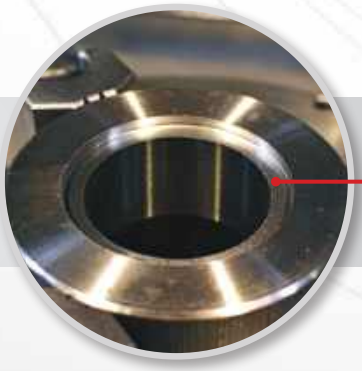
Versatile tools for a variety of applications.

- Diameter range: 0.768" - 9.646" (19.50 mm - 245.00 mm).
- Tangential inserts and insert holders also available.
- Serrated tool bodies can be used for multiple applications including rough boring, chamfering, back boring, and axial grooving.
- Insert holders can be used on large diameter Alu-Line serrated tool bodies and slides located in section G: 3.937" - 128.15" (100.00 mm - 3255.00 mm).

Roughing Applications

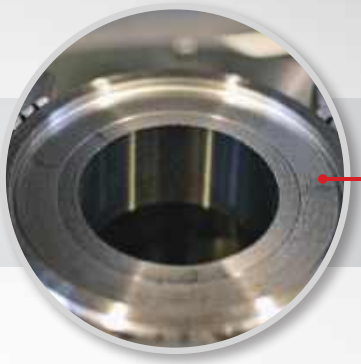
Twin Cutter Assembly:
(1) Reducer: 219087
(2) Serrated tool body: 148004
(3) Insert holders: 151004
(4) Inserts: 10408M158HC79

Tangential Cutter Assembly:
(1) Shank: 353007
(2) Serrated tool body: 148005
(3) Insert holders: 151043
(4) Inserts: 00508M880HC198



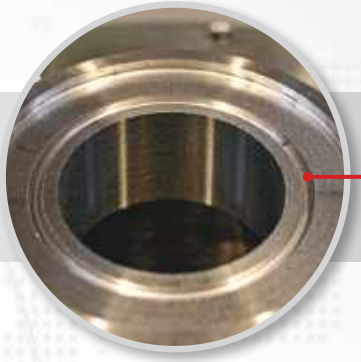
First Tangential Cut

Tangential Cutter Assembly:
(1) Shank: 353008
(2) Serrated tool body: 148006
(3) Insert holders: 151035
(4) Inserts: 397594WHC198



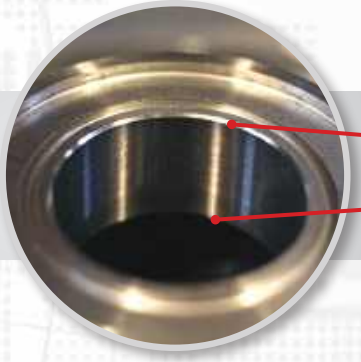
Second Tangential Cut

Axial Grooving Assembly:
(1) Shank: 353009
(2) Serrated tool body: 148007
(3) Support block: 226011
(4) Insert holder: 226010
(5) Insert: 297978WCH136



Axial Groove Cut

Chamfer Assembly:
(1) Shank: 353003
(2) Serrated tool body: 148004
(3) Insert holder: 201009
(4) Inserts: 297497WHC79



Top Chamfer

Bottom Chamfer

Radial Grooving Assembly:
(1) Shank: 353007
(2) Grooving tool: 143055
(3) Inserts: 097254WCH136

Grooves

Finished Application

Case Study

Cycle time is crucial. Why not choose the best process?

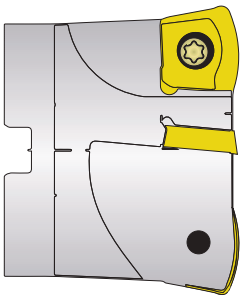
Application: Ductile Cast Iron

Finish Diameter: 1.930" (49 mm)

Pre-Hole Diameter: 1.77" (45 mm)

Boring Depth: 8.23" (209 mm)

Measure	Rough 49 mm Competitor 1.5" High Feed Milling Tool
Speed	1000 SFM (2500 RPM)
Feed Rate	0.020 IPT (153 IPM)
Total Passes	77
Cycle Time (per part)	**1.93 min**



1.5" High Feed Milling Tool

OUR ***SOLUTION***

Wohlhaupter® Twin Cutter

Measure	Rough 49 mm Wohlhaupter Twin Cutter
Speed	500 SFM (900 RPM)
Feed Rate	0.012 IPR (11.88 IPM)
Total Passes	1
Cycle Time (per part)	**0.69 min**

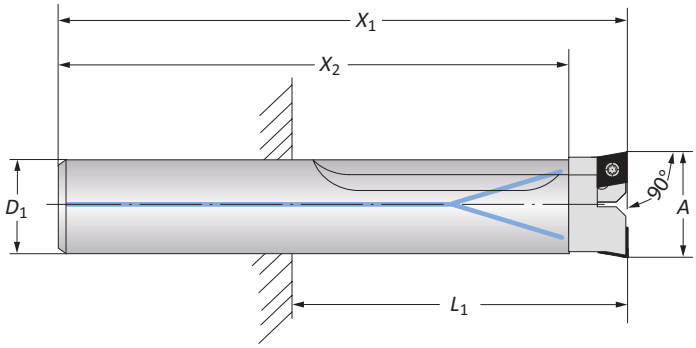
- Twin Cutter assembly:
  (1) ***Insert Holders (x2): 151023***
  (2) ***Serrated tool body: 148018***
  (3) ***Shank: 353015***

Boring inserts
- ***Item No.: 297239WHC79***

Wohlhaupter Twin Cutter

Twin Cutters Same Level

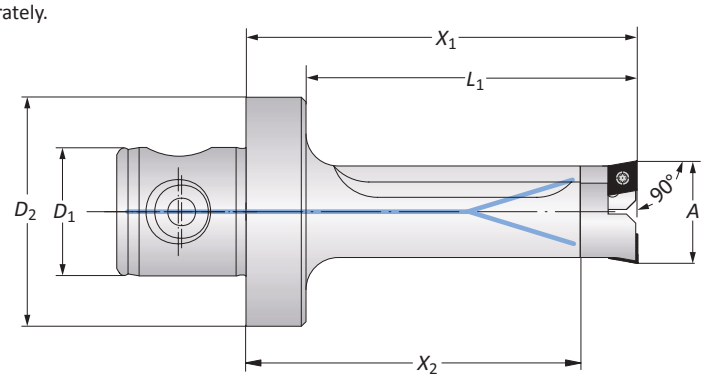
90° | Diameter Range: 0.768" - 1.181" (19.50 mm - 30.00 mm)



Twin Cutters Same Level

	Connection	Boring Range	Twin Cutter					Part No.	
	D_1	A	X_1	X_2	L_1	Weight	Insert Form	Insert Holder	Serrated Body
i	18	0.768 - 0.906	5.910	5.433	3.149	0.661 (lbs)	101	**235031**	**235021**
	20	0.886 - 1.024	5.910	5.433	3.543	0.661 (lbs)	101	**235032**	**235022**
	23	1.004 - 1.181	6.299	5.826	3.937	0.661 (lbs)	101	**235033**	**235023**
m	18	19.50 - 23.00	150.00	138.00	80.00	0.30 (kg)	101	**235031**	**235021**
	20	22.50 - 26.00	150.00	138.00	90.00	0.30 (kg)	101	**235032**	**235022**
	23	25.50 - 30.00	160.00	148.00	100.00	0.30 (kg)	101	**235033**	**235023**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.



Twin Cutters Same Level

	Connection	Boring Range	Twin Cutter					Part No.	
	$D_2 \mid D_1$	A	X_1	X_2	L_1	Weight	Insert Form	Insert Holder	Serrated Body
i	50 - 28	0.768 - 0.906	3.346	2.874	2.834	0.881 (lbs)	101	**235031**	**235001**
	50 - 28	0.886 - 1.024	3.543	3.070	3.031	1.102 (lbs)	101	**235032**	**235002**
	50 - 28	1.004 - 1.181	3.740	3.268	3.228	1.102 (lbs)	101	**235033**	**235003**
	63 - 36	0.768 - 0.906	3.346	2.874	2.834	1.543 (lbs)	101	**235031**	**235011**
	63 - 36	0.886 - 1.024	3.543	3.070	3.031	1.543 (lbs)	101	**235032**	**235012**
	63 - 36	1.004 - 1.181	3.740	3.268	3.228	1.843 (lbs)	101	**235033**	**235013**
m	50 - 28	19.50 - 23.00	85.00	73.00	72.00	0.40 (kg)	101	**235031**	**235001**
	50 - 28	22.50 - 26.00	90.00	78.00	77.00	0.50 (kg)	101	**235032**	**235002**
	50 - 28	25.50 - 30.00	95.00	83.00	82.00	0.50 (kg)	101	**235033**	**235003**
	63 - 36	19.50 - 23.00	85.00	73.00	72.00	0.70 (kg)	101	**235031**	**235011**
	63 - 36	22.50 - 26.00	90.00	78.00	77.00	0.70 (kg)	101	**235032**	**235012**
	63 - 36	25.50 - 30.00	95.00	83.00	82.00	0.83 (kg)	101	**235033**	**235013**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

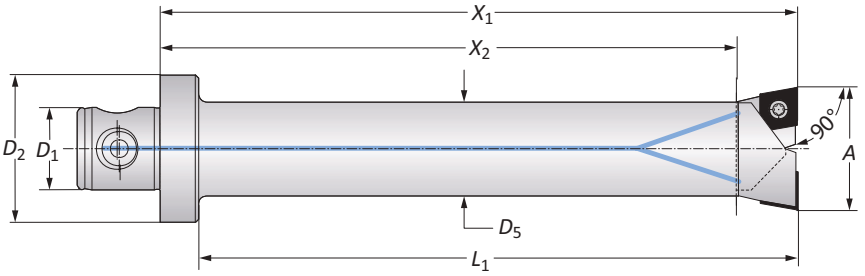
Key on B10-D: 1
B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

i = Imperial (in)
m = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Same Level

90° | 5xD | Diameter Range: 1.142" - 2.598" (29.00 mm - 66.00 mm)



	Connection	Boring Range	Twin Cutter						Part No.	
	$D_2 \mid D_1$	A	X_1	X_2	L_1	D_5	Weight	Insert Form	Insert Holder	Serrated Body
	50 - 28	1.142 - 1.457	6.102	5.551	5.590	1.023	1.984 (lbs)	103	**151001**	**148021**
	50 - 28	1.417 - 1.732	6.889	6.338	6.377	1.259	2.866 (lbs)	103	**151002**	**148022**
ⓘ	50 - 28	1.693 - 2.126	8.465	7.677	7.952	1.456	4.188 (lbs)	103	**151023**	**148023**
	50 - 28	1.693 - 2.126	8.465	7.677	7.952	1.456	4.188 (lbs)	104	**151003**	**148023**
	50 - 28	2.087 - 2.598	8.465	7.677	7.952	1.732	5.511 (lbs)	103	**151024**	**148024**
	50 - 28	2.087 - 2.598	8.465	7.677	7.952	1.732	5.511 (lbs)	104	**151004**	**148024**
	50 - 28	29.00 - 37.00	155.00	141.00	142.00	26.00	0.90 (kg)	103	**151001**	**148021**
	50 - 28	36.00 - 44.00	175.00	161.00	162.00	32.00	1.30 (kg)	103	**151002**	**148022**
ⓜ	50 - 28	43.00 - 54.00	215.00	195.00	202.00	37.00	1.90 (kg)	103	**151023**	**148023**
	50 - 28	43.00 - 54.00	215.00	195.00	202.00	37.00	1.90 (kg)	104	**151003**	**148023**
	50 - 28	53.00 - 66.00	215.00	195.00	202.00	44.00	2.50 (kg)	103	**151024**	**148024**
	50 - 28	53.00 - 66.00	215.00	195.00	202.00	44.00	2.50 (kg)	104	**151004**	**148024**

NOTE: Different lengths available upon request.
NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

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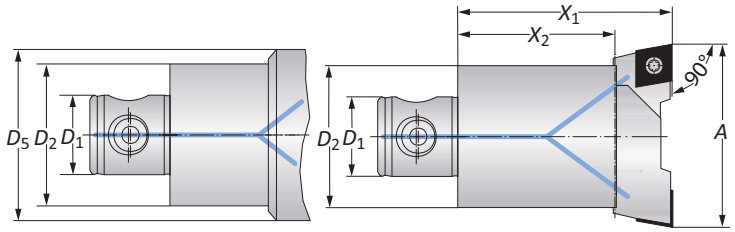
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Same Level

90° | Diameter Range: 1.142" - 4.055" (29.00 mm - 103.00 mm)



	Connection	Boring Range	Twin Cutter					Part No.	
	D_2 | D_1	A	X_1	X_2	D_5	Weight	Insert Form	Insert Holder	Serrated Body
ⓘ	25 - 14	1.142 - 1.457	2.205	1.653	–	0.441 (lbs)	103	**151001**	**148001**
	25 - 14	1.417 - 1.732	2.205	1.653	1.181	0.441 (lbs)	103	**151002**	**148002**
	32 - 18	1.417 - 1.732	2.205	1.653	1.181	0.881 (lbs)	103	**151002**	**148017**
	32 - 18	1.693 - 2.126	2.598	1.811	1.417	0.881 (lbs)	103	**151023**	**148003**
	32 - 18	1.693 - 2.126	2.598	1.811	1.417	0.881 (lbs)	104	**151003**	**148003**
	40 - 22	1.693 - 2.126	2.598	1.811	1.417	1.543 (lbs)	103	**151023**	**148018**
	40 - 22	1.693 - 2.126	2.598	1.811	1.417	1.543 (lbs)	104	**151003**	**148018**
	40 - 22	2.087 - 2.598	2.953	2.165	–	1.543 (lbs)	103	**151024**	**148004**
	40 - 22	2.087 - 2.598	2.953	2.165	–	1.543 (lbs)	104	**151004**	**148004**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.425 (lbs)	103	**151025**	**148005**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.425 (lbs)	104	**151005**	**148005**
	63 - 36	3.228 - 4.055	3.543	2.362	–	4.188 (lbs)	103	**151026**	**148006**
	63 - 36	3.228 - 4.055	3.543	2.362	–	4.188 (lbs)	104	**151086**	**148006**
	63 - 36	3.228 - 4.055	3.543	2.362	–	4.188 (lbs)	105	**151006**	**148006**
ⓜ	25 - 14	29.00 - 37.00	56.00	42.00	–	0.20 (kg)	103	**151001**	**148001**
	25 - 14	36.00 - 44.00	56.00	42.00	30.00	0.20 (kg)	103	**151002**	**148002**
	32 - 18	36.00 - 44.00	56.00	42.00	30.00	0.40 (kg)	103	**151002**	**148017**
	32 - 18	43.00 - 54.00	66.00	46.00	36.00	0.40 (kg)	103	**151023**	**148003**
	32 - 18	43.00 - 54.00	66.00	46.00	36.00	0.40 (kg)	104	**151003**	**148003**
	40 - 22	43.00 - 54.00	66.00	46.00	36.00	0.70 (kg)	103	**151023**	**148018**
	40 - 22	43.00 - 54.00	66.00	46.00	36.00	0.70 (kg)	104	**151003**	**148018**
	40 - 22	53.00 - 66.00	75.00	55.00	–	0.70 (kg)	103	**151024**	**148004**
	40 - 22	53.00 - 66.00	75.00	55.00	–	0.70 (kg)	104	**151004**	**148004**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.10 (kg)	103	**151025**	**148005**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.10 (kg)	104	**151005**	**148005**
	63 - 36	82.00 - 103.00	90.00	60.00	–	1.90 (kg)	103	**151026**	**148006**
	63 - 36	82.00 - 103.00	90.00	60.00	–	1.90 (kg)	104	**151086**	**148006**
	63 - 36	82.00 - 103.00	90.00	60.00	–	1.90 (kg)	105	**151006**	**148006**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

Key on B10-D: 1

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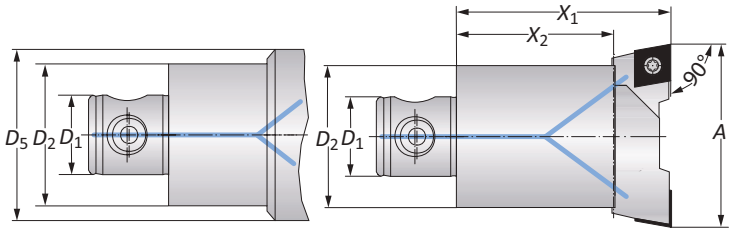
Twin Cutters Same Level

90° | Diameter Range: 3.937" - 8.071" (100.00 mm - 205.00 mm)



	Connection	Boring Range	Twin Cutter					Part No.	
	D_2 | D_1	A	X_1	X_2	D_5	Weight	Insert Form	Insert Holder	Serrated Body
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	103	**151027**	**148007**
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	104	**151087**	**148007**
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	105	**151007**	**148007**
	80 - 36	4.921 - 6.102	3.543	2.362	–	7.054 (lbs)	103	**151028**	**148007**
ⓘ	80 - 36	4.921 - 6.102	3.543	2.362	–	7.054 (lbs)	104	**151088**	**148007**
	80 - 36	4.921 - 6.102	3.543	2.362	–	7.054 (lbs)	105	**151008**	**148007**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	103	**151028**	**148009**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	104	**151088**	**148009**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	105	**151008**	**148009**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	103	**151027**	**148007**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	104	**151087**	**148007**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	105	**151007**	**148007**
	80 - 36	125.00 - 155.00	90.00	60.00	–	3.20 (kg)	103	**151028**	**148007**
ⓜ	80 - 36	125.00 - 155.00	90.00	60.00	–	3.20 (kg)	104	**151088**	**148007**
	80 - 36	125.00 - 155.00	90.00	60.00	–	3.20 (kg)	105	**151008**	**148007**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	103	**151028**	**148009**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	104	**151088**	**148009**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	105	**151008**	**148009**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

Key on B10-D: 1

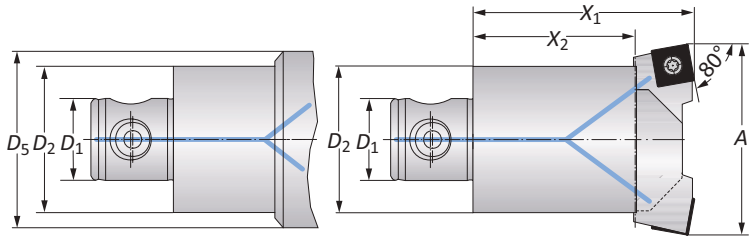
B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Same Level

80° | Diameter Range: 1.142" - 8.071" (29.00 mm - 205.00 mm)



	Connection	Boring Range	Twin Cutter					Part No.	
	D_2 | D_1	A	X_1	X_2	D_5	Weight	Insert Form	Insert Holder	Serrated Tool Body
	25 - 14	1.142 - 1.457	2.205	1.653	–	0.440 (lbs)	112	**151011**	**148001**
	25 - 14	1.417 - 1.732	2.205	1.653	1.181	0.440 (lbs)	112	**151012**	**148002**
	32 - 18	1.417 - 1.732	2.441	1.653	1.181	0.881 (lbs)	112	**151012**	**148017**
	32 - 18	1.693 - 2.126	2.598	1.811	1.417	0.440 (lbs)	113	**151013**	**148003**
	40 - 22	1.693 - 2.126	2.598	1.811	1.417	1.543 (lbs)	113	**151013**	**148018**
ⓘ	40 - 22	2.087 - 2.598	2.952	2.165	–	1.543 (lbs)	113	**151014**	**148004**
	50 - 28	2.559 - 3.268	2.952	2.165	–	2.425 (lbs)	113	**151015**	**148005**
	63 - 36	3.228 - 4.055	3.543	2.362	–	5.070 (lbs)	113	**151036**	**148006**
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	113	**151037**	**148007**
	80 - 36	4.921 - 6.102	3.543	2.362	–	7.054 (lbs)	113	**151038**	**148007**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	113	**151038**	**148009**
	25 - 14	29.00 - 37.00	56.00	42.00	–	0.20 (kg)	112	**151011**	**148001**
	25 - 14	36.00 - 44.00	56.00	42.00	30.00	0.20 (kg)	112	**151012**	**148002**
	32 - 18	36.00 - 44.00	62.00	42.00	30.00	0.40 (kg)	112	**151012**	**148017**
	32 - 18	43.00 - 54.00	66.00	46.00	36.00	0.40 (kg)	113	**151013**	**148003**
	40 - 22	43.00 - 54.00	66.00	46.00	36.00	0.70 (kg)	113	**151013**	**148018**
ⓜ	40 - 22	53.00 - 66.00	75.00	55.00	–	0.70 (kg)	113	**151014**	**148004**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.10 (kg)	113	**151015**	**148005**
	63 - 36	82.00 - 103.00	90.00	60.00	–	2.30 (kg)	113	**151036**	**148006**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	113	**151037**	**148007**
	80 - 36	125.00 - 155.00	90.00	60.00	–	3.20 (kg)	113	**151038**	**148007**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	113	**151038**	**148009**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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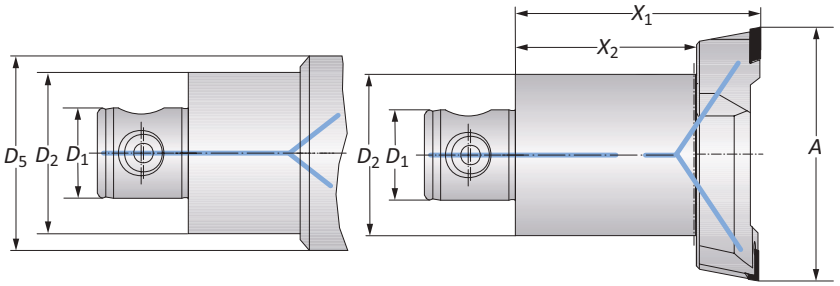
Twin Cutters Same Level Tangential Inserts

Diameter Range: 2.087" - 8.071" (53.00 mm - 205.00 mm)



	Connection	Boring Range	Twin Cutter					Part No.	
	$D_2 \mid D_1$	A	X_1	X_2	D_5	Weight	Insert Form	Insert Holder	Serrated Body
	40 - 22	2.087 - 2.598	2.953	2.165	–	1.543 (lbs)	04	**151022**	**148004**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.204 (lbs)	04	**151032**	**148005**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.204 (lbs)	05	**151043**	**148005**
ⓘ	63 - 36	3.228 - 4.055	3.543	2.362	–	4.850 (lbs)	05	**151035**	**148006**
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	05	**151009**	**148007**
	80 - 36	4.921 - 6.102	3.543	2.362	–	6.843 (lbs)	05	**151010**	**148007**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	05	**151010**	**148009**
	40 - 22	53.00 - 66.00	75.00	55.00	–	0.70 (kg)	04	**151022**	**148004**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.00 (kg)	04	**151032**	**148005**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.00 (kg)	05	**151043**	**148005**
ⓜ	63 - 36	82.00 - 103.00	90.00	60.00	–	2.20 (kg)	05	**151035**	**148006**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	05	**151009**	**148007**
	80 - 36	125.00 - 155.00	90.00	60.00	–	3.10 (kg)	05	**151010**	**148007**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	05	**151010**	**148009**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

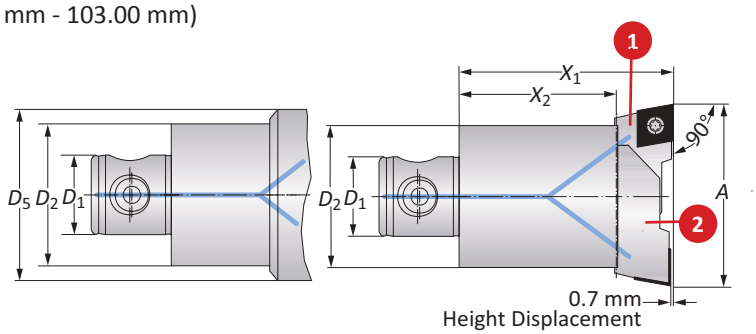
Key on B10-D: 1
B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Height Displaced

90° | Diameter Range: 1.142" - 4.055" (29.00 mm - 103.00 mm)



	Connection D_2 | D_1	Boring Range A	Twin Cutter X_1	X_2	D_5	Weight	Insert Form	Part No. 1 Insert Holder	2. Insert Holder (-0.7 mm)	Serrated Body
	25 - 14	1.142 - 1.457	2.205	1.653	–	0.440 (lbs)	103	**151001**	**151061**	**148001**
	25 - 14	1.417 - 1.732	2.205	1.653	1.181	0.440 (lbs)	103	**151002**	**151062**	**148002**
	32 - 18	1.417 - 1.732	2.205	1.653	1.181	0.881 (lbs)	103	**151002**	**151062**	**148017**
	32 - 18	1.693 - 2.126	2.598	1.811	1.417	0.881 (lbs)	104	**151003**	**151093**	**148003**
ⓘ	40 - 22	1.693 - 2.126	2.598	1.811	1.417	1.543 (lbs)	104	**151003**	**151093**	**148018**
	40 - 22	2.087 - 2.598	2.953	2.165	–	1.543 (lbs)	104	**151004**	**151094**	**148004**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.425 (lbs)	104	**151005**	**151095**	**148005**
	63 - 36	3.228 - 4.055	3.543	2.362	–	5.291 (lbs)	104	**151086**	**151090**	**148006**
	63 - 36	3.228 - 4.055	3.543	2.362	–	5.291 (lbs)	105	**151006**	**151096**	**148006**
	25 - 14	29.00 - 37.00	56.00	42.00	–	0.20 (kg)	103	**151001**	**151061**	**148001**
	25 - 14	36.00 - 44.00	56.00	42.00	30.00	0.20 (kg)	103	**151002**	**151062**	**148002**
	32 - 18	36.00 - 44.00	56.00	42.00	30.00	0.40 (kg)	103	**151002**	**151062**	**148017**
	32 - 18	43.00 - 54.00	66.00	46.00	36.00	0.40 (kg)	104	**151003**	**151093**	**148003**
ⓜ	40 - 22	43.00 - 54.00	66.00	46.00	36.00	0.70 (kg)	104	**151003**	**151093**	**148018**
	40 - 22	53.00 - 66.00	75.00	55.00	–	0.70 (kg)	104	**151004**	**151094**	**148004**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.10 (kg)	104	**151005**	**151095**	**148005**
	63 - 36	82.00 - 103.00	90.00	60.00	–	2.40 (kg)	104	**151086**	**151090**	**148006**
	63 - 36	82.00 - 103.00	90.00	60.00	–	2.40 (kg)	105	**151006**	**151096**	**148006**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

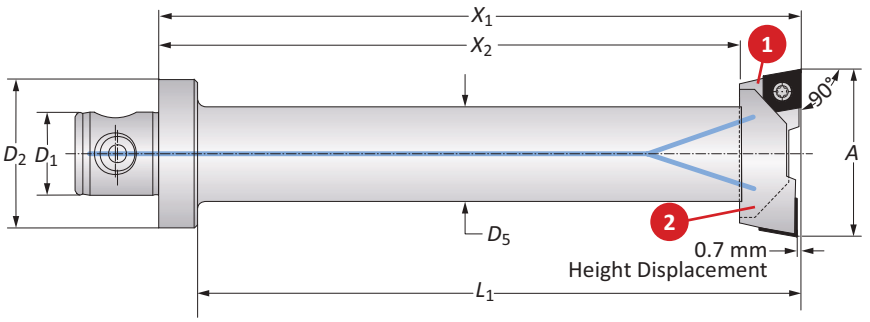
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Height Displaced

90° | 5xD | Diameter Range: 1.142" - 2.598" (29.00 mm - 66.00 mm)



	Connection	Boring Range	Twin Cutter					Insert	Part No.		
	D_2 | D_1	A	X_1	X_2	L_1	D_5	Weight	Form	1. Insert Holder	2. Insert Holder (-0.7 mm)	Serrated Body
ⓘ	50 - 28	1.142 - 1.457	6.102	5.551	5.590	1.023	1.984 (lbs)	103	**151001**	**151061**	**148021**
ⓘ	50 - 28	1.417 - 1.732	6.889	6.338	6.377	1.259	2.866 (lbs)	103	**151002**	**151062**	**148022**
ⓘ	50 - 28	1.693 - 2.126	8.465	7.677	7.952	1.456	4.188 (lbs)	104	**151003**	**151093**	**148023**
ⓘ	50 - 28	2.087 - 2.598	8.465	7.677	7.951	1.732	5.511 (lbs)	104	**151004**	**151094**	**148024**
ⓜ	50 - 28	29.00 - 37.00	155.00	141.00	142.00	26.00	0.90 (kg)	103	**151001**	**151061**	**148021**
ⓜ	50 - 28	36.00 - 44.00	175.00	161.00	162.00	32.00	1.30 (kg)	103	**151002**	**151062**	**148022**
ⓜ	50 - 28	43.00 - 54.00	215.00	195.00	202.00	37.00	1.90 (kg)	104	**151003**	**151093**	**148023**
ⓜ	50 - 28	53.00 - 66.00	215.00	195.00	202.00	44.00	2.50 (kg)	104	**151004**	**151094**	**148024**

NOTE: Different lengths available upon request.
NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

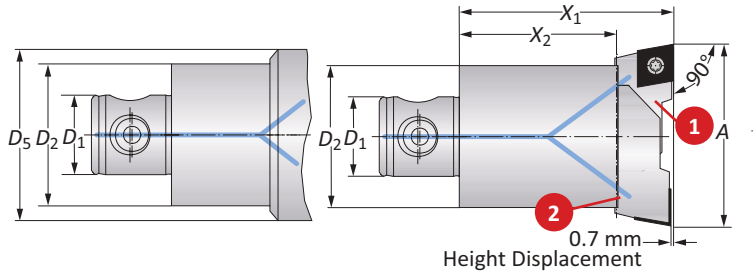
B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Height Displaced

90° | Diameter Range: 3.937" - 8.071" (100.00 mm - 205.00 mm)



	Connection	Boring Range	Twin Cutter				Insert Form	Part No.		
	D_2 | D_1	A	X_1	X_2	D_5	Weight		1. Insert Holder	2. Insert Holder (-0.7 mm)	Serrated Body
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	104	**151087**	**151091**	**148007**
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	105	**151007**	**151097**	**148007**
ⓘ	80 - 36	4.921 - 6.102	3.543	2.362	–	7.054 (lbs)	104	**151088**	**151092**	**148007**
	80 - 36	4.921 - 6.102	3.543	2.362	–	7.054 (lbs)	105	**151008**	**151098**	**148007**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	104	**151088**	**151092**	**148009**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	105	**151008**	**151098**	**148009**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	104	**151087**	**151091**	**148007**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	105	**151007**	**151097**	**148007**
ⓜ	80 - 36	125.00 - 155.00	90.00	60.00	–	3.20 (kg)	104	**151088**	**151092**	**148007**
	80 - 36	125.00 - 155.00	90.00	60.00	–	3.20 (kg)	105	**151008**	**151098**	**148007**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	104	**151088**	**151092**	**148009**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	105	**151008**	**151098**	**148009**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

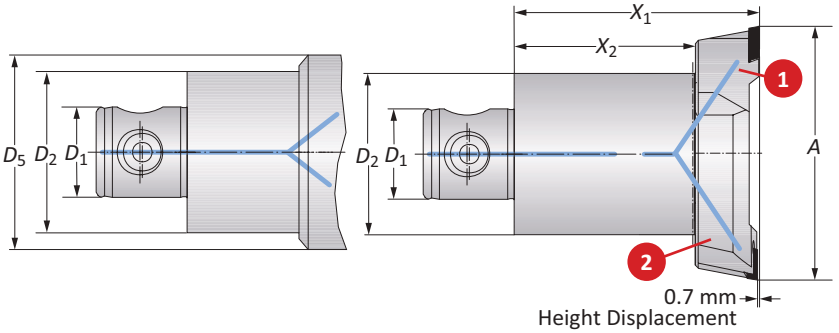
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Twin Cutters Height Displaced Tangential Inserts

Diameter Range: 2.087" - 8.071" (53.00 mm - 205.00 mm)



	Connection $D_2 \mid D_1$	Boring Range A	Twin Cutter X_1	X_2	D_5	Weight	Insert Form	Part No. 1. Insert Holder	2. Insert Holder (-0.7 mm)	Serrated Body
	40 - 22	2.087 - 2.598	2.953	2.165	–	1.543 (lbs)	04	**151022**	**268009**	**148004**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.204 (lbs)	04	**151032**	**268010**	**148005**
	50 - 28	2.559 - 3.268	2.953	2.165	–	2.204 (lbs)	05	**151043**	**268019**	**148005**
ⓘ	63 - 36	3.229 - 4.055	3.543	2.362	–	5.291 (lbs)	04	**151034**	**268020**	**148006**
	63 - 36	3.229 - 4.055	3.543	2.362	–	5.291 (lbs)	05	**151035**	**268021**	**148006**
	80 - 36	3.937 - 5.118	3.543	2.362	–	6.613 (lbs)	05	**151009**	**268022**	**148007**
	80 - 36	4.921 - 6.102	3.543	2.362	–	6.834 (lbs)	05	**151010**	**268023**	**148007**
	80 - 36	5.906 - 8.071	3.543	2.362	4.921	8.818 (lbs)	05	**151010**	**268023**	**148009**
	40 - 22	53.00 - 66.00	75.00	55.00	–	0.70 (kg)	04	**151022**	**268009**	**148004**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.00 (kg)	04	**151032**	**268010**	**148005**
	50 - 28	65.00 - 83.00	75.00	55.00	–	1.00 (kg)	05	**151043**	**268019**	**148005**
ⓜ	63 - 36	82.00 - 103.00	90.00	60.00	–	2.20 (kg)	04	**151034**	**268020**	**148006**
	63 - 36	82.00 - 103.00	90.00	60.00	–	2.20 (kg)	05	**151035**	**268021**	**148006**
	80 - 36	100.00 - 130.00	90.00	60.00	–	3.00 (kg)	05	**151009**	**268022**	**148007**
	80 - 36	125.00 - 155.00	90.00	60.00	–	3.10 (kg)	05	**151010**	**268023**	**148007**
	80 - 36	150.00 - 205.00	90.00	60.00	125.00	4.00 (kg)	05	**151010**	**268023**	**148009**

NOTE: Insert holders sold in quantities of 1, and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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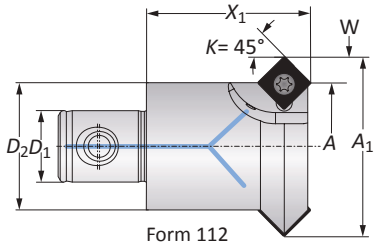
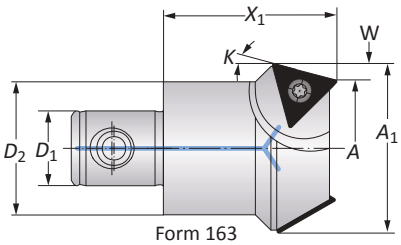
Chamfering Tools

Diameter Range: 0.787" - 1.260" (20.00 mm - 32.00 mm)



Form 112



Form 163

	Connection D_2 | D_1	Approach Angle K	Boring Range A	Cutter Diameter A_1	Chamfering Tool X_1	Chamfering Tool W	Weight	Insert Form	Number of Inserts	Part No.
	25 - 14	15°	0.984	1.299	1.220	0.157	0.330 (lbs)	163	2	**201087**
	25 - 14	45°	0.787	1.299	1.220	0.255	0.330 (lbs)	112	2	**201082**
ⓘ	32 - 18	15°	1.260	1.574	1.614	0.157	0.440 (lbs)	163	2	**201088**
	32 - 18	30°	0.984	1.614	1.614	0.314	0.440 (lbs)	163	2	**201089**
	32 - 18	45°	1.260	1.771	1.614	0.255	0.440 (lbs)	112	3	**201083**
	25 - 14	15°	25.00	33.00	31.00	4.00	0.15 (kg)	163	2	**201087**
	25 - 14	45°	20.00	33.00	31.00	6.50	0.15 (kg)	112	2	**201082**
ⓜ	32 - 18	15°	32.00	40.00	41.00	4.00	0.20 (kg)	163	2	**201088**
	32 - 18	30°	25.00	41.00	41.00	8.00	0.20 (kg)	163	2	**201089**
	32 - 18	45°	32.00	45.00	41.00	6.50	0.20 (kg)	112	3	**201083**

NOTE: K 45° for front and reverse side chamfering.
NOTE: Inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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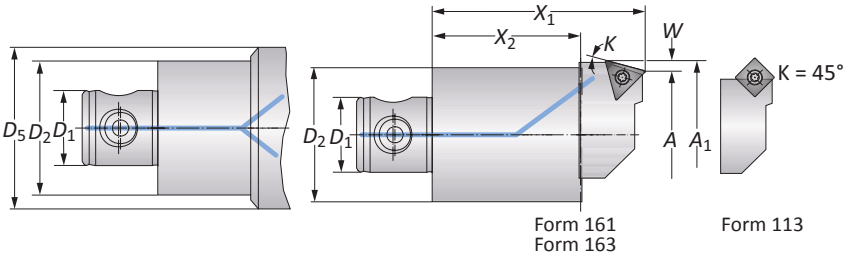
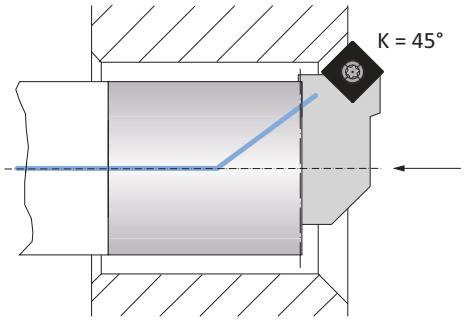
Chamfering Tools

Imperial | Diameter Range: 0.748" - 2.795"





	Connection $D_2 \mid D_1$	Approach Angle K	Boring Range A	Chamfering Range A_1	Chamfering Tool X_1	X_2	D_5	W	Weight	Insert Form	Part No. Insert Holder	Serrated Body
	25 - 14	15°	0.945 - 1.260	1.141 - 1.457	2.362	1.653	–	0.098	0.440 (lbs)	161	**201057**	**148001**
	25 - 14	15°	1.220 - 1.535	1.417 - 1.732	2.362	1.653	1.181	0.098	0.440 (lbs)	161	**201058**	**148002**
	25 - 14	20°	0.866 - 1.181	1.141 - 1.456	2.362	1.653	–	0.138	0.440 (lbs)	161	**201017**	**148001**
	25 - 14	20°	1.142 - 1.457	1.417 - 1.732	2.362	1.653	1.181	0.138	0.440 (lbs)	161	**201018**	**148002**
	25 - 14	30°	0.787 - 1.102	1.141 - 1.456	2.362	1.653	–	0.177	0.440 (lbs)	161	**201067**	**148001**
	25 - 14	30°	1.063 - 1.378	1.417 - 1.732	2.362	1.653	1.181	0.177	0.440 (lbs)	161	**201068**	**148002**
	25 - 14	45°	0.748 - 1.063	1.299 - 1.614	2.283	1.653	–	0.197	0.440 (lbs)	161	**201003***	**148001**
	25 - 14	45°	1.024 - 1.339	1.496 - 1.811	2.283	1.653	–	0.197	0.440 (lbs)	112	**201004**	**148001**
	25 - 14	45°	1.220 - 1.535	1.692 - 2.007	2.362	1.653	1.181	0.236	0.440 (lbs)	112	**201007**	**148002**
	32 - 18	15°	1.220 - 1.535	1.417 - 1.732	2.362	1.653	1.181	0.098	0.440 (lbs)	161	**201058**	**148017**
	32 - 18	20°	1.142 - 1.457	1.417 - 1.732	2.362	1.653	1.181	0.138	0.440 (lbs)	161	**201018**	**148017**
	32 - 18	30°	1.063 - 1.378	1.417 - 1.732	2.362	1.653	1.181	0.177	0.440 (lbs)	161	**201068**	**148017**
ⓘ	32 - 18	45°	1.220 - 1.535	1.692 - 2.007	2.362	1.653	1.181	0.236	0.440 (lbs)	112	**201007**	**148017**
	32 - 18	15°	1.378 - 1.811	1.692 - 2.125	2.795	1.811	1.417	0.157	0.881 (lbs)	163	**201059**	**148003**
	32 - 18	20°	1.299 - 1.732	1.692 - 2.125	2.795	1.811	1.417	0.197	0.881 (lbs)	163	**201019**	**148003**
	32 - 18	30°	1.102 - 1.535	1.692 - 2.125	2.795	1.811	1.417	0.297	0.881 (lbs)	163	**201069**	**148003**
	32 - 18	45°	1.378 - 1.811	1.968 - 2.401	2.598	1.811	1.417	0.295	0.881 (lbs)	113	**201008**	**148003**
	40 - 22	15°	1.378 - 1.811	1.692 - 2.125	2.795	1.811	1.417	0.157	0.881 (lbs)	163	**201059**	**148018**
	40 - 22	20°	1.299 - 1.732	1.692 - 2.125	2.795	1.811	1.417	0.197	0.881 (lbs)	163	**201019**	**148018**
	40 - 22	30°	1.102 - 1.535	1.692 - 2.125	2.795	1.811	1.417	0.295	0.881 (lbs)	163	**201069**	**148018**
	40 - 22	45°	1.378 - 1.811	1.968 - 2.401	2.598	1.811	1.417	0.295	0.881 (lbs)	113	**201008**	**148018**
	40 - 22	15°	1.457 - 1.969	1.771 - 2.283	3.150	2.165	–	0.157	1.543 (lbs)	163	**201060**	**148004**
	40 - 22	20°	1.457 - 1.969	1.850 - 2.362	3.150	2.165	–	0.197	1.543 (lbs)	163	**201020**	**148004**
	40 - 22	30°	1.457 - 1.969	2.047 - 2.559	3.150	2.165	–	0.295	1.543 (lbs)	163	**201070**	**148004**
	40 - 22	45°	1.963 - 2.205	2.283 - 2.795	3.150	2.165	–	0.295	1.543 (lbs)	113	**201009**	**148004**

*Insert holder cannot be used for reverse machining.
NOTE: K 45° for front and reverse side chamfering above Ø 1.220".
NOTE: Insert holders and inserts sold separately.

Key on B10-D: 1
B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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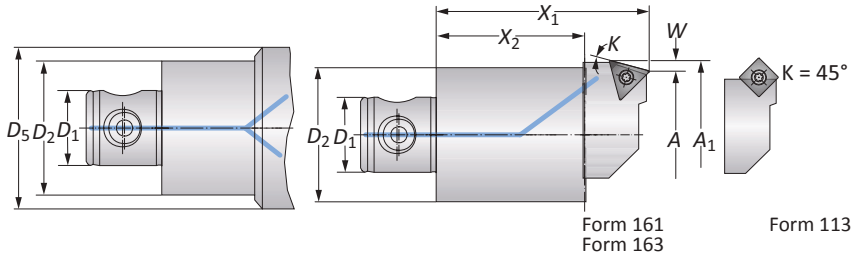
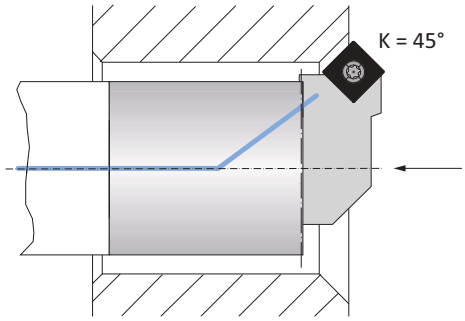
Chamfering Tools

Metric | Diameter Range: (19.00 mm - 71.00 mm)





	Connection	Approach Angle	Boring Range	Chamfering Range	Chamfering Tool				Weight	Insert Form	Part No.	
	$D_2 \mid D_1$	K	A	A_1	X_1	X_2	D_5	W			Insert Holder	Serrated Body
	25 - 14	15°	24.00 - 32.00	29.00 - 37.00	60.00	42.00	–	2.50	0.20 (kg)	161	**201057**	**148001**
	25 - 14	15°	31.00 - 39.00	36.00 - 44.00	60.00	42.00	30.00	2.50	0.20 (kg)	161	**201058**	**148002**
	25 - 14	20°	22.00 - 30.00	29.00 - 37.00	60.00	42.00	–	3.50	0.20 (kg)	161	**201017**	**148001**
	25 - 14	20°	29.00 - 37.00	36.00 - 44.00	60.00	42.00	30.00	3.50	0.20 (kg)	161	**201018**	**148002**
	25 - 14	30°	20.00 - 28.00	29.00 - 37.00	60.00	42.00	–	4.50	0.20 (kg)	161	**201067**	**148001**
	25 - 14	30°	27.00 - 35.00	36.00 - 44.00	60.00	42.00	30.00	4.50	0.20 (kg)	161	**201068**	**148002**
	25 - 14	45°	19.00 - 27.00	33.00 - 41.00	58.00	42.00	–	5.00	0.20 (kg)	161	**201003***	**148001**
	25 - 14	45°	26.00 - 34.00	38.00 - 46.00	58.00	42.00	–	5.00	0.20 (kg)	112	**201004**	**148001**
	25 - 14	45°	31.00 - 39.00	43.00 - 51.00	60.00	42.00	30.00	6.00	0.20 (kg)	112	**201007**	**148002**
	32 - 18	15°	31.00 - 39.00	36.00 - 44.00	60.00	42.00	30.00	2.50	0.20 (kg)	161	**201058**	**148017**
	32 - 18	20°	29.00 - 37.00	36.00 - 44.00	60.00	42.00	30.00	3.50	0.20 (kg)	161	**201018**	**148017**
	32 - 18	30°	27.00 - 35.00	36.00 - 44.00	60.00	42.00	30.00	4.50	0.20 (kg)	161	**201068**	**148017**
ⓜ	32 - 18	45°	31.00 - 39.00	43.00 - 51.00	60.00	42.00	30.00	6.00	0.20 (kg)	112	**201007**	**148017**
	32 - 18	15°	35.00 - 46.00	43.00 - 54.00	71.00	46.00	36.00	4.00	0.40 (kg)	163	**201059**	**148003**
	32 - 18	20°	33.00 - 44.00	43.00 - 54.00	71.00	46.00	36.00	5.00	0.40 (kg)	163	**201019**	**148003**
	32 - 18	30°	28.00 - 39.00	43.00 - 54.00	71.00	46.00	36.00	7.50	0.40 (kg)	163	**201069**	**148003**
	32 - 18	45°	35.00 - 46.00	50.00 - 61.00	66.00	46.00	36.00	7.50	0.40 (kg)	113	**201008**	**148003**
	40 - 22	15°	35.00 - 46.00	43.00 - 54.00	71.00	46.00	36.00	4.00	0.40 (kg)	163	**201059**	**148018**
	40 - 22	20°	33.00 - 44.00	43.00 - 54.00	71.00	46.00	36.00	5.00	0.40 (kg)	163	**201019**	**148018**
	40 - 22	30°	28.00 - 39.00	43.00 - 54.00	71.00	46.00	36.00	7.50	0.40 (kg)	163	**201069**	**148018**
	40 - 22	45°	35.00 - 46.00	50.00 - 61.00	66.00	46.00	36.00	7.50	0.40 (kg)	113	**201008**	**148018**
	40 - 22	15°	37.00 - 50.00	45.00 - 58.00	80.00	55.00	–	4.00	0.70 (kg)	163	**201060**	**148004**
	40 - 22	20°	37.00 - 50.00	47.00 - 60.00	80.00	55.00	–	5.00	0.70 (kg)	163	**201020**	**148004**
	40 - 22	30°	37.00 - 50.00	52.00 - 65.00	80.00	55.00	–	7.50	0.70 (kg)	163	**201070**	**148004**
	40 - 22	45°	43.00 - 56.00	58.00 - 71.00	80.00	55.00	–	7.50	0.70 (kg)	113	**201009**	**148004**

*Insert holder cannot be used for reverse machining.
NOTE: K 45° for front and reverse side chamfering above Ø 31.00 mm.
NOTE: Insert holders and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii
Key on B10-D:1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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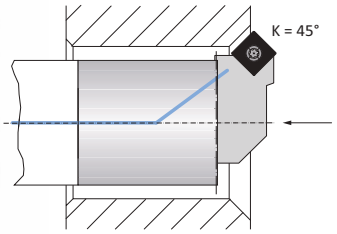
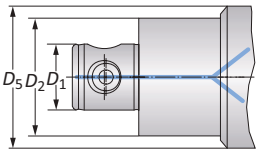
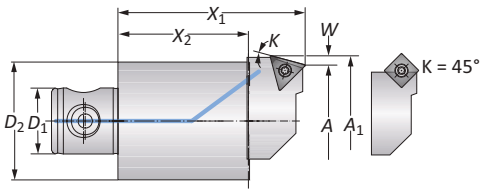
Chamfering Tools

Diameter Range: 1.969" - 8.504" (50.00 mm - 216.00 mm)







Form 161
Form 163

Form 113

	Connection	Approach Angle	Boring Range	Chamfering Range	Chamfering Tool						Part No.	
	D_2 | D_1	K	A	A_1	X_1	X_2	D_5	W	Weight	Insert Form	Insert Holder	Serrated Body
	50 - 28	15°	1.969 - 2.677	2.283 - 2.992	3.150	2.165	–	0.157	2.204 (lbs)	163	**201061**	**148005**
	50 - 28	20°	1.969 - 2.677	2.362 - 3.070	3.150	2.165	–	0.197	2.204 (lbs)	163	**201021**	**148005**
	50 - 28	30°	1.969 - 2.677	2.559 - 3.267	3.150	2.165	–	0.197	2.204 (lbs)	163	**201071**	**148005**
	50 - 28	45°	2.165 - 2.874	2.755 - 3.464	3.150	2.165	–	0.295	2.204 (lbs)	113	**201010**	**148005**
	63 - 36	15°	2.677 - 3.504	2.992 - 3.818	3.543	2.362	–	0.157	4.188 (lbs)	163	**201062**	**148006**
	63 - 36	20°	2.677 - 3.504	3.070 - 3.897	3.543	2.362	–	0.197	4.188 (lbs)	163	**201022**	**148006**
	63 - 36	30°	2.677 - 3.504	3.268 - 4.094	3.543	2.362	–	0.295	4.188 (lbs)	163	**201072**	**148006**
	63 - 36	45°	2.835 - 3.661	3.425 - 4.251	3.543	2.362	–	0.295	4.188 (lbs)	113	**201011**	**148006**
	80 - 36	15°	3.504 - 4.685	3.818 - 5.000	3.543	2.362	–	0.157	5.732 (lbs)	163	**201063**	**148007**
ⓘ	80 - 36	15°	4.685 - 5.866	5.000 - 6.259	3.543	2.362	–	0.157	5.952 (lbs)	163	**201064**	**148007**
	80 - 36	15°	5.669 - 7.835	5.984 - 8.149	3.543	2.362	4.921	0.157	7.936 (lbs)	163	**201064**	**148009**
	80 - 36	20°	3.504 - 4.685	3.989 - 5.078	3.543	2.362	–	0.197	5.732 (lbs)	163	**201023**	**148007**
	80 - 36	20°	4.685 - 5.866	5.078 - 6.259	3.543	2.362	–	0.197	5.952 (lbs)	163	**201024**	**148007**
	80 - 36	20°	5.669 - 7.835	6.062 - 8.228	3.543	2.362	4.921	0.197	7.936 (lbs)	163	**201024**	**148009**
	80 - 36	30°	3.504 - 4.685	4.094 - 5.275	3.543	2.362	–	0.295	5.732 (lbs)	163	**201073**	**148007**
	80 - 36	30°	4.685 - 5.866	5.275 - 6.456	3.543	2.362	–	0.295	5.952 (lbs)	163	**201074**	**148007**
	80 - 36	30°	5.669 - 7.835	6.259 - 8.425	3.543	2.362	4.921	0.295	7.936 (lbs)	163	**201074**	**148009**
	80 - 36	45°	3.622 - 4.803	4.212 - 5.393	3.543	2.362	–	0.295	5.732 (lbs)	113	**201012**	**148007**
	80 - 36	45°	4.764 - 5.945	5.354 - 6.535	3.543	2.362	–	0.295	5.952 (lbs)	113	**201013**	**148007**
	80 - 36	45°	5.748 - 7.913	6.338 - 8.504	3.543	2.362	4.921	0.295	7.936 (lbs)	113	**201013**	**148009**
	50 - 28	15°	50.00 - 68.00	58.00 - 76.00	80.00	55.00	–	4.00	1.00 (kg)	163	**201061**	**148005**
	50 - 28	20°	50.00 - 68.00	60.00 - 78.00	80.00	55.00	–	5.00	1.00 (kg)	163	**201021**	**148005**
	50 - 28	30°	50.00 - 68.00	65.00 - 83.00	80.00	55.00	–	7.50	1.00 (kg)	163	**201071**	**148005**
	50 - 28	45°	55.00 - 73.00	70.00 - 88.00	80.00	55.00	–	7.50	1.00 (kg)	113	**201010**	**148005**
	63 - 36	15°	68.00 - 89.00	76.00 - 97.00	90.00	60.00	–	4.00	1.90 (kg)	163	**201062**	**148006**
	63 - 36	20°	68.00 - 89.00	78.00 - 99.00	90.00	60.00	–	5.00	1.90 (kg)	163	**201022**	**148006**
	63 - 36	30°	68.00 - 89.00	83.00 - 104.00	90.00	60.00	–	7.50	1.90 (kg)	163	**201072**	**148006**
	63 - 36	45°	72.00 - 93.00	87.00 - 108.00	90.00	60.00	–	7.50	1.90 (kg)	113	**201011**	**148006**
	80 - 36	15°	89.00 - 119.00	97.00 - 127.00	90.00	60.00	–	4.00	2.60 (kg)	163	**201063**	**148007**
ⓜ	80 - 36	15°	119.00 - 149.00	127.00 - 159.00	90.00	60.00	–	4.00	2.70 (kg)	163	**201064**	**148007**
	80 - 36	15°	144.00 - 199.00	152.00 - 207.00	90.00	60.00	125.00	4.00	3.60 (kg)	163	**201064**	**148009**
	80 - 36	20°	89.00 - 119.00	99.00 - 129.00	90.00	60.00	–	5.00	2.60 (kg)	163	**201023**	**148007**
	80 - 36	20°	119.00 - 149.00	129.00 - 159.00	90.00	60.00	–	5.00	2.70 (kg)	163	**201024**	**148007**
	80 - 36	20°	144.00 - 199.00	154.00 - 209.00	90.00	60.00	125.00	5.00	3.60 (kg)	163	**201024**	**148009**
	80 - 36	30°	89.00 - 119.00	104.00 - 134.00	90.00	60.00	–	7.50	2.60 (kg)	163	**201073**	**148007**
	80 - 36	30°	119.00 - 149.00	134.00 - 164.00	90.00	60.00	–	7.50	2.70 (kg)	163	**201074**	**148007**
	80 - 36	30°	144.00 - 199.00	159.00 - 214.00	90.00	60.00	125.00	7.50	3.60 (kg)	163	**201074**	**148009**
	80 - 36	45°	92.00 - 122.00	107.00 - 137.00	90.00	60.00	–	7.50	2.60 (kg)	113	**201012**	**148007**
	80 - 36	45°	121.00 - 151.00	136.00 - 166.00	90.00	60.00	–	7.50	2.70 (kg)	113	**201013**	**148007**
	80 - 36	45°	146.00 - 201.00	161.00 - 216.00	90.00	60.00	125.00	7.50	3.60 (kg)	113	**201013**	**148009**

NOTE: K 45° = front and reverse side chamfering.
NOTE: Insert holders and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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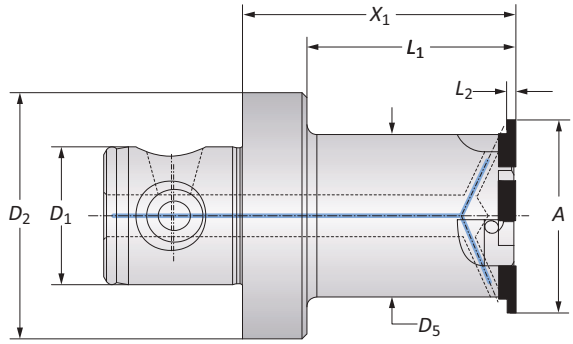
Grooving Tools for Circular Milling

Diameter Range: Ø >0.787" (20.00 mm)



	Connection D_2 | D_1	Cutter Diameter A	Grooving Tool X_1	L_1	D_5	Groove Width L_2	Groove Depth	Number of Inserts	Weight	Insert Form	Part No.
	50 - 28	0.787	2.165	1.575	0.669	max 0.093	max 0.059	2	0.881 (lbs)	89	**143051**
	50 - 28	0.787	3.740	3.228	0.669	max 0.093	max 0.059	2	0.881 (lbs)	89	**143052**
	50 - 28	1.535	2.165	1.654	1.299	max 0.133	max 0.098	4	1.322 (lbs)	90	**143053**
ⓘ	32 - 18	1.535	1.575	1.575	1.299	max 0.133	max 0.098	4	0.661 (lbs)	90	**143054**
	50 - 28	1.929	2.165	1.575	1.692	max 0.133	max 0.098	5	1.543 (lbs)	90	**143055**
	40 - 22	1.929	1.575	1.575	1.692	max 0.133	max 0.098	5	1.102 (lbs)	90	**143056**
	50 - 28	2.480	1.575	1.575	2.086	max 0.231	max 0.185	6	1.543 (lbs)	91	**143057**
	63 - 36	3.110	1.575	1.575	2.716	max 0.231	max 0.185	8	2.645 (lbs)	91	**143058**
	50 - 28	20.00	55.00	40.00	17.00	max 2.37	max 1.50	2	0.40 (kg)	89	**143051**
	50 - 28	20.00	95.00	82.00	17.00	max 2.37	max 1.50	2	0.40 (kg)	89	**143052**
	50 - 28	39.00	55.00	42.00	33.00	max 3.37	max 2.50	4	0.60 (kg)	90	**143053**
ⓜ	32 - 18	39.00	40.00	40.00	33.00	max 3.37	max 2.50	4	0.30 (kg)	90	**143054**
	50 - 28	49.00	55.00	40.00	43.00	max 3.37	max 2.50	5	0.70 (kg)	90	**143055**
	40 - 22	49.00	40.00	40.00	43.00	max 3.37	max 2.50	5	0.50 (kg)	90	**143056**
	50 - 28	63.00	40.00	40.00	53.00	max 5.87	max 4.70	6	0.70 (kg)	91	**143057**
	63 - 36	79.00	40.00	40.00	69.00	max 5.87	max 4.70	8	1.20 (kg)	91	**143058**

NOTE: Different lengths available upon request.
NOTE: Inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

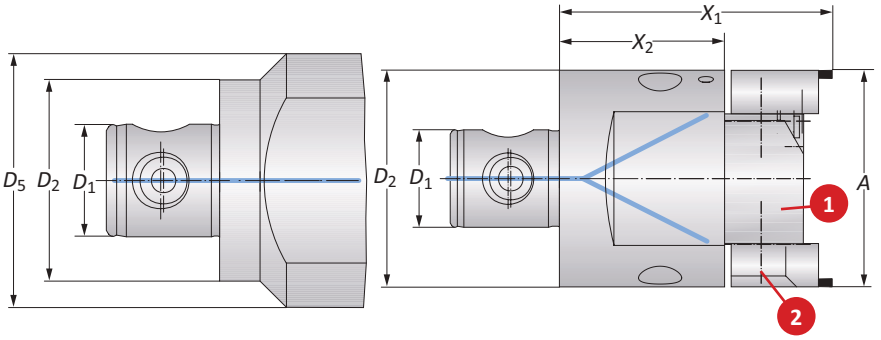
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Axial Grooving Tools

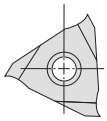
Diameter Range: 0.787" - 8.071" (20.00 mm - 205.00 mm)



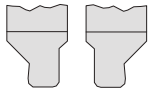
	Connection	Boring Range	Grooving Tool				Part No.			
	$D_2 \mid D_1$	A	X_1	X_2	D_5	Weight	1. Support Block	Insert Form	2. Insert Holder	Serrated Tool Body
ⓘ	50 - 28	0.787 - 2.283	3.268	2.165	2.480	2.866 (lbs)	–	304	226030	148010
	80 - 36	2.244 - 3.307	3.937	2.362	–	5.732 (lbs)	226011	304	226031	148007
	80 - 36	3.228 - 6.102	3.937	2.362	4.921	8.157 (lbs)	226012	304	226031	148009
	80 - 36	6.024 - 8.071	3.937	2.362	4.921	8.157 (lbs)	226013	304	226031	148009
ⓜ	50 - 28	20.00 - 58.00	83.00	55.00	63.00	1.30 (kg)	–	304	226030	148010
	80 - 36	57.00 - 84.00	100.00	60.00	–	2.60 (kg)	226011	304	226031	148007
	80 - 36	82.00 - 155.00	100.00	60.00	125.00	3.70 (kg)	226012	304	226031	148009
	80 - 36	153.00 - 205.00	100.00	60.00	125.00	3.70 (kg)	226013	304	226031	148009

NOTE: Groove width is 0.039" - 0.276" (1.00 mm - 7.00 mm). (With Twin Cutter and diameter offset up to 12.00 mm is possible.)
Groove depth is 0.039" - 0.236" (1.00 mm - 6.00 mm).
NOTE: Support block with machining diameters smaller than 4.842" (123.00 mm) can only be secured with one screw.
NOTE: Insert holders, support blocks, and inserts sold separately.

Examples of recessing replaceable inserts:


Other insert types available upon request.

Two-Sided Cutting Form


Single-Sided Cutting Form (Right / Left)

Two-Sided Angle Cutting

With Corner Radius

Full Radius

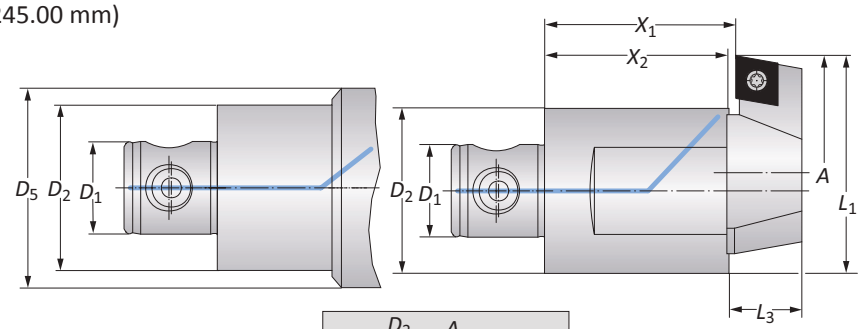
B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii
Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

Reverse Machining Tools

Diameter Range: 1.142" - 9.646" (29.00 mm - 245.00 mm)



$$L_1 = \frac{D_2}{2} + \frac{A}{2} + 0.5 \text{ mm}$$

	Connection	Boring Range	Reverse Machining						Part No.	
	D_2 | D_1	A	X_1	X_2	L_3	D_5	Weight	Insert Form	Insert Holder	Serrated Tool Body
	25 - 14	1.142 - 1.457	1.575	1.535	0.551	–	0.440 (lbs)	103	**251001**	**148011**
	25 - 14	1.339 - 1.654	1.575	1.535	0.551	–	0.440 (lbs)	103	**251002**	**148011**
	25 - 14	1.417 - 1.732	1.575	1.535	0.551	–	0.440 (lbs)	103	**251002**	**148012**
	25 - 14	1.732 - 2.047	1.575	1.535	0.708	–	0.440 (lbs)	104	**251003**	**148012**
	32 - 18	1.693 - 2.126	1.575	1.535	0.708	–	0.661 (lbs)	104	**251003**	**148013**
	32 - 18	2.165 - 2.598	1.575	1.535	0.708	–	0.881 (lbs)	104	**251004**	**148013**
	40 - 22	2.087 - 2.835	1.575	1.535	0.708	–	1.102 (lbs)	104	**251004**	**148014**
ⓘ	40 - 22	2.598 - 3.346	1.575	1.535	0.708	–	1.102 (lbs)	104	**251005**	**148014**
	50 - 28	2.756 - 3.740	2.205	2.165	0.866	–	2.425 (lbs)	104	**251006**	**148015**
	50 - 28	3.622 - 4.606	2.205	2.165	0.866	–	2.866 (lbs)	104	**251007**	**148015**
	63 - 36	3.622 - 4.803	2.205	2.165	0.866	–	3.747 (lbs)	104	**251007**	**148016**
	80 - 36	4.724 - 5.906	2.441	2.362	1.023	–	5.952 (lbs)	104	**251008**	**148007**
	80 - 36	6.535 - 7.717	2.441	2.362	1.023	–	6.393 (lbs)	104	**251009**	**148007**
	80 - 36	5.709 - 7.874	2.441	2.362	1.023	4.921	7.936 (lbs)	104	**251008**	**148009**
	80 - 36	7.480 - 9.646	2.441	2.362	1.023	4.921	8.157 (lbs)	104	**251009**	**148009**
	25 - 14	29.00 - 37.00	40.00	39.00	14.00	–	0.20 (kg)	103	**251001**	**148011**
	25 - 14	34.00 - 42.00	40.00	39.00	14.00	–	0.20 (kg)	103	**251002**	**148011**
	25 - 14	36.00 - 44.00	40.00	39.00	14.00	–	0.20 (kg)	103	**251002**	**148012**
	25 - 14	44.00 - 52.00	40.00	39.00	18.00	–	0.20 (kg)	104	**251003**	**148012**
	32 - 18	43.00 - 54.00	40.00	39.00	18.00	–	0.30 (kg)	104	**251003**	**148013**
	32 - 18	55.00 - 66.00	40.00	39.00	18.00	–	0.40 (kg)	104	**251004**	**148013**
	40 - 22	53.00 - 72.00	40.00	39.00	18.00	–	0.50 (kg)	104	**251004**	**148014**
ⓜ	40 - 22	66.00 - 85.00	40.00	39.00	18.00	–	0.50 (kg)	104	**251005**	**148014**
	50 - 28	70.00 - 95.00	56.00	55.00	22.00	–	1.10 (kg)	104	**251006**	**148015**
	50 - 28	92.00 - 117.00	56.00	55.00	22.00	–	1.30 (kg)	104	**251007**	**148015**
	63 - 36	92.00 - 122.00	56.00	55.00	22.00	–	1.70 (kg)	104	**251007**	**148016**
	80 - 36	120.00 - 150.00	62.00	60.00	26.00	–	2.70 (kg)	104	**251008**	**148007**
	80 - 36	166.00 - 196.00	62.00	60.00	26.00	–	2.90 (kg)	104	**251009**	**148007**
	80 - 36	145.00 - 200.00	62.00	60.00	26.00	125.00	3.60 (kg)	104	**251008**	**148009**
	80 - 36	190.00 - 245.00	62.00	60.00	26.00	125.00	3.70 (kg)	104	**251009**	**148009**

NOTE: Only use inserts with chip grooves all around.
NOTE: Insert holders and inserts sold separately.

B10-M: 12-19 | B10-D: 24 | B10-F | B10-H | B10: vi-vii

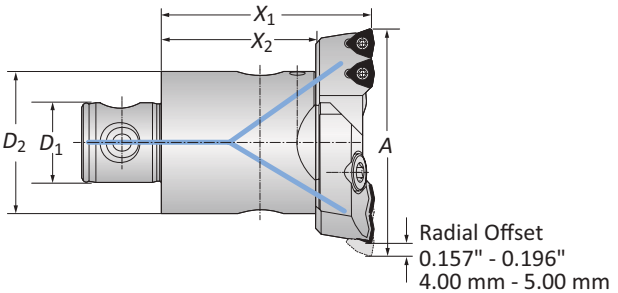
Key on B10-D: 1

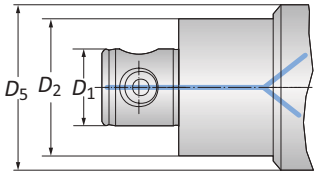
ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

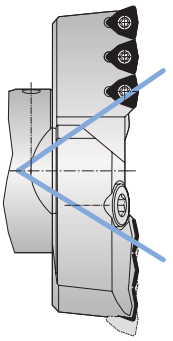
IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: **7611** | *email:* **appeng@alliedmachine.com**

VolCut Insert Holders

Diameter Range: 2.559" - 128.150" (65.00 mm - 3255.00 mm)







Serrated Bodies with VolCut Insert Holders

	Connection	Boring Range		Serrated Body				Number of Inserts	Insert Form	Part No.	
	D_2 | D_1	A	A_{min}**	X_1	X_2	D_5	Weight			VolCut Insert Holder	Serrated Body
ⓘ	50 - 28	2.559 - 3.268	2.559 - 2.756	2.913	2.165	–	2.425 (lbs)	2	464	**151019**	**148005**
	63 - 36	3.228 - 4.055	3.228 - 3.425	3.504	2.362	–	4.850 (lbs)	3	464	**151039**	**148006**
	80 - 36	3.937 - 5.118	3.937 - 4.134	3.504	2.362	–	6.613 (lbs)	3	464	**151059**	**148007**
	80 - 36	4.921 - 6.102	4.921 - 5.118	3.504	2.362	–	7.054 (lbs)	3	464	**151069**	**148007**
	80 - 36	5.906 - 8.071	5.906 - 6.102	3.504	2.362	4.921	11.243 (lbs)	3	464	**151069**	**148009**
	⚠ D60	7.874 - 128.150	–	–	–	–	–	3	464	**149030**	*
ⓜ	50 - 28	65.00 - 83.00	65.00 - 70.00	74.00	55.00	–	1.10 (kg)	2	464	**151019**	**148005**
	63 - 36	82.00 - 103.00	82.00 - 87.00	89.00	60.00	–	2.20 (kg)	3	464	**151039**	**148006**
	80 - 36	100.00 - 130.00	100.00 - 105.00	89.00	60.00	–	3.00 (kg)	3	464	**151059**	**148007**
	80 - 36	125.00 - 155.00	125.00 - 130.00	89.00	60.00	–	3.20 (kg)	3	464	**151069**	**148007**
	80 - 36	150.00 - 205.00	150.00 - 155.00	89.00	60.00	125.00	5.10 (kg)	3	464	**151069**	**148009**
	⚠ D60	200.00 - 3255.00	–	–	–	–	–	3	464	**149030**	*

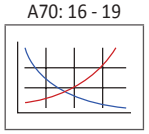
NOTE: Inserts, insert holders, and serrated body are sold separately.
*For large diameter serrated slides, please contact Application Eng. (330.343.4283 ext: 7611) and see section B10-G in the Wohlhaupter® Product Catalog.
**For smaller diameters, both cartridges must be set to the same diameter. Only the outside insert on each cartridge can be engaged in the material.

IC Inserts

Carbide Grade	Geometry	Part No. AM300®	WSP-Screw
P35 (C5)	Standard	**OP-05T308-P**	IS-10-1
K35 (C1)	Standard	**OP-05T308-1P**	IS-10-1
K20 (C2)	Standard	**OP-05T308-2P**	IS-10-1
P35 (C5)	High Rake	**OP-05T308-PHR**	IS-10-1

NOTE: See section A70 in the Allied Master Product Catalog for recommended cutting data, cutting materials, and geometries.

A70: 16 - 19



B10: vi-vii

Key on B10-D: 1

ⓘ = Imperial (in)
ⓜ = Metric (mm)
Inserts sold separately

⚠ **WARNING** **For large diameter boring with VolCut insert holders please:**
- Contact our Application Engineering department before purchasing (330.343.4283 *ext:* **7611** | *email:* **appeng@alliedmachine.com)**
- Refer to section B10-G in the Wohlhaupter® MultiBore® System Tools Catalog.

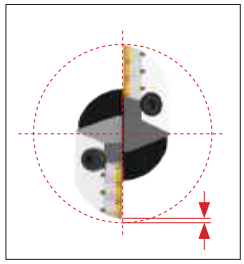
VolCut Technical Information

Setup Instructions | Minimum Pilot Calculation

Step 1:
Loosen the mounting screws on both cartridges.

Step 2:
Set one cartridge to the finish diameter by tightening the adjustment screw against the adjustment pin.

Step 3:
Tighten the mounting screws on the cartridge to 15-19 Nm (11-14 ft-lbf).



Step 4:
Set the opposing cartridge with 0.157" - 0.196" (4 mm - 5 mm) radial offset inward by tightening the adjustment screw against the adjustment pin (optimum situation for each insert to remove equal material).

Step 5:
Tighten the mounting screws on the cartridge to 15-19 Nm (11-14 ft-lbf).

Note: Drilling systems with OP inserts are used as single cutters. The replaceable inserts are mounted offset in diameter. Please review the assembly instructions.

Minimum Pilot Calculation

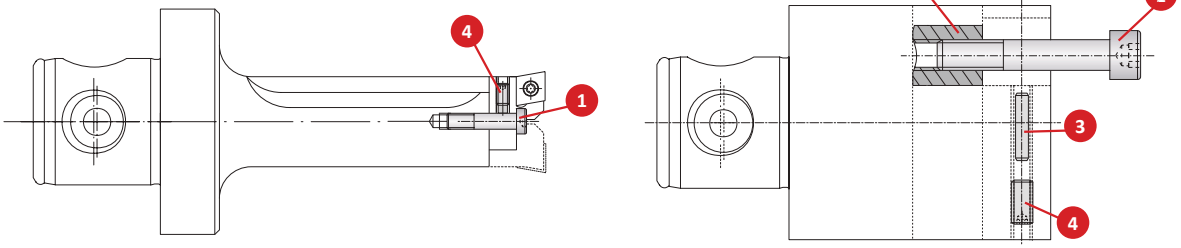
Calculation: Finish Diameter - Opening Range = Minimum Pilot Hole Diameter

Insert Holder	Diameter Range	Opening Range
151019	2.559" - 2.756" (65.00 mm - 70.00 mm)	0.600" (15.24 mm)
	2.756" - 3.268" (70.00 mm - 83.00 mm)	1.880" (47.75 mm)
151039	3.228" - 3.425" (82.00 mm - 87.00 mm)	0.600" (15.24 mm)
	3.425" - 4.055" (87.00 mm - 103.00 mm)	2.680" (68.07 mm)
151059	3.937" - 4.134" (100.00 mm - 105.00 mm)	0.600" (15.24 mm)
	4.134" - 5.118" (105.00 mm - 130.00 mm)	2.680" (68.07 mm)
151069	4.921" - 5.118" (125.00 mm - 130.00 mm)	0.600" (15.24 mm)
	5.118" - 8.071" (130.00 mm - 205.00 mm)	2.680" (68.07 mm)
149030	7.874" - 128.150" (200.00 mm - 3255.00 mm)	2.680" (68.07 mm)

Example: To open an existing hole to 4.500" diameter, a 151059 insert holder would be used with a 148007 serrated tool body, and the minimum pilot diameter would be 4.500" - 2.680" = 1.820" (114.30 mm - 68.07 mm = 46.23 mm).

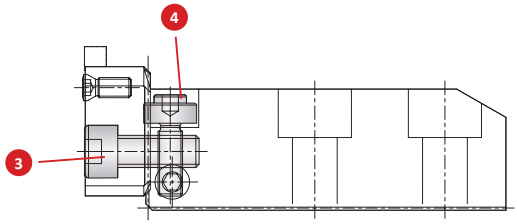
Accessories

Clamping Elements | Axial Grooving Accessories



Clamping Elements

Connection	Serrated Tool Body	Part No. 1. Cap Screw	Service Key	2. Clamping Nut	3. Adjustment Pin	4. Thread Pin	Service Key
25 - 14	148001	**140108**	**s4 / B**	**140114**	–	**115280**	**s2.5 / A**
25 - 14	148002	**148110**	**s5 / B**	**115667**	–	**126157**	**s2.5 / A**
25 - 14	148011	**148110**	**s5 / B**	**148113**	–	**117148**	**s2.5 / A**
25 - 14	148012	**148110**	**s5 / B**	**115666**	–	**117148**	**s2.5 / A**
32 - 18	148003	**140110**	**s5 / B**	**115667**	–	**126157**	**s2.5 / A**
32 - 18	148013	**148110**	**s5 / B**	**148114**	–	**115192**	**s2.5 / A**
32 - 18	148017	**148110**	**s5 / B**	**115667**	–	**126157**	**s2.5 / A**
40 - 22	148004	**140110**	**s5 / B**	**140116**	–	**115407**	**s2.5 / A**
40 - 22	148014	**148110**	**s5 / B**	**148114**	–	**126157**	**s2.5 / A**
40 - 22	148018	**140110**	**s5 / B**	**115667**	–	**126157**	**s2.5 / A**
50 - 28	148005	**140111**	**s6 / B**	**140117**	–	**140121**	**s2.5 / A**
50 - 28	148010	**140111**	**s6 / B**	**140117**	–	**140121**	**s2.5 / A**
50 - 28	148015	**140112**	**s6 / B**	**140117**	–	**215111**	**s2.5 / A**
50 - 28	235001	**415111**	**T25 / B**	–	–	**215346**	**s1.5 / A**
50 - 28	235002	**415112**	**T25 / B**	–	–	**215346**	**s1.5 / A**
50 - 28	235003	**415113**	**T25 / B**	–	–	**215346**	**s1.5 / A**
50 - 28	148021	**140108**	**s4 / B**	**140114**	–	**115280**	**s2.5 / A**
50 - 28	148022	**140110**	**s5 / B**	**115667**	–	**126157**	**s2.5 / A**
50 - 28	148023	**140110**	**s5 / B**	**115667**	–	**126157**	**s2.5 / A**
50 - 28	148024	**140110**	**s5 / B**	**140116**	–	**115407**	**s2.5 / A**
63 - 36	148006	**140112**	**s6 / B**	**140118**	–	**140121**	**s2.5 / A**
63 - 36	148016	**140112**	**s6 / B**	**140117**	–	**116550**	**s2.5 / A**
63 - 36	235011	**415111**	**T25 / B**	–	–	**215346**	**s1.5 / A**
63 - 36	235012	**415112**	**T25 / B**	–	–	**215346**	**s1.5 / A**
63 - 36	235013	**415113**	**T25 / B**	–	–	**215346**	**s1.5 / A**
80 - 36	148007	**115730**	**s6 / B**	**140119**	–	**116550**	**s2.5 / A**
80 - 36	148009	**115730**	**s6 / B**	**140119**	**140120**	**115519**	**s2.5 / A**
Ø 18	235021	**415111**	**T25 / B**	–	–	**215346**	**s1.5 / A**
Ø 20	235022	**415112**	**T25 / B**	–	–	**215346**	**s1.5 / A**
Ø 23	235023	**415113**	**T25 / B**	–	–	**215346**	**s1.5 / A**



Axial Grooving Accessories

Support Base	3. Cap Screw Part No.	Service Key	4. Axial Adjustment Screw Part No.	Service Key
226011	**023182**	s6 / B	**215374**	s4 / B
226012	**023182**	s6 / B	**215374**	s4 / B
226013	**023182**	s6 / B	**215374**	s4 / B

B10-M: 12-19
Key on B10-D: 1
B10: vi-vii

ⓘ = Imperial (in)
ⓜ = Metric (mm)

Notes

Guaranteed Test / Demo Application Form

Distributor PO #	

The following must be filled out completely before your test will be considered.

IMPORTANT: For processing, send purchase order to your Allied Field Sales Engineer (FSE). Please clearly mark the paperwork as "Test Order."

Distributor Information

Company Name: _____
Contact: _____
Account Number: _____
Phone: _____
Email: _____

End User Information

Company Name: _____
Contact: _____
Industry: _____
Phone: _____
Email: _____

Current Process

List all tooling, coatings, substrates, speeds and feeds, tool life, and any problems you are experiencing.

_____

_____

Test Objective

List what would make this a successful test (i.e. penetration rate, finish, tool life, hole size, etc.).

_____

_____

Application Information

Hole Diameter: _____ in/mm
Tolerance: _____
Material: _____ (4150, A36, cast iron, etc.)
Preexisting Diameter: _____ in/mm
Depth of Cut: _____ in/mm
Hardness: _____ (BHN, Rc)
Required Finish: _____ RMS
State: _____ (Casting, hot rolled, forging)

Machine Information

Machine Type: _____ (Lathe, screw machine, machine center, etc.)
Builder: _____ (Haas, Mori Seiki, etc.)
Model #: _____
Shank Required: _____ (CAT50, Morse taper, etc.)
Power: _____ HP/KW
Thrust: _____ lbs/N

Rigidity:
- ☐ Excellent
- ☐ Good
- ☐ Poor

Orientation:
- ☐ Vertical
- ☐ Horizontal

Tool Rotating:
- ☐ Yes
- ☐ No

Coolant Information

Coolant Delivery: _____ (Through tool, flood)
Coolant Pressure: _____ PSI / bar
Coolant Type: _____ (Air mist, oil, synthetic, water soluble, etc.)
Coolant Volume: _____ GPM / LPM

Requested Tooling

QTY	Item Number

QTY	Item Number

ALLIED MACHINE & ENGINEERING

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ALLIED MACHINE & ENGINEERING

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Complete information as to operating conditions, machine, setup, and the application of cutting fluid should accompany any product returned for inspection. This warranty shall not apply to any Allied Machine products which have been subjected to misuse, abuse, improper operating conditions, improper machine setup or improper application of cutting fluid or which have been repaired or altered if such repair or alteration, in the judgement of Allied Machine, would adversely affect the performance of the product.

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