

DORIAN[®]
INTERNATIONAL
TOOL

ADVANCED
TOOLING SUPPLIES INC.



Milling Solution Tool



Solution Tool!
Makes Deep Hole Boring Simpler

YOUR ACHIEVEMENT OUR TOOLS

TECHNOLOGY, QUALITY & PERFORMANCE

WILL TURN
MACHINING INTO
PROFIT



Product Offering Overview	Pg. 4
Anti-Vibration Solution Tool Introduction	Pg. 5
Universal Boring and Milling System	Pg. 6
Tool Head Selection Guide	Pg. 7
Tool Holder Selection Guide	Pg. 8
Quick-Change System	Pg. 10
Quick-Change System Connection	Pg. 11
Quick-Change Finishing Boring Head	Pg. 15
Quick-Change Roughing Boring Heads	Pg. 19
Quick-Change Face Mill Adaptor	Pg. 25
Quick-Change End Mill Tool Holder	Pg. 29
Integral System	Pg. 33
Integral Finishing Boring System	Pg. 34
Integral Twin Insert Roughing Boring System	Pg. 36
Integral Step Insert Roughing Boring System	Pg. 37
Integral Face Mill Adaptor System	Pg. 39
Integral End Mill Tool Holder System	Pg. 41
Spare Parts	Pg. 43
Quality Control	Pg. 50
Application Form for Milling Solution Tool	Pg. 51
Index	Pg. 52
International Sales Representatives	Pg. 53

Quick-Change System

Universal Boring and Milling Bar with Quick-Change Tool Heads

- Increased productivity due to efficient tool changing system.
- Provides flexibility by using same bar for multiple applications.
- Maximum versatility as a result of large selection of tooling styles and sizes.
- Through-coolant system to improve tool life.

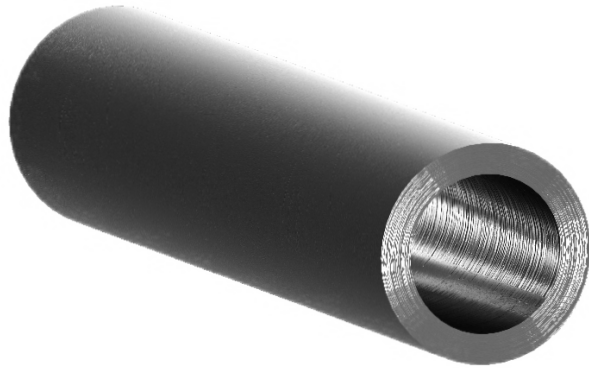


Integral System

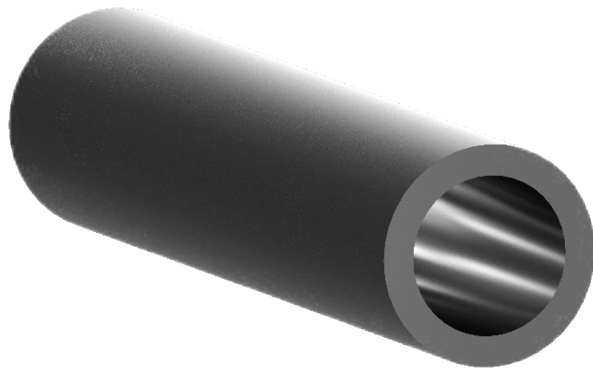
Integrated Boring and Milling Bar with Specific Tool Head

- Provides greater rigidity ensuring high stability in extreme machining applications.
- Incredibly sturdy and reliable.
- Compact design for better performance.
- Through-coolant system to improve tool life.





Machined with Standard toolholder



Machined with Milling Solution Tool!™

Purpose

Effects of Vibration include:

- Damage Machine Tools.
- Poor Surface Quality.
- Excessive Tool Wear.
- Inaccuracy.

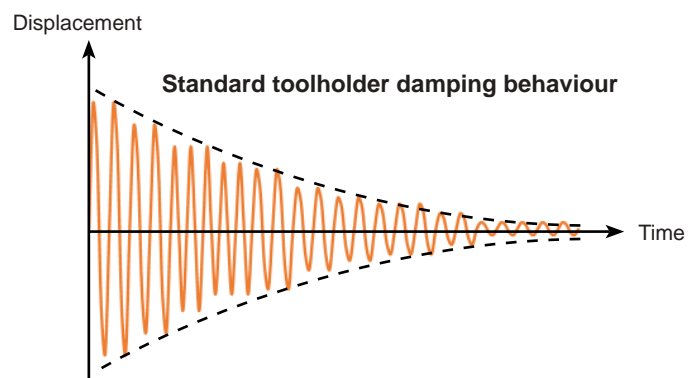
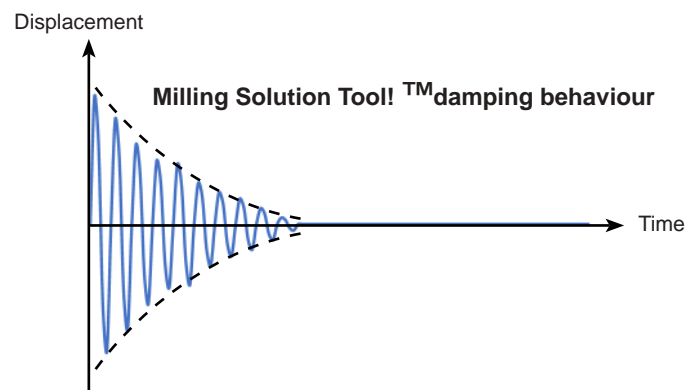
Dorian Tool's Solution Tool - Anti-Vibration System Provides:

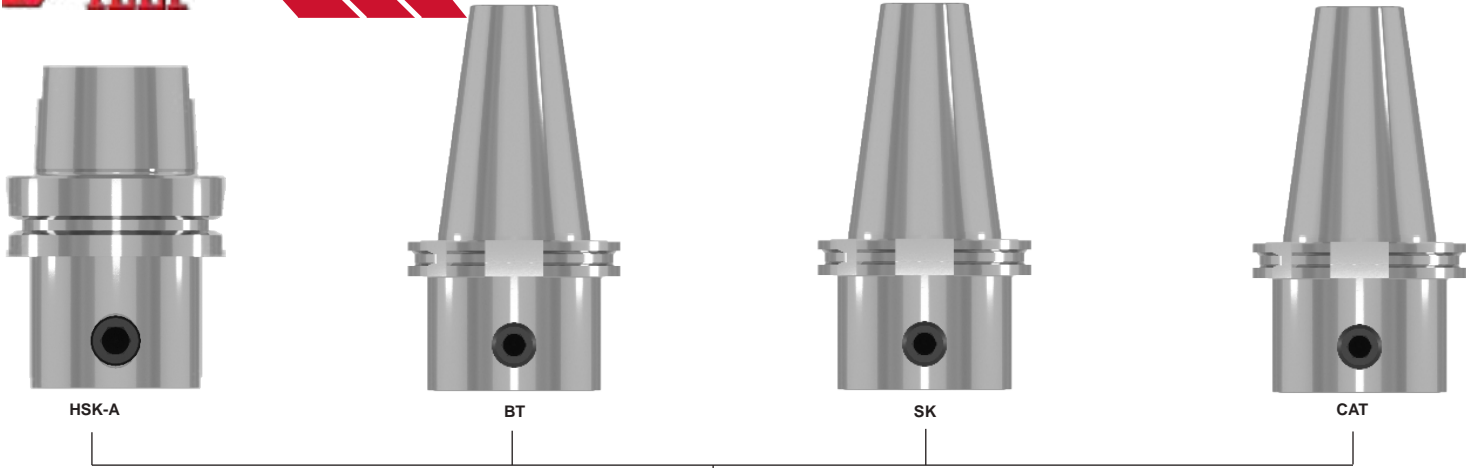
- Excellent Stability.
- Maximum Rigidity.
- Best Surface Finish.
- Exceptional Product Quality.

Principle

Dorian Tool's Solution Tool - Anti-Vibration System

- Vibration Damping System is incorporated in the Bar to increase the overall dynamic stiffness.
- The damping system absorbs vibrations which are caused by cutting tools.
- It provides steady operations for high Length to Diameter ratio overhangs.
- The Anti-Vibration System offers better accuracy, surface finish, longer tool life & higher material removal rates.





HSK-A

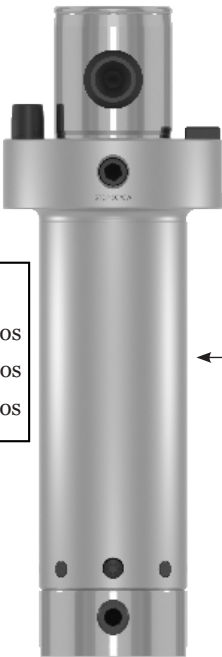
BT

SK

CAT

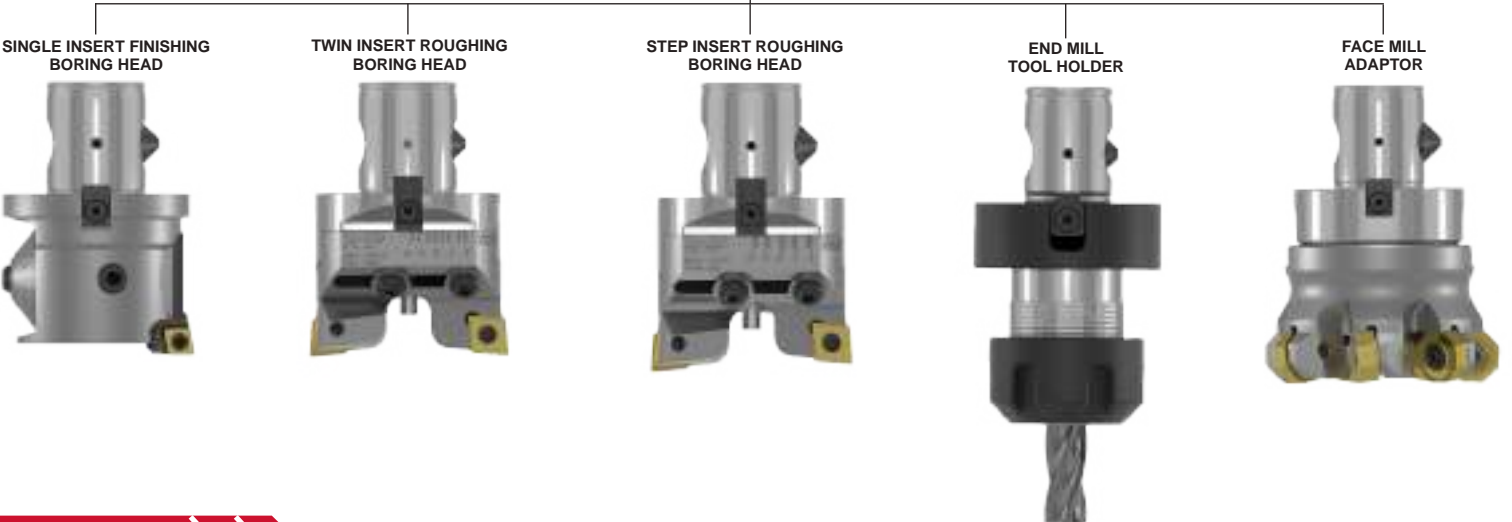
MACHINE SPINDLE CONNECTION
DT

Available in Sizes:
 - Ø42mm with 4 x Dia., 6 x Dia., 8 x Dia., 10 x Dia. Boring Ratios
 - Ø50mm with 4 x Dia., 6 x Dia., 8 x Dia., 10 x Dia. Boring Ratios
 - Ø63mm with 4 x Dia., 6 x Dia., 8 x Dia., 10 x Dia. Boring Ratios



UNIVERSAL QUICK-CHANGE
BORING & MILLING BAR

QUICK-CHANGE
TOOL HEAD CONNECTION
UQCS



SINGLE INSERT FINISHING
BORING HEAD

TWIN INSERT ROUGHING
BORING HEAD

STEP INSERT ROUGHING
BORING HEAD

END MILL
TOOL HOLDER

FACE MILL
ADAPTOR

- Solution Tool!™ features a wide range of Anti-Vibration Tool Holding solutions for Milling, including Single Insert Finishing Boring Head, Twin Insert Roughing Boring Head, Step Insert Roughing Boring Head, End Mill Tool Holder, Face Mill Adaptor System.
- Our products are available in through system coolant technology for high performance, functionality, and durability for traditional and heavy-duty machining.

***Quick-Change Single Insert
Finishing Boring Head***



***Quick-Change Twin Insert
Roughing Boring Head***



***Quick-Change Step Insert
Roughing Boring Head***



Quick-Change End Mill Tool Holder



Quick-Change Face Mill Adaptor



Tool Holder (known as Machine Taper) securely locks the Milling Solution Tool!™ Bar and is introduced into the machine spindle.

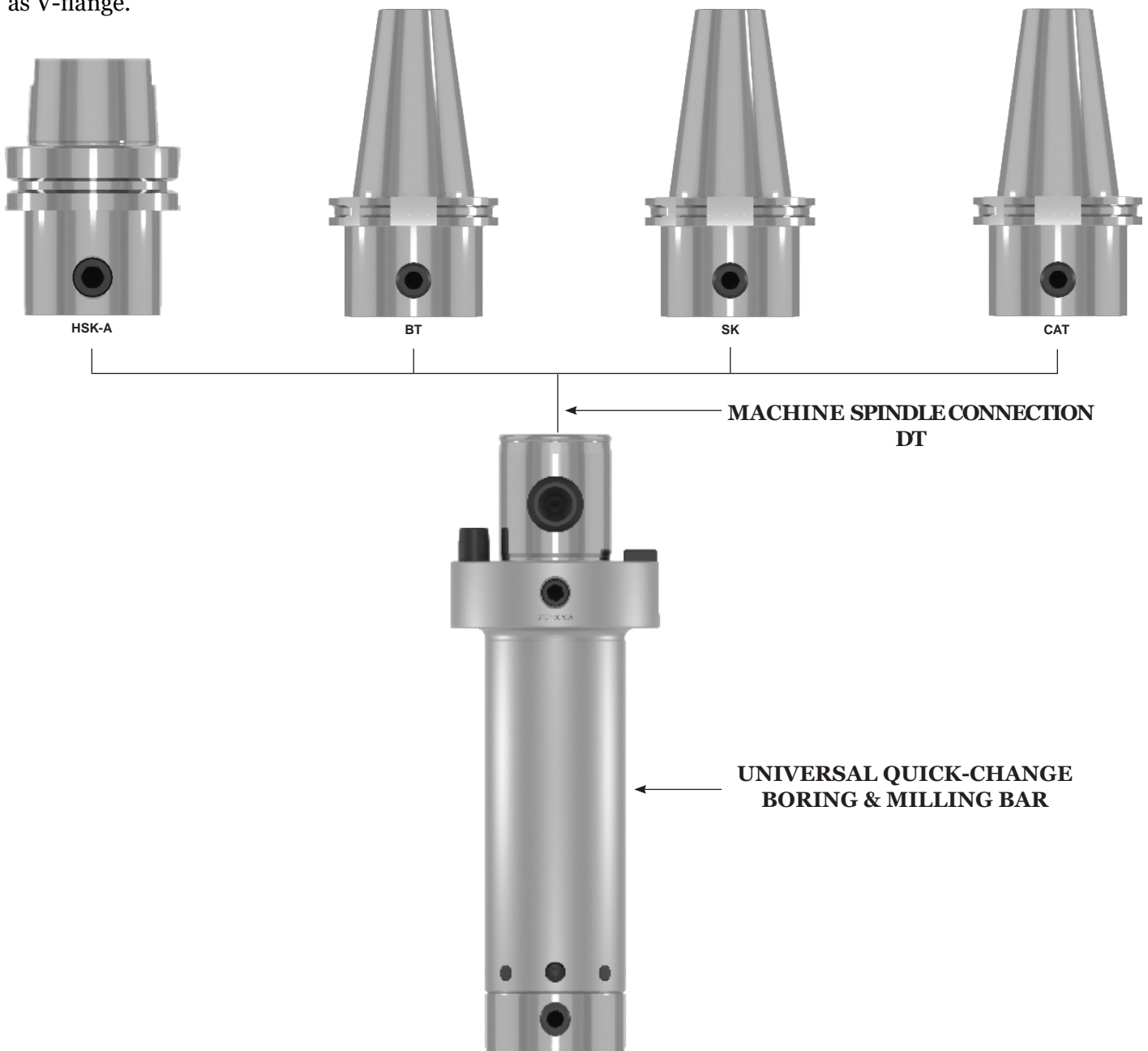
Available in HSK-A63 and HSK-A100 Taper, SK40 and SK50, CAT40 and CAT50, BT40 and BT50.

HSK-A Tool Holder (Hohl Shaft Kegel, or Hollow Taper Shank): HSK is originated from Germany and is popular for its stability and balance in high-speed machining operations at a higher accuracy. It is designed to increase grip as spindle speed increases.

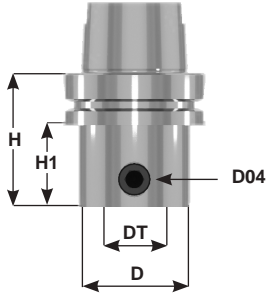
SK Tool Holder (Steep Taper): SK is designed to allow more rigid applications when heavy radial loads are part of the machining process.

BT Tool Holder (Bonsai Taper) : BT is dual flange taper developed in Japan. It is symmetrical about spindle axis allowing for greater stability and balance during small and high speed machine work.

CAT Tool Holder (Caterpillar “V-flange”): CAT is standardized steep taper by Caterpillar Inc. which features a V-groove in the flange for the grip. This groove is why CAT toolholders are occasionally referred to as V-flange.



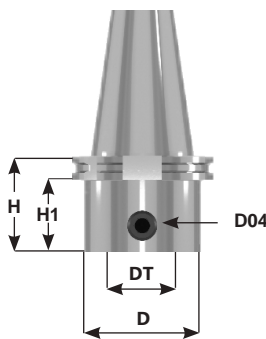
HSK-A TOOLHOLDER



HSK-A Toolholder

Part Number	UPC	Spindle Connection DT	Holder Taper	H	H1	D	D04 Locking Taper Screw		Weight Kg
							Description	UPC	
HSK63-DT63-80	63581	DT63	HSK-A63	80	54	63	D04-63-24 LTS	63363	1.5
HSK100-DT63-80	63582	DT63	HSK-A100	80	35	63	D04-63-24 LTS	63363	3.3
HSK100-DT80-90	63583	DT80	HSK-A100	90	45	80	D04-80-24 LTS	63364	4.0

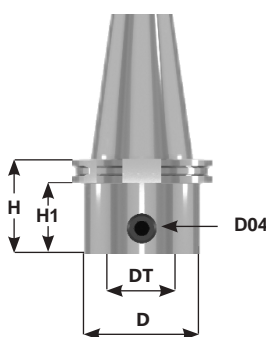
SK TOOLHOLDER



SK Toolholder

Part Number	UPC	Spindle Connection DT	Holder Taper	H	H1	D	D04 Locking Taper Screw		Weight Kg
							Description	UPC	
SK40-DT63-65	63588	DT63	SK40	65	46	63	D04-63-24 LTS	63363	1.5
SK50-DT63-60	63589	DT63	SK50	60	41	63	D04-63-24 LTS	63363	3.3
SK50-DT80-70	63590	DT80	SK50	70	51	80	D04-80-24 LTS	63364	4.0

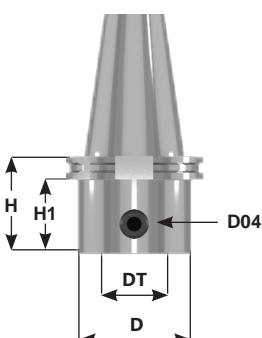
CAT TOOLHOLDER



CAT Toolholder

Part Number	UPC	Spindle Connection DT	Holder Taper	H	H1	D	D04 Locking Taper Screw		Weight Kg
							Description	UPC	
CAT40-DT63-65	63591	DT63	CAT40	65	46	63	D04-63-24 LTS	63363	1.5
CAT50-DT63-65	63592	DT63	CAT50	65	30	63	D04-63-24 LTS	63363	3.0
CAT50-DT80-75	63593	DT80	CAT50	75	40	80	D04-80-24 LTS	63364	3.3

BT TOOLHOLDER



BT Toolholder

Part Number	UPC	Spindle Connection DT	Holder Taper	H	H1	D	D04 Locking Taper Screw		Weight Kg
							Description	UPC	
BT40-DT63-55	63594	DT63	BT40	55	28	63	D04-63-24 LTS	63363	1.4
BT50-DT63-80	63585	DT63	BT50	80	42	63	D04-63-24 LTS	63363	4.3
BT50-DT80-100	63586	DT80	BT50	100	62	80	D04-80-24 LTS	63364	5.5

- All dimensions are in mm unless otherwise specified.

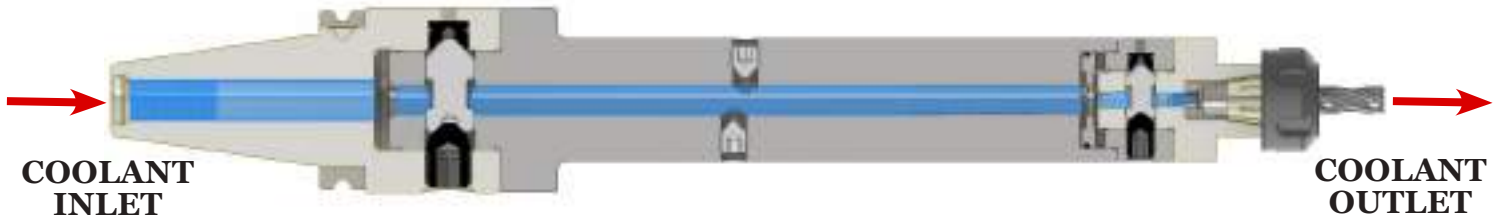
QUICK-CHANGE SYSTEM

One Universal Bar

Five Quick-Change Tool Heads



THROUGH-COOLANT SYSTEM

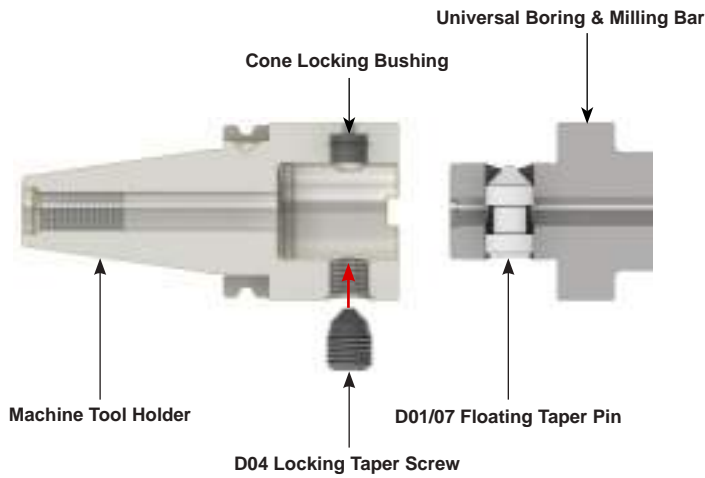


QUICK-CHANGE SYSTEM CONNECTION

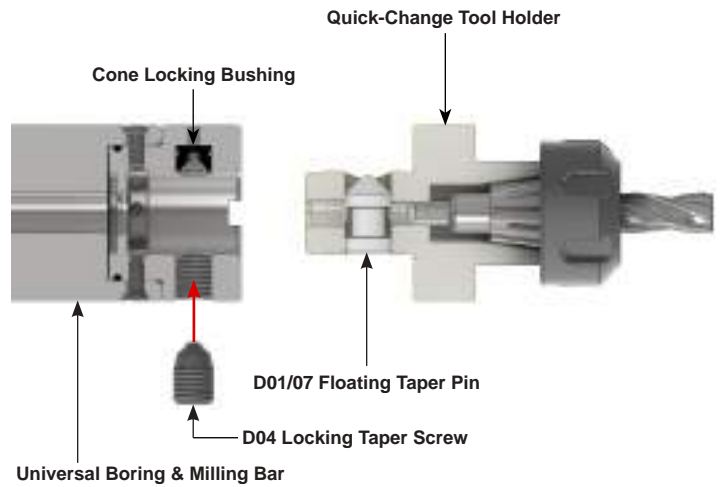
HIGHLY EFFICIENT & NO SPECIAL TOOLS REQUIRED



Machine Spindle Connection



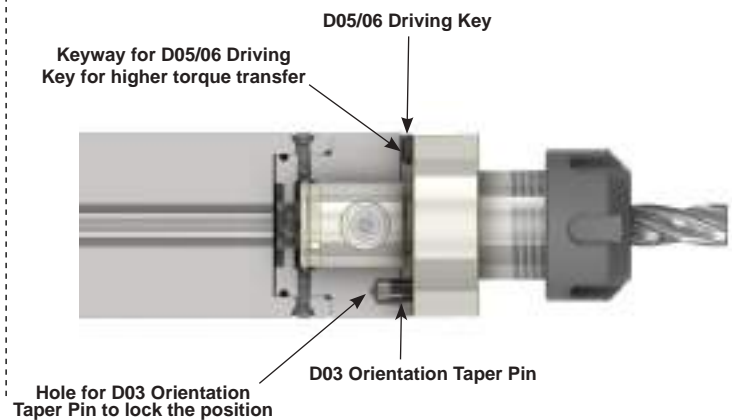
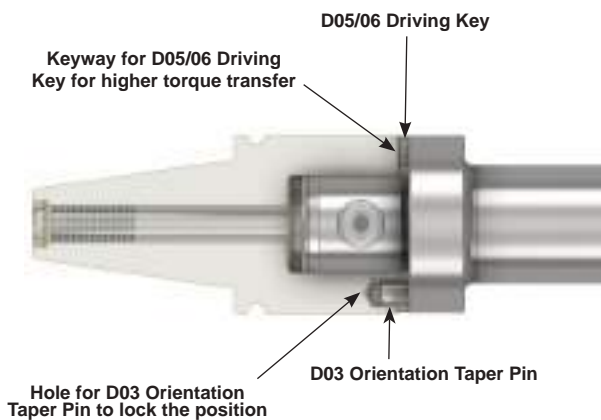
Quick-Change Tool Head Connection

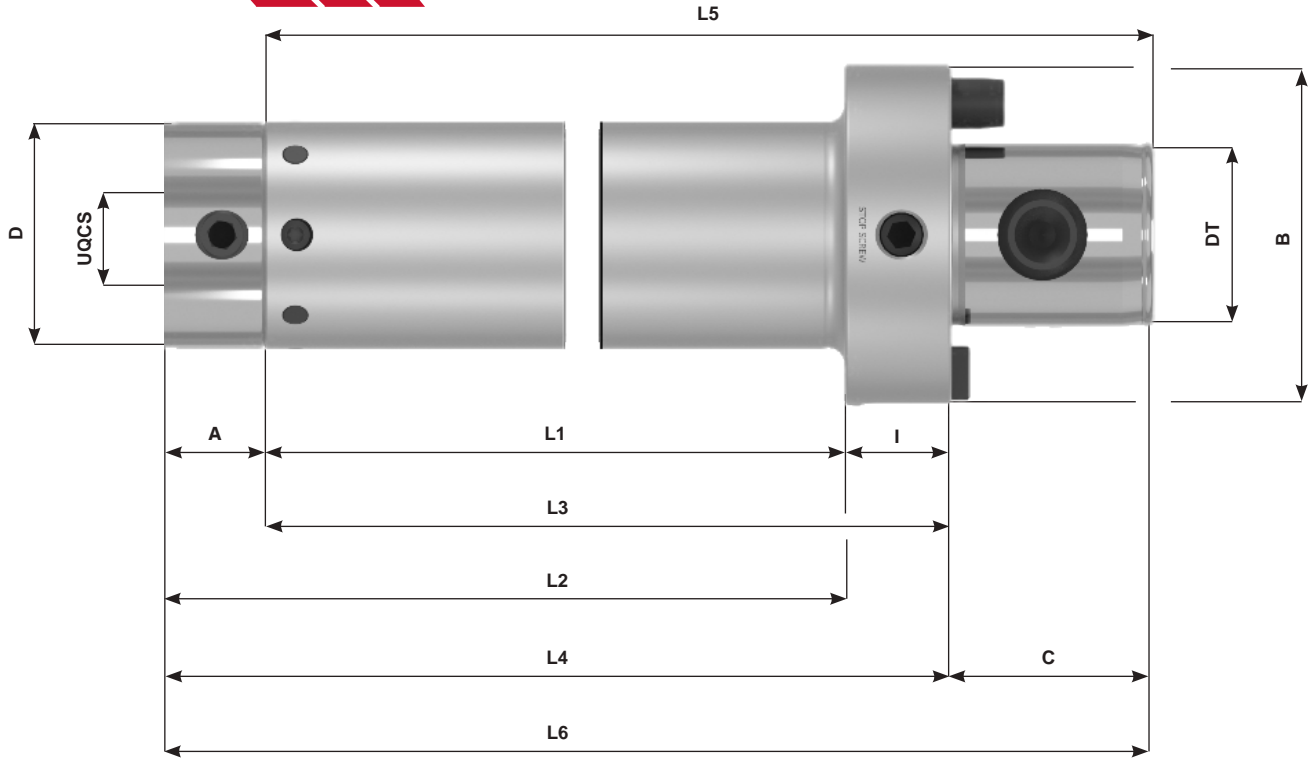


Once the Bar is inserted in the Machine Spindle connection, Lock the Universal Boring & Milling bar using D04 Locking Taper Screw with the help of Allen Wrench.



Once the Quick-change Tool Holder is inserted in the Universal Boring & Milling Bar, Lock the bar using D04 Locking Taper Screw with the help of Allen Wrench.



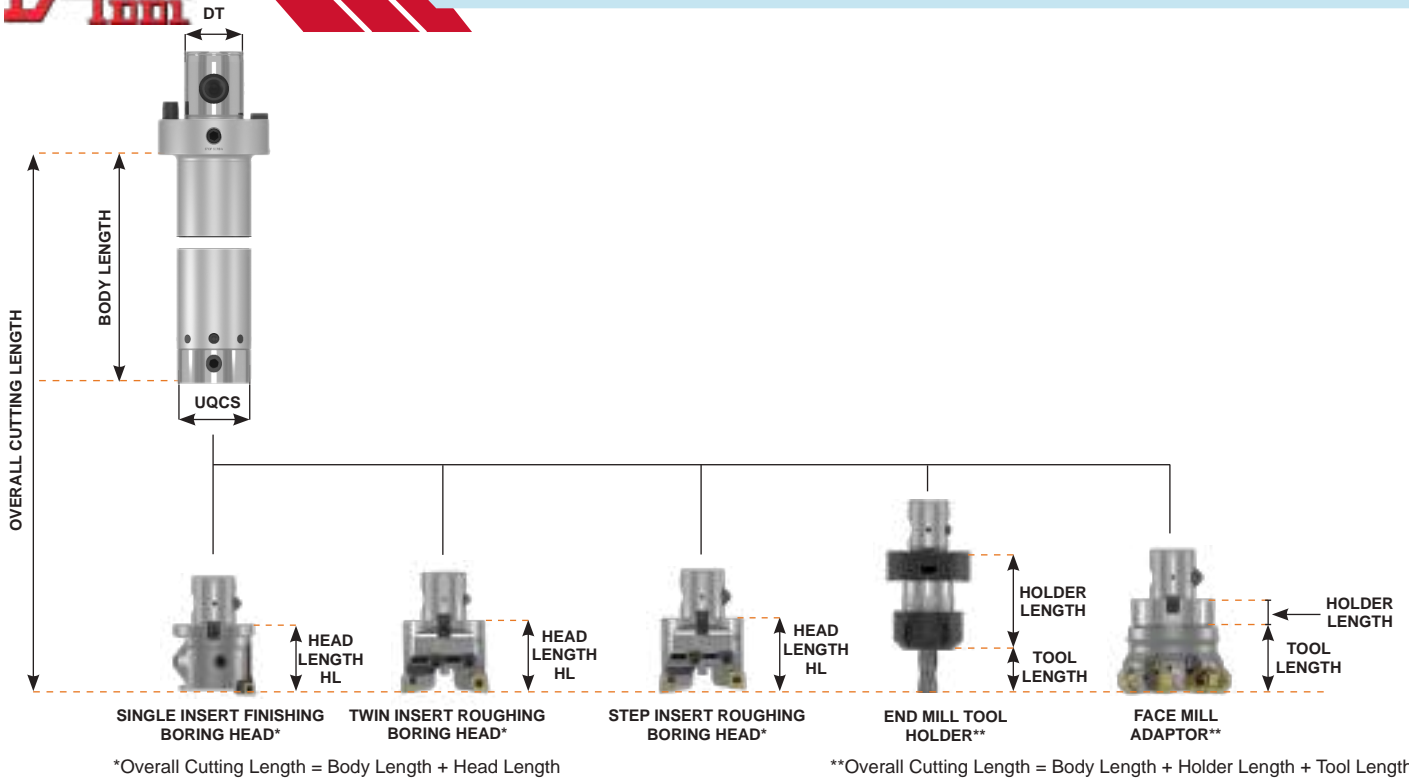


QUICK-CHANGE BORING & MILLING BAR SPECIFICATIONS

Part Number	UPC	Boring Ratio	Nominal Boring Length	Tool Head Connection UQCS	Spindle Connection DT	Bar Weight (kg)	A	B	C	D	I	L1	L2	L3	L4	L5	L6
42mm-Solution Tool - Universal Quick-Change Milling Bar Specifications																	
DST-UQCS42-04 0168-DT63	63100	4	168	UQCS42	DT63	2.6	19	63	38	42	20	109	128	129	148	167	186
DST-UQCS42-04 0168-DT80	63056	4	168	UQCS42	DT80	3.3	19	80	43	42	25	109	128	134	153	177	196
DST-UQCS42-06 0252-DT63	63101	6	252	UQCS42	DT63	3.5	19	63	38	42	20	193	212	213	232	251	270
DST-UQCS42-06 0252-DT80	63057	6	252	UQCS42	DT80	4.2	19	80	43	42	25	193	212	218	237	261	280
DST-UQCS42-08 0336-DT63	63102	8	336	UQCS42	DT63	4.7	19	63	38	42	20	277	296	297	316	335	354
DST-UQCS42-08 0336-DT80	63103	8	336	UQCS42	DT80	5.6	19	80	43	42	25	277	296	302	321	345	364
DST-UQCS42-10 0420-DT63	63104	10	420	UQCS42	DT63	6.0	19	63	38	42	20	361	380	381	400	419	438
DST-UQCS42-10 0420-DT80	63105	10	420	UQCS42	DT80	6.7	19	80	43	42	25	361	380	386	405	429	448
50mm-Solution Tool - Universal Quick-Change Milling Bar Specifications																	
DST-UQCS50-04 0200-DT63	63106	4	200	UQCS50	DT63	4.8	24	63	38	50	35	126	150	161	185	199	223
DST-UQCS50-04 0200-DT80	63107	4	200	UQCS50	DT80	5.4	24	80	43	50	35	126	150	161	185	204	228
DST-UQCS50-06 0300-DT63	63108	6	300	UQCS50	DT63	6.2	24	63	38	50	25	226	250	251	275	289	313
DST-UQCS50-06 0300-DT80	63109	6	300	UQCS50	DT80	6.8	24	80	43	50	25	226	250	251	275	294	318
DST-UQCS50-08 0400-DT63	63058	8	400	UQCS50	DT63	8.0	24	63	38	50	25	326	350	351	375	389	413
DST-UQCS50-08 0400-DT80	63110	8	400	UQCS50	DT80	8.4	24	80	43	50	25	326	350	351	375	394	418
DST-UQCS50-10 0500-DT63	63059	10	500	UQCS50	DT63	10.0	24	63	38	50	25	426	450	451	475	489	513
DST-UQCS50-10 0500-DT80	63111	10	500	UQCS50	DT80	10.4	24	80	43	50	25	426	450	451	475	494	518
63mm-Solution Tool - Universal Quick-Change Milling Bar Specifications																	
DST-UQCS63-04 0252-DT63	63112	4	252	UQCS63	DT63	6.2	27.45	63	38	63	0	169.6	197.05	169.6	197.05	207.6	235.05
DST-UQCS63-04 0252-DT80	63113	4	252	UQCS63	DT80	7.4	27.45	80	43	63	25	169.6	197.05	194.6	222.05	237.6	265.05
DST-UQCS63-06 0378-DT63	63114	6	378	UQCS63	DT63	10.0	27.45	63	38	63	0	295.6	323.05	295.6	323.05	333.6	361.05
DST-UQCS63-06 0378-DT80	63115	6	378	UQCS63	DT80	11.3	27.45	80	43	63	25	295.6	323.05	320.6	348.05	363.6	391.05
DST-UQCS63-08 0504-DT80	63116	8	504	UQCS63	DT80	15.1	27.45	80	43	63	25	421.6	449.05	446.6	474.05	489.6	517.05
DST-UQCS63-10 0630-DT80	63117	10	630	UQCS63	DT80	18.5	27.45	80	43	63	25	547.6	575.05	572.6	600.05	615.6	643.05

*Quick-Change Bar Body is sold individually without Tool Heads.

- All dimensions are in mm unless otherwise specified.



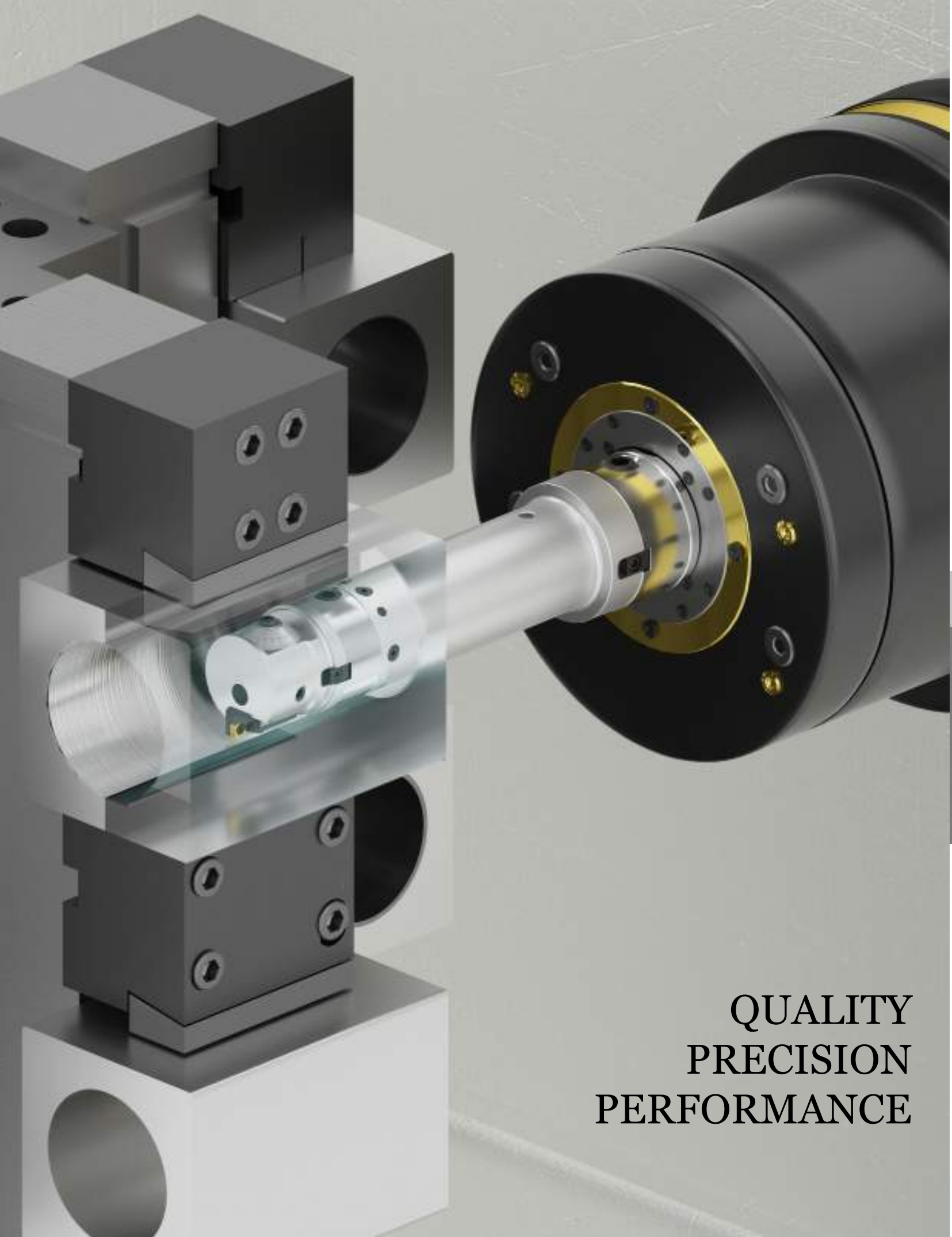
QUICK-CHANGE TOOL HEADS**

Single Insert Finishing Boring Head			Twin Insert Roughing Boring Head			Step Insert Roughing Boring Head			End Mill Tool Holder		Face Mill Adaptor	
Part Number	Head Length HL	Overall Cutting Length	Part Number	Head Length HL	Overall Cutting Length	Part Number	Head Length HL	Overall Cutting Length	Part Number	Holder Length	Part Number	Holder Length
42mm Solution Tool - Universal Boring and Milling Bar - Quick-Change System												
DST-UQCS-FBH42	40	168	DST-UQCS-TRH42	40	168	DST-UQCS-SRH42	40	168	DST-UQCS-EMH42-ER20	50	DST-UQCS-FMA42-M13 DST-UQCS-FMA42-M16 DST-UQCS-FMA42-M22	13
		168			168							
		252			252							
		252			252							
		336			336							
		336			336							
		420			420							
		420			420							
50mm Solution Tool - Universal Boring and Milling Bar - Quick-Change System												
DST-UQCS-FBH50	50	200	DST-UQCS-TRH50	50	200	DST-UQCS-SRH50	50	200	DST-UQCS-EMH50-ER25	55	DST-UQCS-FMA50-M16 DST-UQCS-FMA50-M22 DST-UQCS-FMA50-M27	16
		200			200							
		300			300							
		300			300							
		400			400							
		400			400							
		500			500							
		500			500							
63mm Solution Tool - Universal Boring and Milling Bar - Quick-Change System												
DST-UQCS-FBH63	54.95	252	DST-UQCS-TRH63	54.95	252	DST-UQCS-SRH63	54.95	252	DST-UQCS-EMH63-ER32	60	DST-UQCS-FMA63-M16 DST-UQCS-FMA63-M22 DST-UQCS-FMA63-M27 DST-UQCS-FMA63-M32 DST-UQCS-FMA63-M40	21
		252			252							
		378			378							
		378			378							
		504			504							
		630			630							

**Quick-Change Tool Heads sold separately.

- All dimensions are in mm unless otherwise specified.





QUALITY
PRECISION
PERFORMANCE

QUICK-CHANGE FINISHING BORING HEAD

- Quick-change Single Insert Finish Boring Head assures the highest quality of performance that your production requires.
- Offers Precision adjustment for tight tolerance bores enabling more productive and accurate boring.
- Easier Diameter adjustments via micro dial to balance complete assemblies for improved performance in finish, tool life, concentricity, and roundness.



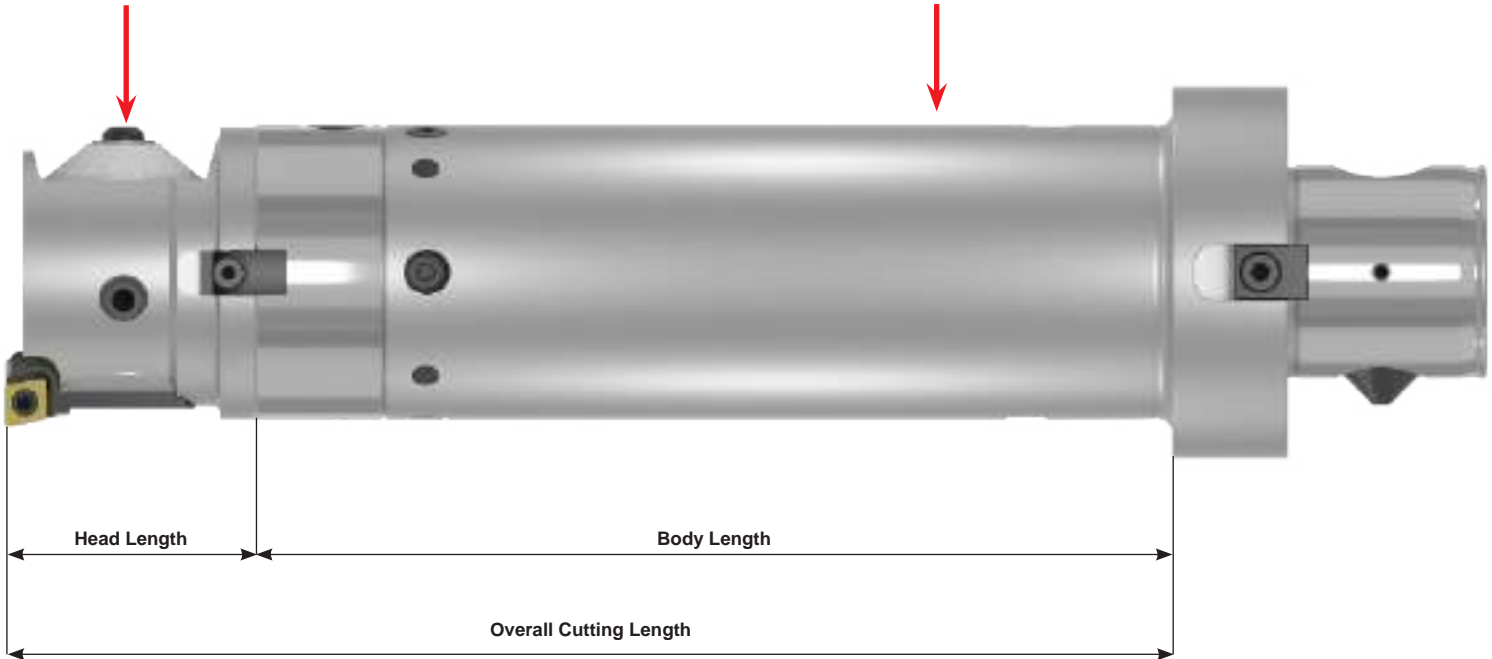
Features and Benefits

- Micro Dial with .0001" (.005mm) graduation for .0003" (.01mm) adjustments on diameter without need for Vernier scale.
- Interchangeable Finishing Boring cartridge with different choice of inserts covers a diameter range from 48 to 116mm (1.890" to 4.564").
- Top quality coating on Tool Head Body guarantees the very best corrosion protection and dependability.
- Through-coolant system supply to the cutting edge for improved tool life.

Overall Cutting Length

Quick-Change Single Insert Finishing Boring Head

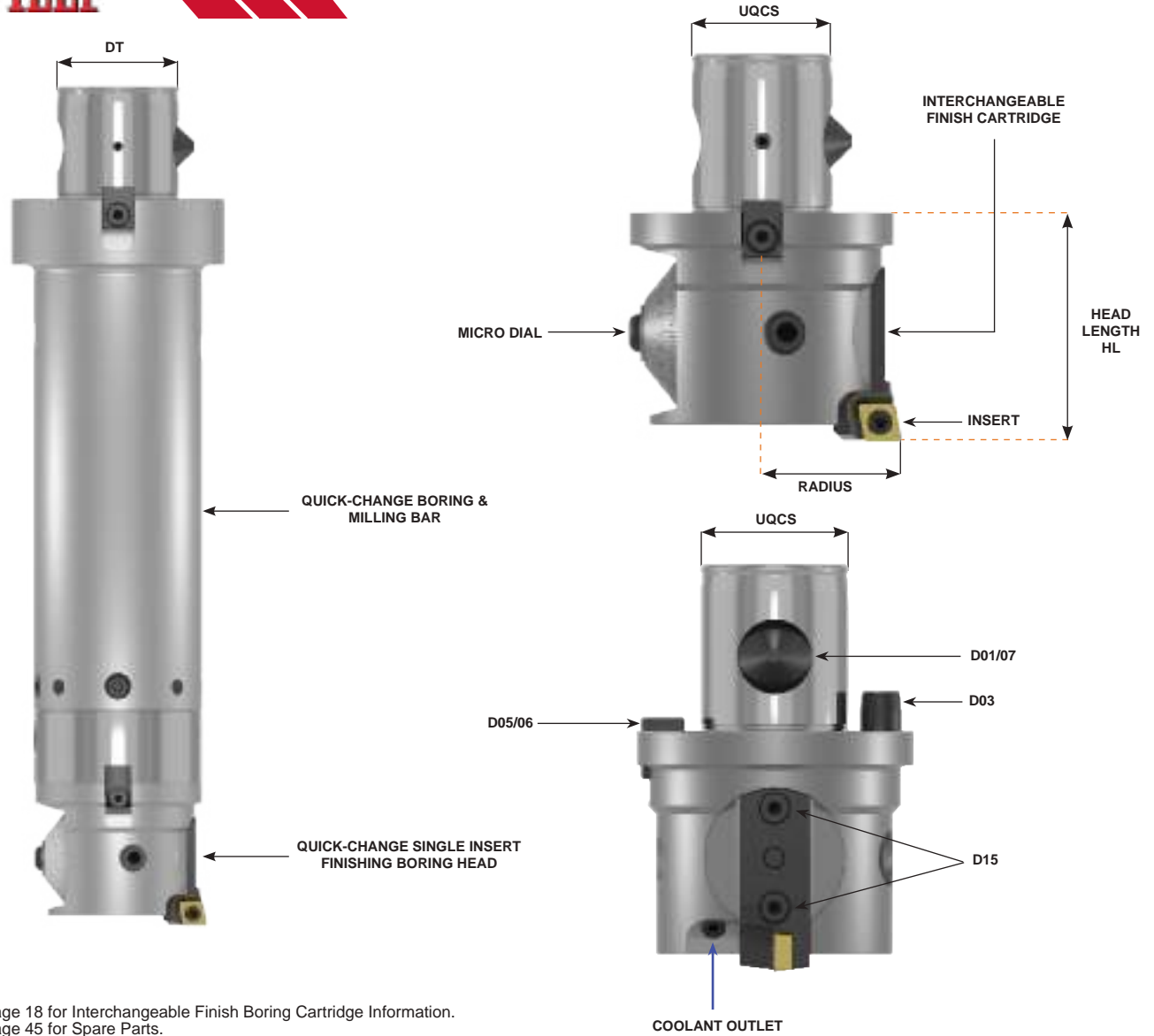
Universal Quick-Change Boring & Milling Bar



*Overall Cutting Length = Body Length + Head Length

QUICK-CHANGE BORING AND MILLING BAR							QUICK-CHANGE SINGLE INSERT FINISHING BORING HEAD			OVERALL CUTTING LENGTH
Part Number	UPC	Bar Diameter	Boring Ratio	Spindle Connection DT	Body Length	Tool Head Connection UQCS	Part Number	UPC	Head Length	
42mm Quick-Change Boring and Milling Bar with Single Insert Tool Head										
DST-UQCS42-04 0168-DT63	63100	42	4	DT63	128	UQCS42	DST-UQCS-FBH42	63198	40	168
DST-UQCS42-04 0168-DT80	63056		4	DT80	128					168
DST-UQCS42-06 0252-DT63	63101		6	DT63	212					252
DST-UQCS42-06 0252-DT80	63057		6	DT80	212					252
DST-UQCS42-08 0336-DT63	63102		8	DT63	296					336
DST-UQCS42-08 0336-DT80	63103		8	DT80	296					336
DST-UQCS42-10 0420-DT63	63104		10	DT63	380					420
DST-UQCS42-10 0420-DT80	63105		10	DT80	380					420
50mm Quick-Change Boring and Milling Bar with Single Insert Tool Head										
DST-UQCS50-04 0200-DT63	63106	50	4	DT63	150	UQCS50	DST-UQCS-FBH50	63199	50	200
DST-UQCS50-04 0200-DT80	63107		4	DT80	150					200
DST-UQCS50-06 0300-DT63	63108		6	DT63	250					300
DST-UQCS50-06 0300-DT80	63109		6	DT80	250					300
DST-UQCS50-08 0400-DT80	63110		8	DT80	350					400
DST-UQCS50-10 0500-DT80	63111		10	DT80	450					500
63mm Quick-Change Boring and Milling Bar with Single Insert Tool Head										
DST-UQCS63-04 0252-DT63	63112	63	4	DT63	197.05	UQCS63	DST-UQCS-FBH63	63200	54.95	252
DST-UQCS63-04 0252-DT80	63113		4	DT80	197.05					252
DST-UQCS63-06 0378-DT63	63114		6	DT63	323.05					378
DST-UQCS63-06 0378-DT80	63115		6	DT80	323.05					378
DST-UQCS63-08 0504-DT80	63116		8	DT80	449.05					504
DST-UQCS63-10 0630-DT80	63117		10	DT80	575.05					630

- All dimensions are in mm unless otherwise specified.

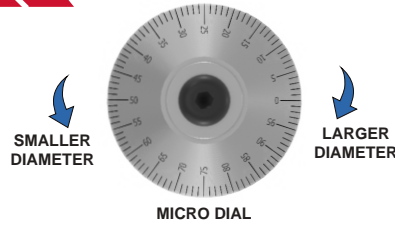
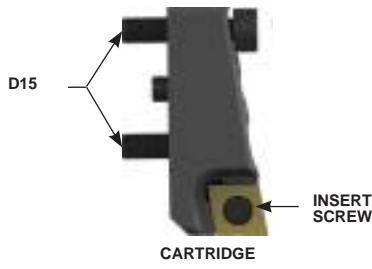


- Please refer page 18 for Interchangeable Finish Boring Cartridge Information.
 - Please refer page 45 for Spare Parts.

QUICK-CHANGE SINGLE INSERT FINISHING BORING HEAD					INTERCHANGEABLE FINISH BORING CARTRIDGE									
Part Number	UPC	Tool Head		Tool Head Connection UQCS	Wt. (kg)	Finishing Small Bore Cartridge	Boring Range		Finishing Medium Bore Cartridge	Boring Range		Finishing Large Bore Cartridge	Boring Range	
		D	HL				Metric	Inch		Metric	Inch		Metric	Inch
42mm Quick-Change Single Insert Finishing Boring Head														
DST-UQCS-FBH42	63198	42	40	UQCS42	0.8	DST-42FBC-S48.61-SCFCL06 DST-42FBC-S48.61-SCJCL06 DST-42FBC-S48.61-STFCL11 DST-42FBC-S48.61-SSDCN06	48 to 61	1.890 to 2.402	DST-42FBC-M58.71-SCFCL06 DST-42FBC-M58.71-SCJCL06 DST-42FBC-M58.71-STFCL11 DST-42FBC-M58.71-SSDCN06	58 to 71	2.283 to 2.795	DST-42FBC-L68.81-SCFCL06 DST-42FBC-L68.81-SCJCL06 DST-42FBC-L68.81-STFCL11 DST-42FBC-L68.81-SSDCN06	68 to 81	2.677 to 3.189
50mm Quick-Change Single Insert Finishing Boring Head														
DST-UQCS-FBH50	63199	50	50	UQCS50	1.2	DST-50FBC-S56.71-SCFCL09 DST-50FBC-S56.71-SCJCL09 DST-50FBC-S56.71-STFCL11 DST-50FBC-S56.71-SSDCN09	56 to 71	2.205 to 2.795	DST-50FBC-M68.83-SCFCL09 DST-50FBC-M68.83-SCJCL09 DST-50FBC-M68.83-STFCL11 DST-50FBC-M68.83-SSDCN09	68 to 83	2.677 to 3.268	DST-50FBC-L80.95-SCFCL09 DST-50FBC-L80.95-SCJCL09 DST-50FBC-L80.95-STFCL11 DST-50FBC-L80.95-SSDCN09	80 to 95	3.150 to 3.740
63mm Quick-Change Single Insert Finishing Boring Head														
DST-UQCS-FBH63	63200	63	54.95	UQCS63	2.1	DST-63FBC-S68.88-SCFCL09 DST-63FBC-S68.88-SCJCL09 DST-63FBC-S68.88-STFCL16 DST-63FBC-S68.88-SSDCN09	68 to 88	2.677 to 3.465	DST-63FBC-M82.102-SCFCL09 DST-63FBC-M82.102-SCJCL09 DST-63FBC-M82.102-STFCL16 DST-63FBC-M82.102-SSDCN09	82 to 102	3.228 to 4.106	DST-63FBC-L96.116-SCFCL09 DST-63FBC-L96.116-SCJCL09 DST-63FBC-L96.116-STFCL16 DST-63FBC-L96.116-SSDCN09	96 to 116	3.780 to 4.564

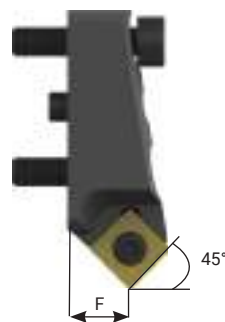
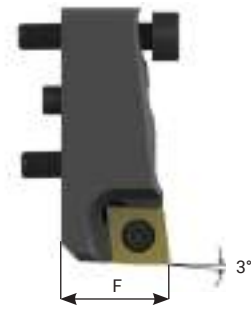
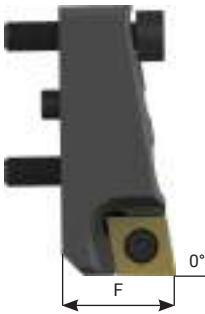
- All dimensions are in mm unless otherwise specified.





MICRO DIAL SPECIFICATIONS					
Micro Dial Graduation		Insert Movement		Cutting Diameter	
Dial Turn	No. of Lines	Metric	Inch	Metric	Inch
1/100	1	0.0050	0.000197	0.010	0.000394
1/4	25	0.1250	0.004921	0.250	0.009843
1/2	50	0.2500	0.009843	0.500	0.019685
3/4	75	0.3750	0.014764	0.750	0.029528
1	100	0.5000	0.019685	1.000	0.039370

- Please refer page 45 for D15 Cartridge Locking Screws.



INTERCHANGEABLE FINISH BORING CARTRIDGE SPECIFICATIONS

Part Number	UPC	Quick Change Finishing Boring Head	Boring Range		F	Insert		Wt. (kg)
			Metric	Inch		Geometry	Screw	
42mm SCFCL06 Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-SCFCL06	63257	DST-UQCS-FBH42	48 to 61	1.890 to 2.402	12	CCMT-0602	TS-25.45-6M2	0.018
DST-42FBC-M58.71-SCFCL06	63258		58 to 71	2.283 to 2.795	17			0.032
DST-42FBC-L68.81-SCFCL06	63259		68 to 81	2.677 to 3.189	22			0.045
50mm SCFCL09 Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-SCFCL09	63269	DST-UQCS-FBH50	56 to 71	2.205 to 2.795	13	CCMT-09T304	TS-4.7-8M1	0.030
DST-50FBC-M68.83-SCFCL09	63270		68 to 83	2.677 to 3.268	19			0.038
DST-50FBC-L80.95-SCFCL06	63271		80 to 95	3.150 to 3.740	25			0.054
63mm SCFCL12 Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-SCFCL12	63281	DST-UQCS-FBH63	68 to 88	2.677 to 3.465	16	CCMT-1204	TS-5.8-10M1	0.025
DST-63FBC-M82.102-SCFCL12	63282		82 to 102	3.228 to 4.106	23			0.045
DST-63FBC-L96.116-SCFCL12	63283		96 to 116	3.780 to 4.564	30			0.064

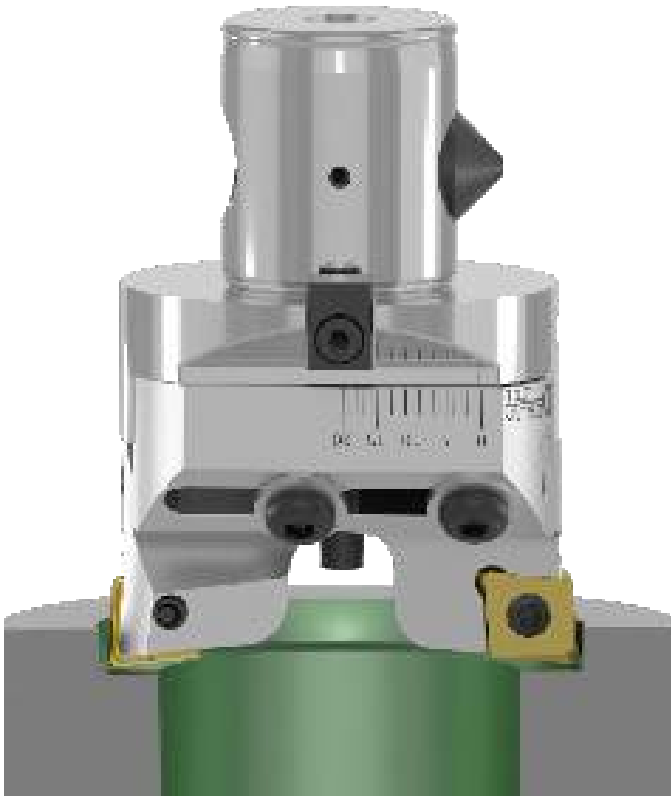
42mm SCJCL06-7° Insert Clearance Angle 3° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-SCJCL06	63260	DST-UQCS-FBH42	48 to 61	1.890 to 2.402	12	CCMT-0602	TS-25.45-6M2	0.019
DST-42FBC-M58.71-SCJCL06	63261		58 to 71	2.283 to 2.795	17			0.033
DST-42FBC-L68.81-SCJCL06	63262		68 to 81	2.677 to 3.189	22			0.046
50mm SCJCL09-7° Insert Clearance Angle 3° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-SCJCL09	63272	DST-UQCS-FBH50	56 to 71	2.205 to 2.795	13	CCMT-09T304	TS-4.7-8TM1	0.022
DST-50FBC-M68.83-SCJCL09	63273		68 to 83	2.677 to 3.268	19			0.040
DST-50FBC-L80.95-SCJCL09	63274		80 to 95	3.150 to 3.740	25			0.056
63mm SCJCL12-7° Insert Clearance Angle 3° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-SCJCL12	63284	DST-UQCS-FBH63	68 to 88	2.677 to 3.465	16	CCMT-1204	TS-5.8-10M1	0.027
DST-63FBC-M82.102-SCJCL12	63285		82 to 102	3.228 to 4.106	23			0.047
DST-63FBC-L96.116-SCJCL12	63286		96 to 116	3.780 to 4.564	30			0.065

42mm STFCL11-7° Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-STFCL11	63263	DST-UQCS-FBH42	48 to 61	1.890 to 2.402	12	TCMT-1102	TS-25.45-6M2	0.017
DST-42FBC-M58.71-STFCL11	63264		58 to 71	2.283 to 2.795	17			0.031
DST-42FBC-L68.81-STFCL11	63265		68 to 81	2.677 to 3.189	22			0.044
50mm STFCL11-7° Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-STFCL11	63275	DST-UQCS-FBH50	56 to 71	2.205 to 2.795	13	TCMT-1102	TS-25.45-6M2	0.020
DST-50FBC-M68.83-STFCL11	63276		68 to 83	2.677 to 3.268	19			0.037
DST-50FBC-L80.95-STFCL11	63277		80 to 95	3.150 to 3.740	25			0.053
63mm STFCL16-7° Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-STFCL16	63287	DST-UQCS-FBH63	68 to 88	2.677 to 3.465	16	TCMT-16T3	TS-4.7-8TM1	0.024
DST-63FBC-M82.102-STFCL16	63288		82 to 102	3.228 to 4.106	23			0.044
DST-63FBC-L96.116-STFCL16	63289		96 to 116	3.780 to 4.564	30			0.063

42mm SSDCN06-Insert Clearance Angle 45° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-SSDCN06	63266	DST-UQCS-FBH42	48 to 61	1.890 to 2.402	12	SCMT-0602	TS-25.45-6M2	0.015
DST-42FBC-M58.71-SSDCN06	63267		58 to 71	2.283 to 2.795	17			0.029
DST-42FBC-L68.81-SSDCN06	63268		68 to 81	2.677 to 3.189	22			0.042
50mm SSDCN09-Insert Clearance Angle 45° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-SSDCN09	63278	DST-UQCS-FBH50	56 to 71	2.205 to 2.795	13	SCMT-09T3	TS-4.7-8TM1	0.018
DST-50FBC-M68.83-SSDCN09	63279		68 to 83	2.677 to 3.268	19			0.035
DST-50FBC-L80.95-SSDCN09	63280		80 to 95	3.150 to 3.740	25			0.051
63mm SSDCN12-Insert Clearance Angle 45° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-SSDCN12	63290	DST-UQCS-FBH63	68 to 88	2.677 to 3.465	16	SCMT-1204	TS-5.8-10M1	0.022
DST-63FBC-M82.102-SSDCN12	63291		82 to 102	3.228 to 4.106	23			0.042
DST-63FBC-L96.116-SSDCN12	63292		96 to 116	3.780 to 4.564	30			0.060

- All dimensions are in mm unless otherwise specified.

QUICK-CHANGE ROUGHING BORING HEADS

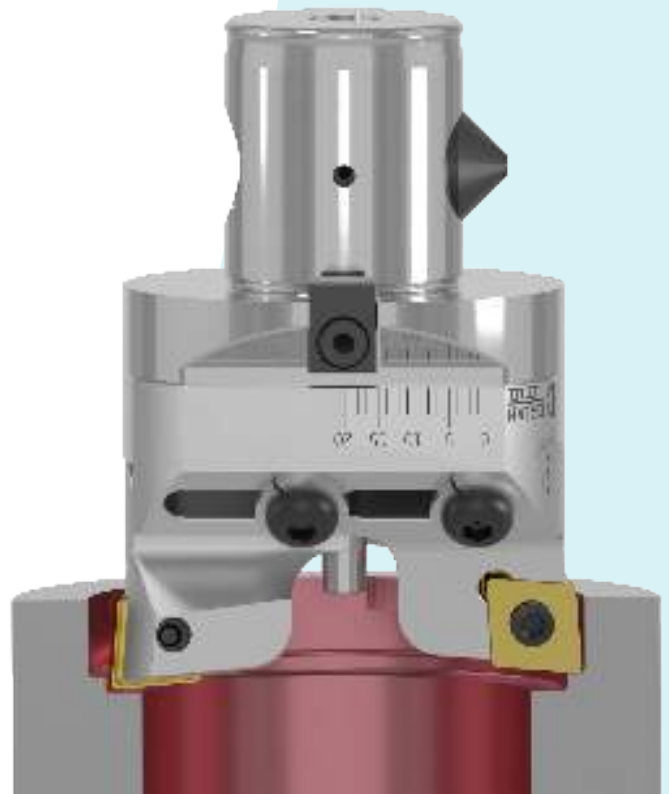


Quick-Change Step Insert Rough Boring Head

- Step Insert Roughing Boring Head has a step for different axial height and cutting diameter.
- First cut Insert for smaller cutting diameter and deeper cut.
- Second cut Insert for Larger cutting diameter and shallow cut.
- Improved chip control in long chipping materials.
- Designed to increase the stock removal rate.

Quick-Change Twin Insert Rough Boring Head

- Twin Insert Roughing Boring Head has the insert set at same axial height and cutting diameter.
- Designed to perform balanced cutting that can speed up cutting process.
- Chips are smaller, broken cleanly in open spaces between insert holders allow perfect chip formation and evacuation.



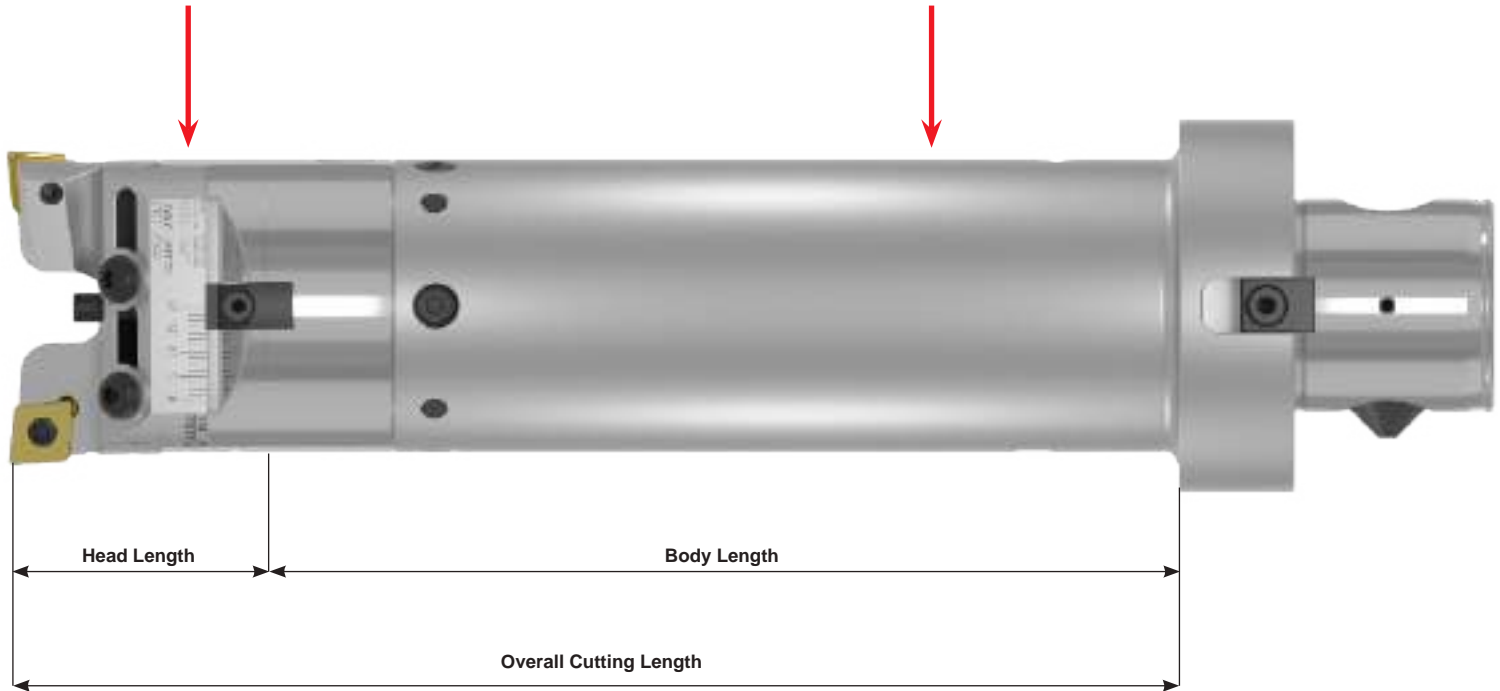
Features and Benefits

- Roughing Boring Head designed for heavy-duty roughing boring, ultimate performance and versatility.
- Unique flexible design with Interchangeable Roughing Boring Arms provides maximum rigidity and highest cutting performance.
- Interchangeable Arms in sizes small, medium, and large with different choice of Inserts covers a diameter range from 68 to 116mm (2.677" to 4.564").
- Corrosion resistant high-quality coating and Through-coolant system supply to the cutting edge for improved tool life.

Overall Cutting Length

Quick-Change Twin Insert Roughing Boring Head

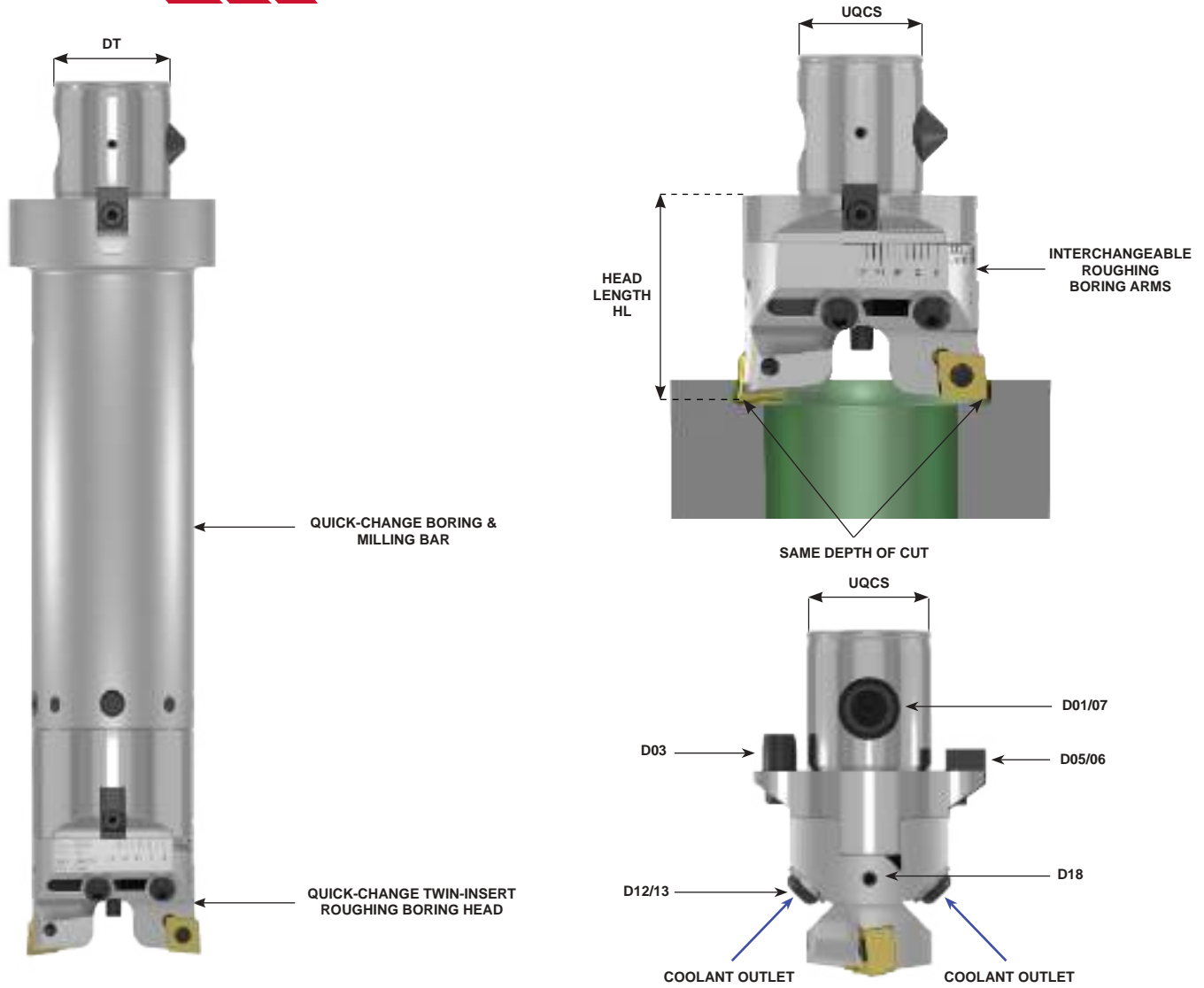
Universal Quick-Change Boring & Milling Bar



*Overall Cutting Length = Body Length + Head Length

QUICK-CHANGE BORING AND MILLING BAR							QUICK-CHANGE TWIN INSERT TOOL HEAD			Overall Cutting Length
Part Number	UPC	Bar Diameter	Boring Ratio	Spindle Connection DT	Body Length	Tool Head Connection UQCS	Part Number	UPC	Head Length	
42mm Quick-Change Boring and Milling Bar with Twin Insert Tool Head										
DST-UQCS42-04 0168-DT63	63100	42	4	DT63	128	UQCS42	DST-UQCS-TRH42	63206	40	168
DST-UQCS42-04 0168-DT80	63056		4	DT80	128					168
DST-UQCS42-06 0252-DT63	63101		6	DT63	212					252
DST-UQCS42-06 0252-DT80	63057		6	DT80	212					252
DST-UQCS42-08 0336-DT63	63102		8	DT63	296					336
DST-UQCS42-08 0336-DT80	63103		8	DT80	296					336
DST-UQCS42-10 0420-DT63	63104		10	DT63	380					420
DST-UQCS42-10 0420-DT80	63105		10	DT80	380					420
50mm Quick-Change Boring and Milling Bar with Twin Insert Tool Head										
DST-UQCS50-04 0200-DT63	63106	50	4	DT63	150	UQCS50	DST-UQCS-TRH50	63207	50	200
DST-UQCS50-04 0200-DT80	63107		4	DT80	150					200
DST-UQCS50-06 0300-DT63	63108		6	DT63	250					300
DST-UQCS50-06 0300-DT80	63109		6	DT80	250					300
DST-UQCS50-08 0400-DT80	63110		8	DT80	350					400
DST-UQCS50-10 0500-DT80	63111		10	DT80	450					500
63mm Quick-Change Boring and Milling Bar with Twin Insert Tool Head										
DST-UQCS63-04 0252-DT63	63112	63	4	DT63	197.05	UQCS63	DST-UQCS-TRH63	63208	54.95	252
DST-UQCS63-04 0252-DT80	63113		4	DT80	197.05					252
DST-UQCS63-06 0378-DT63	63114		6	DT63	323.05					378
DST-UQCS63-06 0378-DT80	63115		6	DT80	323.05					378
DST-UQCS63-08 0504-DT80	63116		8	DT80	449.05					504
DST-UQCS63-10 0630-DT80	63117		10	DT80	575.05					630

- All dimensions are in mm unless otherwise specified.



- Please refer page 24 for Interchangeable Double Insert Arm Set.
 - Please refer page 46 for Spare Parts.

QUICK-CHANGE TWIN INSERT ROUGHING BORING HEAD					INTERCHANGEABLE ROUGHING BORING ARMS									
Part Number	UPC	Tool Head		Tool Head Connection UQCS	Wt. (kg)	Roughing Small Bore Double-Insert Arm Set	Boring Range		Roughing Medium Bore Double-Insert Arm Set	Boring Range		Roughing Large Bore Double-Insert Arm Set	Boring Range	
		D	HL				Metric	Inch		Metric	Inch		Metric	Inch
42mm Quick-Change Twin Insert Roughing Boring Head														
DST-UQCS-TRH42	63206	42	40	UQCS42	0.4	DST-42RBA-S48.61-SCGCL06	48	1.890	DST-42RBA-M58.71-SCGCL06	58	2.283	DST-42RBA-L68.81-SCGCL06	68	2.677
						DST-42RBA-S48.61-SCLCL06	to	to	DST-42RBA-M58.71-SCLCL06	to	to	DST-42RBA-L68.81-SCLCL06	to	to
						DST-42RBA-S48.61-SCRCL06	61	2.402	DST-42RBA-M58.71-SCRCL06	71	2.795	DST-42RBA-L68.81-SCRCL06	81	3.189
50mm Quick-Change Twin Insert Roughing Boring Head														
DST-UQCS-TRH50	63207	50	50	UQCS50	0.55	DST-50RBA-S56.71-SCGCL09	56	2.205	DST-50RBA-M68.83-SCGCL09	68	2.677	DST-50RBA-L80.95-SCGCL09	80	3.150
						DST-50RBA-S56.71-SCLCL09	to	to	DST-50RBA-M68.83-SCLCL09	to	to	DST-50RBA-L80.95-SCLCL09	to	to
						DST-50RBA-S56.71-SCRCL09	71	2.795	DST-50RBA-M68.83-SCRCL09	83	3.268	DST-50RBA-L80.95-SCRCL09	95	3.740
63mm Quick-Change Twin Insert Roughing Boring Head														
DST-UQCS-TRH63	63208	63	54.95	UQCS63	0.8	DST-63RBA-S69.89-SCGNL12	69	2.717	DST-63RBA-M82.102-SCGNL12	82	3.228	DST-63RBA-L96.116-SCGNL12	96	3.780
						DST-63RBA-S69.89-SCRNL12	to	to	DST-63RBA-M82.102-SCRNL12	to	to	DST-63RBA-L96.116-SCRNL12	to	to
						DST-63RBA-S69.89-SCGCL12	to	3.504	DST-63RBA-M82.102-SCGCL12	to	4.106	DST-63RBA-L96.116-SCGCL12	to	4.564
						DST-63RBA-S69.89-SCLCL12	89		DST-63RBA-M82.102-SCLCL12	102		DST-63RBA-L96.116-SCLCL12	116	

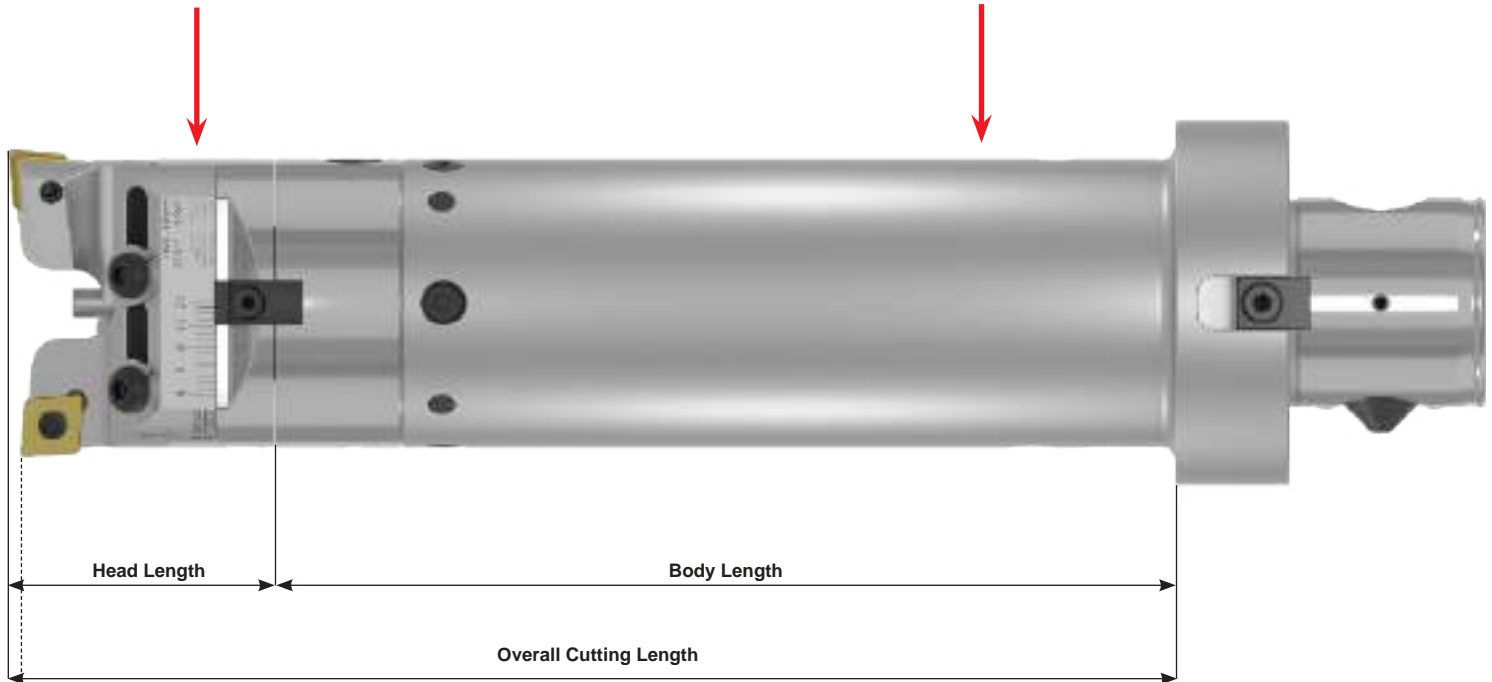
- All dimensions are in mm unless otherwise specified.



Overall Cutting Length

Quick-Change Step Insert
Roughing Boring Head

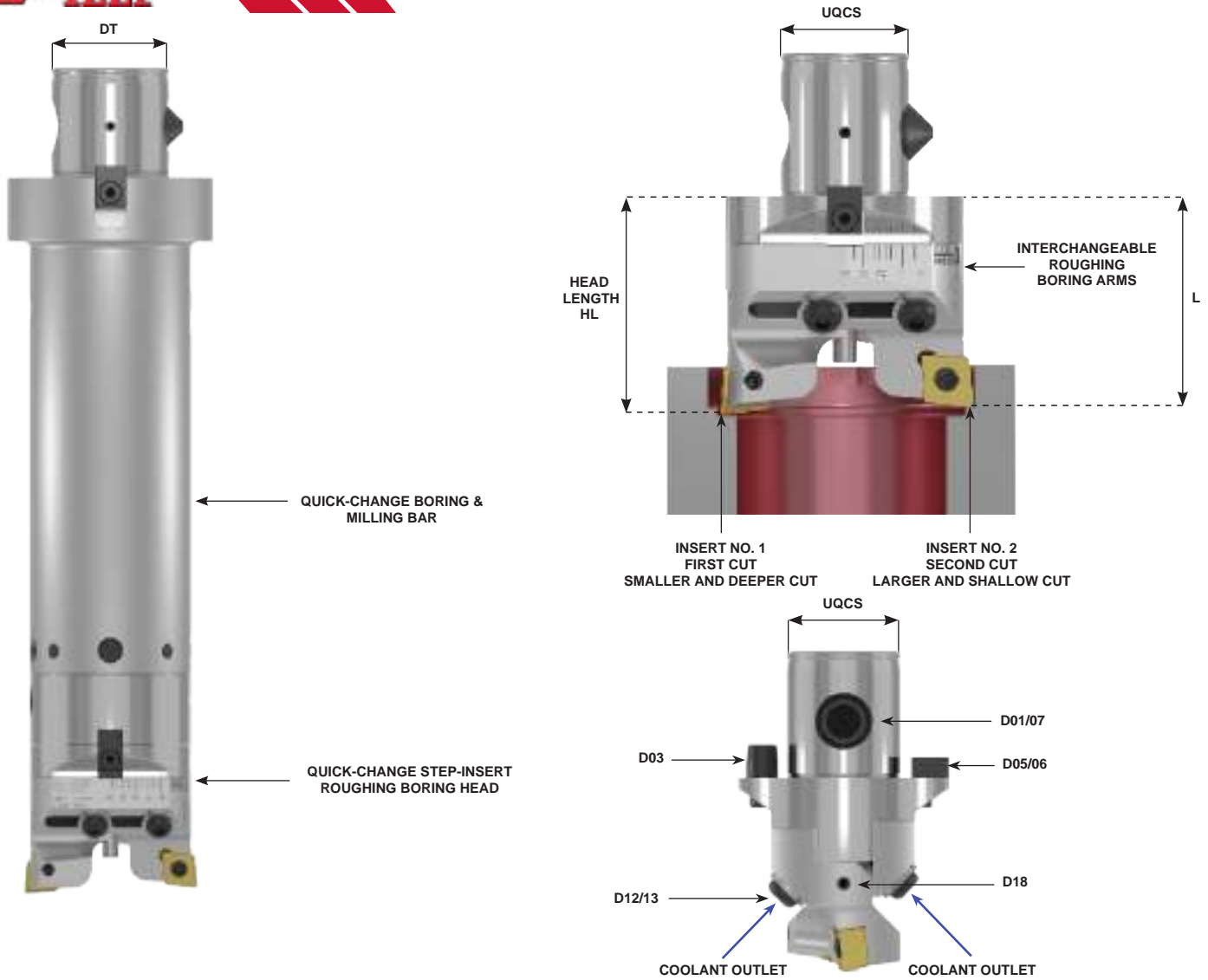
Universal Quick-Change Boring & Milling Bar



*Overall Cutting Length = Body Length + Head Length

QUICK-CHANGE BORING AND MILLING BAR							QUICK-CHANGE STEP INSERT TOOL HEAD			Overall Cutting Length
Part Number	UPC	Bar Diameter	Boring Ratio	Spindle Connection DT	Body Length	Tool Head Connection UQCS	Part Number	UPC	Head Length	
42mm Quick-Change Boring and Milling Bar with Step Insert Tool Head										
DST-UQCS42-04 0168-DT63	63100	42	4	DT63	128	UQCS42	DST-UQCS-SRH42	63214	40	168
DST-UQCS42-04 0168-DT80	63056		4	DT80	128					168
DST-UQCS42-06 0252-DT63	63101		6	DT63	212					252
DST-UQCS42-06 0252-DT80	63057		6	DT80	212					252
DST-UQCS42-08 0336-DT63	63102		8	DT63	296					336
DST-UQCS42-08 0336-DT80	63103		8	DT80	296					336
DST-UQCS42-10 0420-DT63	63104		10	DT63	380					420
DST-UQCS42-10 0420-DT80	63105		10	DT80	380					420
50mm Quick-Change Boring and Milling Bar with Step Insert Tool Head										
DST-UQCS50-04 0200-DT63	63106	50	4	DT63	150	UQCS50	DST-UQCS-SRH50	63215	50	200
DST-UQCS50-04 0200-DT80	63107		4	DT80	150					200
DST-UQCS50-06 0300-DT63	63108		6	DT63	250					300
DST-UQCS50-06 0300-DT80	63109		6	DT80	250					300
DST-UQCS50-08 0400-DT80	63110		8	DT80	350					400
DST-UQCS50-10 0500-DT80	63111		10	DT80	450					500
63mm Quick-Change Boring and Milling Bar with Step Insert Tool Head										
DST-UQCS63-04 0252-DT63	63112	63	4	DT63	197.05	UQCS63	DST-UQCS-SRH63	63216	54.95	252
DST-UQCS63-04 0252-DT80	63113		4	DT80	197.05					252
DST-UQCS63-06 0378-DT63	63114		6	DT63	323.05					378
DST-UQCS63-06 0378-DT80	63115		6	DT80	323.05					378
DST-UQCS63-08 0504-DT80	63116		8	DT80	449.05					504
DST-UQCS63-10 0630-DT80	63117		10	DT80	575.05					630

- All dimensions are in mm unless otherwise specified.

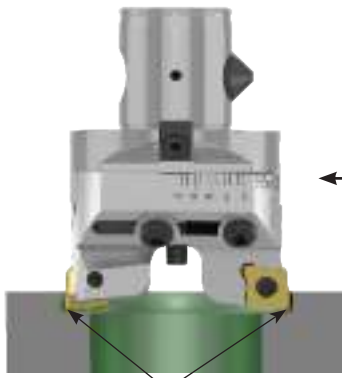


- Please refer page 24 for Interchangeable Double Insert Arm Set.
 - Please refer page 47 for Spare Parts.

QUICK-CHANGE STEP INSERT ROUGHING BORING HEAD SPECIFICATIONS					INTERCHANGEABLE ROUGHING BORING ARMS										
Part Number	UPC	Tool Head			Tool Head Connection UQCS	Wt. (kg)	Roughing Small Bore Double-Insert Arm Set		Roughing Medium Bore Double-Insert Arm Set		Roughing Large Bore Double-Insert Arm Set		Boring Range		
		D	L	HL			Metric	Inch	Metric	Inch	Metric	Inch	Metric	Inch	
42mm Quick-Change Step Insert Roughing Boring Head															
DST-UQCS-SRH42	63214	42	39.8	40	UQCS42	0.45	DST-42RBA-S48.61-SCGCL06	48	1.890	DST-42RBA-M58.71-SCGCL06	58	2.283	DST-42RBA-L68.81-SCGCL06	68	2.677
							DST-42RBA-S48.61-SCLCL06	to	to	DST-42RBA-M58.71-SCLCL06	to	to	DST-42RBA-L68.81-SCLCL06	to	to
							DST-42RBA-S48.61-SCRCL06	61	2.402	DST-42RBA-M58.71-SCRCL06	71	2.795	DST-42RBA-L68.81-SCRCL06	81	3.189
50mm Quick-Change Step Insert Roughing Boring Head															
DST-UQCS-SRH50	63215	50	49.75	50	UQCS50	0.60	DST-50RBA-S56.71-SCGCL09	56	2.205	DST-50RBA-M68.83-SCGCL09	68	2.677	DST-50RBA-L80.95-SCGCL09	80	3.150
							DST-50RBA-S56.71-SCLCL09	to	to	DST-50RBA-M68.83-SCLCL09	to	to	DST-50RBA-L80.95-SCLCL09	to	to
							DST-50RBA-S56.71-SCRCL09	71	2.795	DST-50RBA-M68.83-SCRCL09	83	3.268	DST-50RBA-L80.95-SCRCL09	95	3.740
63mm Quick-Change Step Insert Roughing Boring Head															
DST-UQCS-SRH63	63216	63	54.65	54.95	UQCS63	0.85	DST-63RBA-S69.89-SCGNL12	69	2.717	DST-63RBA-M82.102-SCGNL12	82	3.228	DST-63RBA-L96.116-SCGNL12	96	3.780
							DST-63RBA-S69.89-SCRNL12	to	to	DST-63RBA-M82.102-SCRNL12	to	to	DST-63RBA-L96.116-SCRNL12	to	to
							DST-63RBA-S69.89-SCGCL12	to	to	DST-63RBA-M82.102-SCGCL12	to	to	DST-63RBA-L96.116-SCGCL12	to	to
							DST-63RBA-S69.89-SCLCL12	89	3.504	DST-63RBA-M82.102-SCLCL12	102	4.106	DST-63RBA-L96.116-SCLCL12	116	4.564

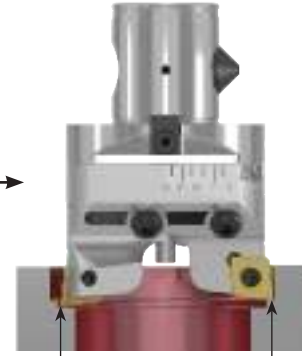
- All dimensions are in mm unless otherwise specified.





SAME DEPTH OF CUT

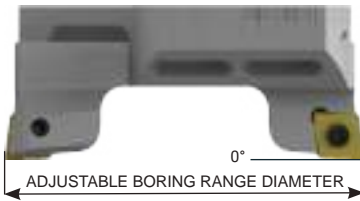
QUICK-CHANGE TWIN-INSERT ROUGHING BORING HEAD



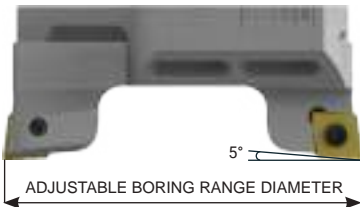
INSERT NO. 1 FIRST CUT SMALLER AND DEEPER CUT **INSERT NO. 2 SECOND CUT LARGER AND SHALLOW CUT**

QUICK-CHANGE STEP-INSERT ROUGHING BORING HEAD

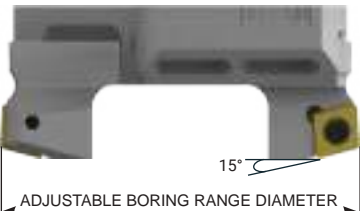
- Please refer page 46 and 47 for D12/13 and D18



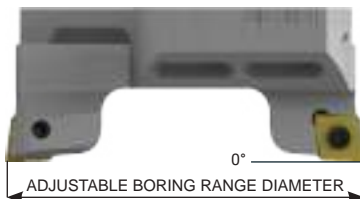
0°
ADJUSTABLE BORING RANGE DIAMETER



5°
ADJUSTABLE BORING RANGE DIAMETER



15°
ADJUSTABLE BORING RANGE DIAMETER



0°
ADJUSTABLE BORING RANGE DIAMETER

INTERCHANGEABLE ROUGHING BORING ARMS SPECIFICATIONS

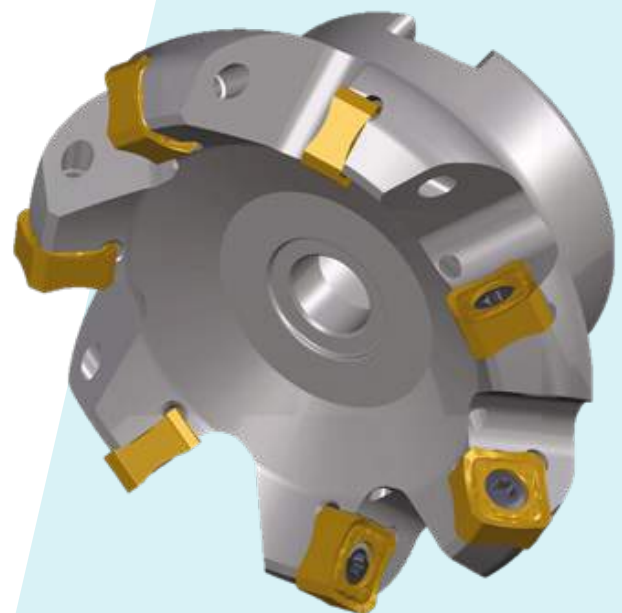
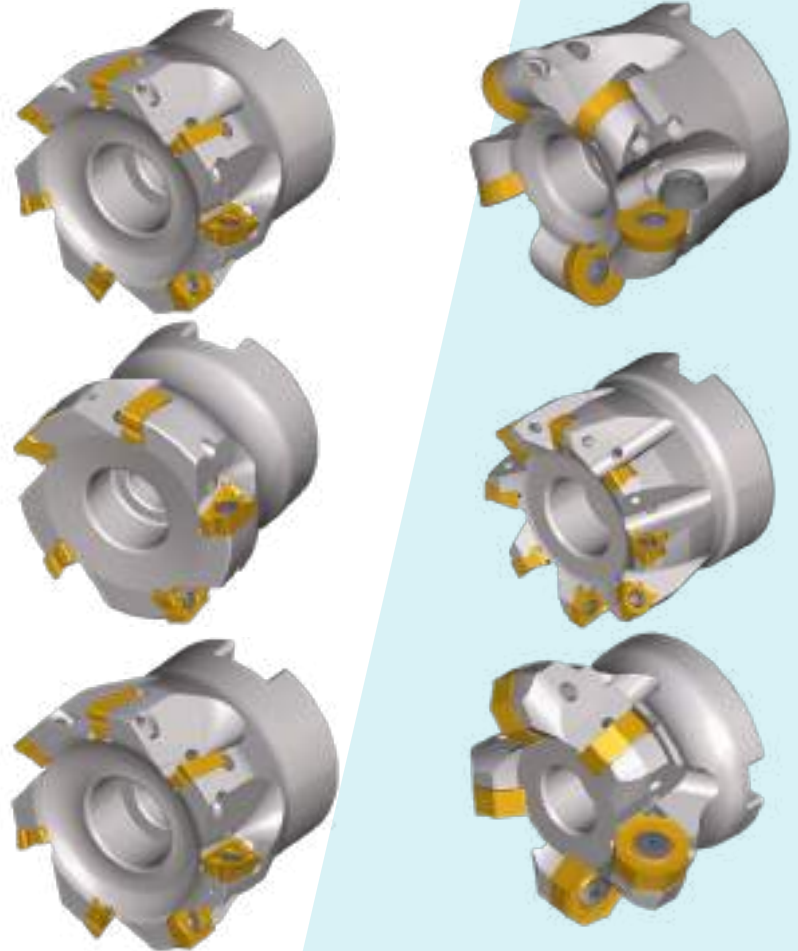
Part Number	UPC	Quick-Change Roughing Boring Head	Boring Range		Insert		Wt. (kg)
			Metric	Inch	Geometry	Screw	
42mm SCGCL06 0°, Roughing Boring Head Arm Set							
DST-42RBA-S48.81-SCGCL06	63227	DST-UQCS-TRH42 DST-UQCS-SRH42	48 to 61	1.890 to 2.402	CCMT-0602	TS-25.45-6M2	0.240
DST-42RBA-M58.71-SCGCL06	63228		58 to 71	2.283 to 2.795			0.290
DST-42RBA-L68.81-SCGCL06	63229		68 to 81	2.677 to 3.189			0.340
50mm SCGCL09 0°, Roughing Boring Head Arm Set							
DST-50RBA-S56.71-SCGCL09	63236	DST-UQCS-TRH50 DST-UQCS-SRH50	56 to 71	2.205 to 2.795	CCMT-09T304	TS-4.7-8M1	0.280
DST-50RBA-M68.83-SCGCL09	63237		68 to 83	2.677 to 3.268			0.350
DST-50RBA-L80.95-SCGCL09	63238		80 to 95	3.150 to 3.740			0.400
63mm SCGCL12 0°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCGCL12	63251	DST-UQCS-TRH63 DST-UQCS-SRH63	69 to 89	2.717 to 3.504	CCMT-1204	TS-5.8-10M1	0.330
DST-63RBA-M82.102-SCGCL12	63252		82 to 102	3.228 to 4.106			0.440
DST-63RBA-L96.116-SCGCL12	63253		96 to 116	3.780 to 4.564			0.500
42mm SCLCL06 5°, Roughing Boring Head Arm Set							
DST-RBA42-S48.61-SCLCL06	63230	DST-UQCS-TRH42 DST-UQCS-SRH42	48 to 61	1.890 to 2.402	CCMT-0602	TS-25.45-6M2	0.240
DST-RBA42-M58.71-SCLCL06	63231		58 to 71	2.283 to 2.795			0.290
DST-RBA42-L68.81-SCLCL06	63232		68 to 81	2.677 to 3.189			0.340
50mm SCLCL09 5°, Roughing Boring Head Arm Set							
DST-50RBA-S56.71-SCLCL09	63239	DST-UQCS-TRH50 DST-UQCS-SRH50	56 to 71	2.205 to 2.795	CCMT-09T304	TS-4.7-8M1	0.280
DST-50RBA-M68.83-SCLCL09	63240		68 to 83	2.677 to 3.268			0.350
DST-50RBA-L80.95-SCLCL09	63241		80 to 95	3.150 to 3.740			0.400
63mm SCLCL12 5°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCLCL12	63254	DST-UQCS-TRH63 DST-UQCS-SRH63	69 to 89	2.717 to 3.504	CCMT-1204	TS-5.8-10M1	0.280
DST-63RBA-M82.102-SCLCL12	63255		82 to 102	3.228 to 4.106			0.350
DST-63RBA-L96.116-SCLCL12	63256		96 to 116	3.780 to 4.564			0.400
42mm SCRCL06 15°, Roughing Boring Head Arm Set							
DST-42RBA-S48.61-SCRCL06	63233	DST-UQCS-TRH42 DST-UQCS-SRH42	48 to 61	1.890 to 2.402	CCMT-0602	TS-25.45-6M2	0.240
DST-42RBA-M58.71-SCRCL06	63234		58 to 71	2.283 to 2.795			0.290
DST-42RBA-L68.81-SCRCL06	63235		68 to 81	2.677 to 3.189			0.340
50mm SCRCL09 15°, Roughing Boring Head Arm Set							
DST-50RBA-S56.71-SCRCL09	63242	DST-UQCS-TRH50 DST-UQCS-SRH50	56 to 71	2.205 to 2.795	CCMT-09T304	TS-4.7-8M1	0.280
DST-50RBA-M68.83-SCRCL09	63243		68 to 83	2.677 to 3.268			0.350
DST-50RBA-L80.95-SCRCL09	63244		80 to 95	3.150 to 3.740			0.400
63mm SCRNL12 15°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCRNL12	63248	DST-UQCS-TRH63 DST-UQCS-SRH63	69 to 89	2.717 to 3.504	CNMG-1204	TS-1032-5M1	0.280
DST-63RBA-M80.102-SCRNL12	63249		82 to 102	3.228 to 4.106			0.350
DST-63RBA-L96.116-SCRNL12	63250		96 to 116	3.780 to 4.564			0.400
63mm SCGNL12 0°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCGNL12	63245	DST-UQCS-TRH63 DST-UQCS-SRH63	69 to 89	2.717 to 3.504	CNMG-1204	TS-1032-5M1	0.280
DST-63RBA-M82.102-SCGNL12	63246		82 to 102	3.228 to 4.106			0.350
DST-63RBA-L96.116-SCGNL12	63247		96 to 116	3.780 to 4.564			0.400

- All dimensions are in mm unless otherwise specified.

QUICK-CHANGE FACE MILL ADAPTOR & MILLING CUTTERS



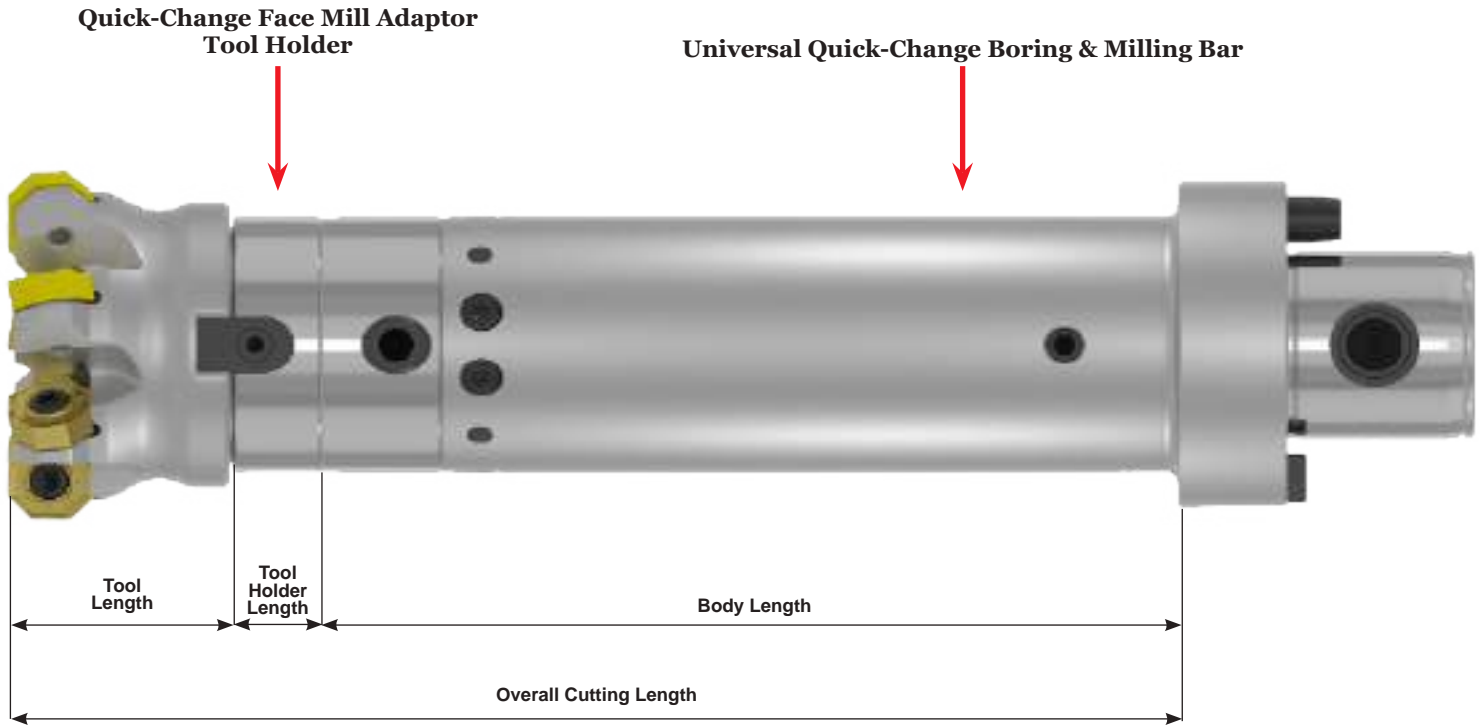
Face Mill Connection



- Face Mill Adaptor System has a modular construction making it simple and easier to switch different milling cutters.
- Covers a broad range of heavy machining milling applications.
- Highly efficient performance in rough to fine milling applications.
- Perfectly balanced during high speed milling.
- Heavy duty driving keys for higher torque transfer.
- Top quality coating on Tool Head Body guarantees the very best corrosion protection and dependability.
- Through-coolant system supply to the cutting edge for improved tool life.

Quick-Change Face Mill Adaptor System

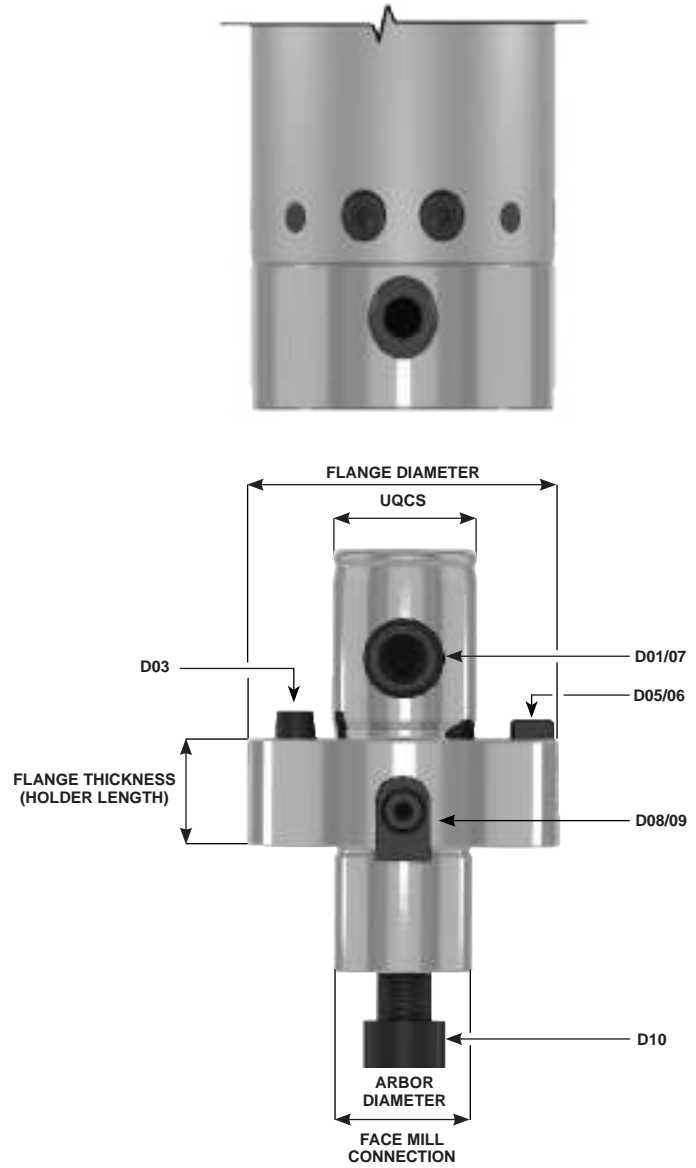
Overall Cutting Length



- Please check for Tool Length with the Manufacturer's specification.
- Overall Cutting Length = Body Length + Tool Holder Length + Tool Length
- The minimum tool length is mentioned to have a nominal boring length according to the boring ratio.
- The maximum tool length will vary according to the machining material and the diameter of the face mill.

QUICK-CHANGE BORING AND MILLING BAR							QUICK-CHANGE FACE MILL ADAPTOR SYSTEM				Overall Cutting Length
Part Number	UPC	Bar Diameter	Boring Ratio	Spindle Connection DT	Body Length	Tool Head Connection UQCS	Part Number	UPC	Holder Length	Minimum Tool Length	
42mm Quick-Change Boring and Milling Bar with Face Mill Tool Holder											
DST-UQCS42-04 0168-DT63	63100	42	4	DT63	128	UQCS42	DST-UQCS-FMA42-M13 DST-UQCS-FMA42-M16 DST-UQCS-FMA42-M22	63300 63301 63302	13	27	168
DST-UQCS42-04 0168-DT80	63056		4	DT80	128						168
DST-UQCS42-06 0252-DT63	63101		6	DT63	212						252
DST-UQCS42-06 0252-DT80	63057		6	DT80	212						252
DST-UQCS42-08 0336-DT63	63102		8	DT63	296						336
DST-UQCS42-08 0336-DT80	63103		8	DT80	296						336
DST-UQCS42-10 0420-DT63	63104		10	DT63	380						420
DST-UQCS42-10 0420-DT80	63105		10	DT80	380						420
50mm Quick-Change Boring and Milling Bar with Face Mill Tool Holder											
DST-UQCS50-04 0200-DT63	63106	50	4	DT63	150	UQCS50	DST-UQCS-FMA50-M16 DST-UQCS-FMA50-M22 DST-UQCS-FMA50-M27	63303 63304 63305	16	34	200
DST-UQCS50-04 0200-DT80	63107		4	DT80	150						200
DST-UQCS50-06 0300-DT63	63108		6	DT63	250						300
DST-UQCS50-06 0300-DT80	63109		6	DT80	250						300
DST-UQCS50-08 0400-DT80	63110		8	DT80	350						400
DST-UQCS50-10 0500-DT80	63111		10	DT80	450						500
63mm Quick-Change Boring and Milling Bar with Face Mill Tool Holder											
DST-UQCS63-04 0252-DT63	63112	63	4	DT63	197.05	UQCS63	DST-UQCS-FMA63-M16 DST-UQCS-FMA63-M22 DST-UQCS-FMA63-M27 DST-UQCS-FMA63-M32 DST-UQCS-FMA63-M40	63306 63307 63308 63309 63310	21	33.95	252
DST-UQCS63-04 0252-DT80	63113		4	DT80	197.05						252
DST-UQCS63-06 0378-DT63	63114		6	DT63	323.05						378
DST-UQCS63-06 0378-DT80	63115		6	DT80	323.05						378
DST-UQCS63-08 0504-DT80	63116		8	DT80	449.05						504
DST-UQCS63-10 0630-DT80	63117		10	DT80	575.05						630

- All dimensions are in mm unless otherwise specified.



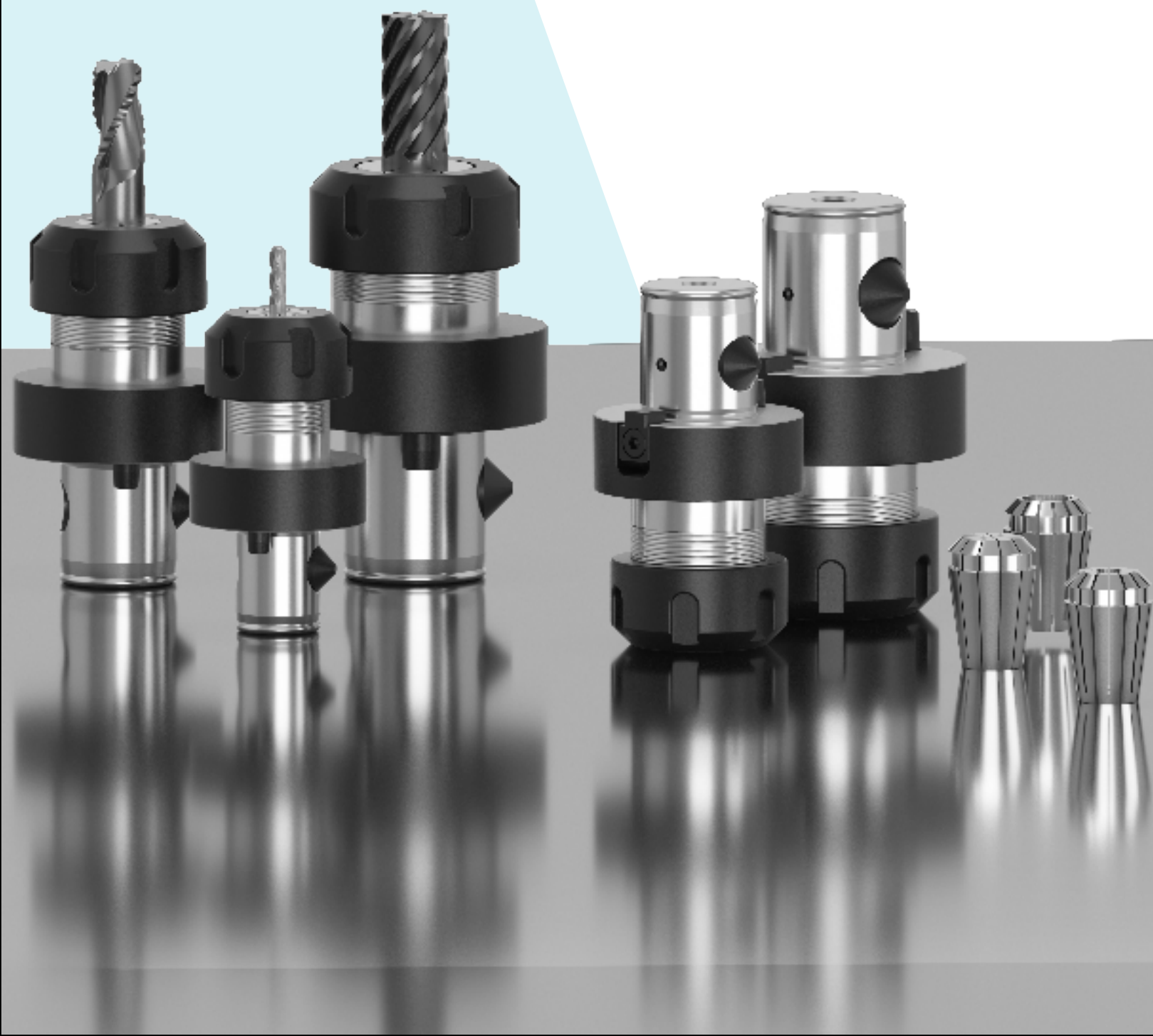
METRIC						
QUICK-CHANGE FACE MILL ADAPTOR						
Part Number	UPC	Tool Head Connection UQCS	Arbor Diameter	Flange Diameter	Flange Thickness	Weight (kg)
42mm-Quick-Change Face Mill Adaptor						
DST-UQCS-FMA42-M13	63300	UQCS42	13	42	13	0.28
DST-UQCS-FMA42-M16	63301		16			0.28
DST-UQCS-FMA42-M22	63302		22			0.33
50mm-Quick-Change Face Mill Adaptor						
DST-UQCS-FMA50-M16	63303	UQCS50	16	50	16	0.48
DST-UQCS-FMA50-M22	63304		22			0.50
DST-UQCS-FMA50-M27	63305		27			0.58
63mm-Quick-Change Face Mill Adaptor						
DST-UQCS-FMA63-M16	63306	UQCS63	16	63	21	0.78
DST-UQCS-FMA63-M22	63307		22			0.87
DST-UQCS-FMA63-M27	63308		27			0.90
DST-UQCS-FMA63-M32	63309		32			0.93
DST-UQCS-FMA63-M40	63310		40			1.68

INCH						
QUICK-CHANGE FACE MILL ADAPTOR						
Part Number	UPC	Tool Head Connection UQCS	Arbor Diameter	Flange Diameter	Flange Thickness	Weight (kg)
42mm-Quick-Change Face Mill Adaptor						
DST-UQCS-FMA42-I0750	63293	UQCS42	0.750	1.654	0.591	0.32
DST-UQCS-FMA42-I1000	63294		1.000	1.654		0.35
50mm-Quick-Change Face Mill Adaptor						
DST-UQCS-FMA50-I0750	63295	UQCS50	0.750	1.969	0.630	0.49
DST-UQCS-FMA50-I1000	63296		1.000	1.969		0.58
63mm-Quick-Change Face Mill Adaptor						
DST-UQCS-FMA63-I0750	63297	UQCS63	0.750	2.480	0.827	0.87
DST-UQCS-FMA63-I1000	63298		1.000	2.480		0.90
DST-UQCS-FMA63-I1500	63299		1.500	3.750		1.53

- Please check with the Manufacturer's specification for Face Mill Length.
 - Please refer page 48 for Spare Parts.
 - All dimensions are in mm unless otherwise specified.



TECHNOLOGY, QUALITY & PERFORMANCE



QUICK-CHANGE END MILL TOOL HOLDER

HIGH PERFORMANCE
EXTREME RIGIDITY
FLEXIBILITY
ACCURACY
VERSATILITY
EFFICIENCY



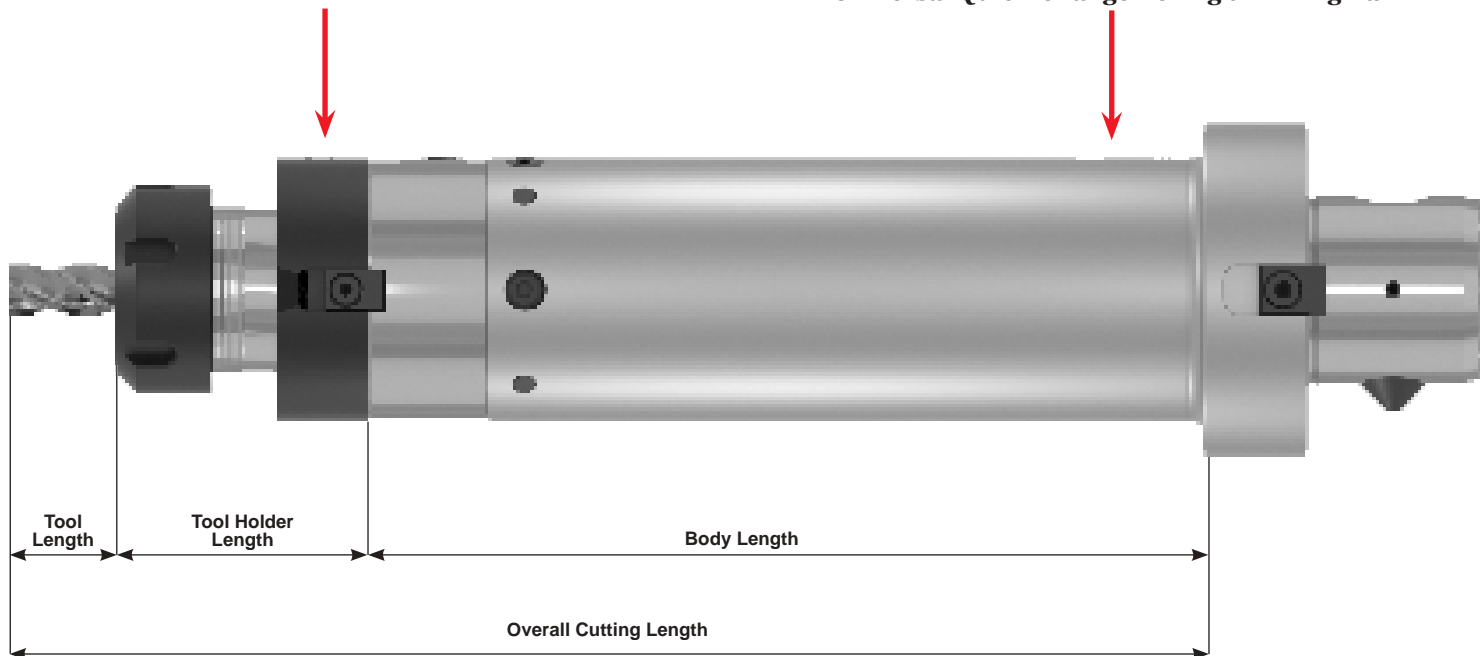
Features and Benefits

- Quick-Change End Mill Tool Holder offers flexibility and durability which eliminates extra operations and maximizes efficiency.
- Ultra precision ER collets available in ER 20, ER 25, and ER 32 sizes provide highest gripping force and concentricity to improve the life and performance of the cutting tools.
- Top quality coating on Tool Head Body guarantees the very best corrosion protection and dependability.
- Through-coolant system supply to the cutting edge for improved tool life.

Overall Cutting Length

Quick-Change End Mill Tool Holder

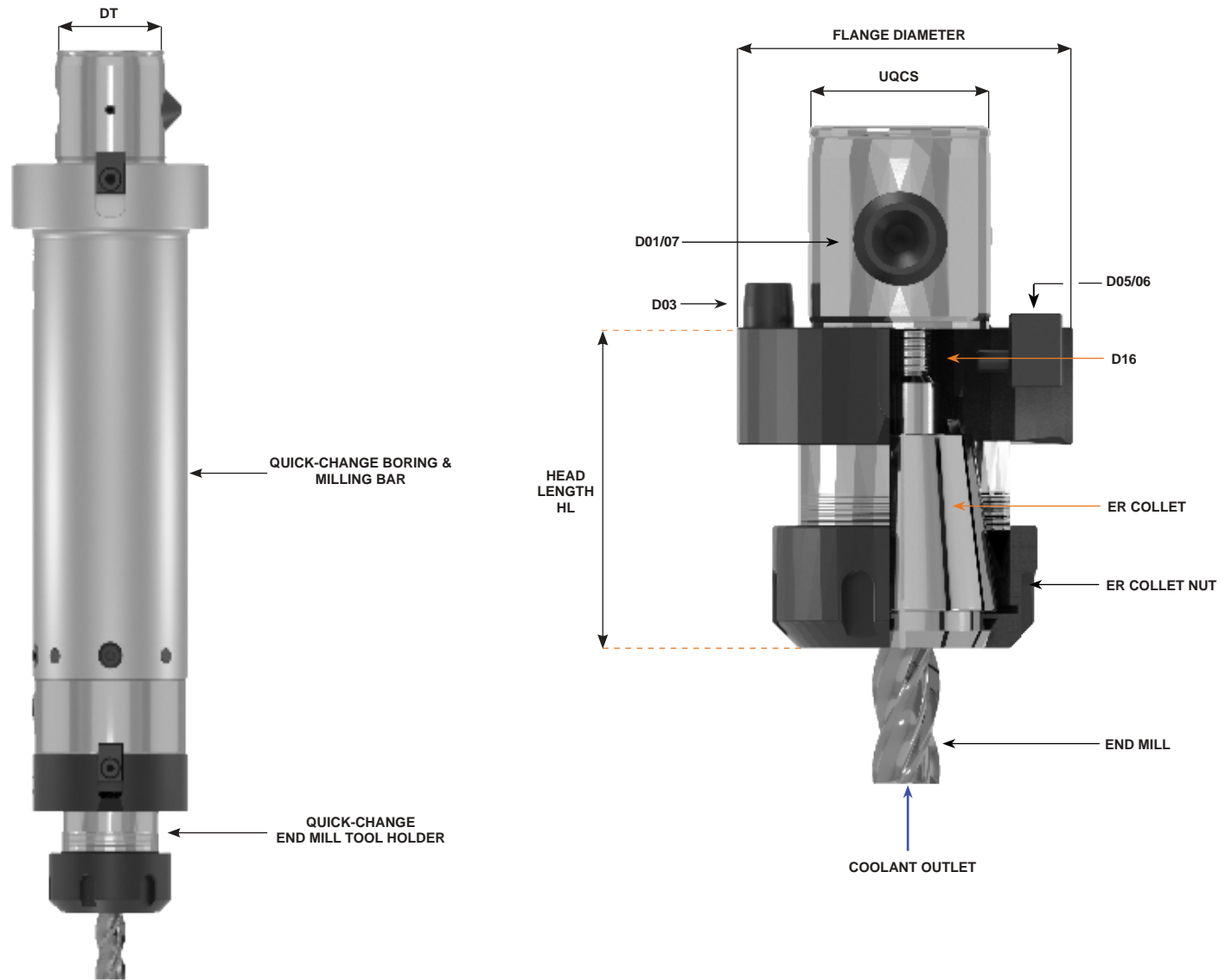
Universal Quick-Change Boring & Milling Bar



- Please check for Tool Length with the Manufacturer's specification.
- Overall Cutting Length = Body Length + Tool Holder Length + Tool Length
- The minimum tool length is mentioned to have a nominal boring length according to the boring ratio.
- The maximum tool length will vary according to the machining material and the diameter of the end mill.

QUICK-CHANGE BORING AND MILLING BAR						QUICK END MILL TOOL HOLDER				Overall Cutting Length	
Part Number	UPC	Bar Diameter	Boring Ratio	Spindle Connection DT	Body Length	Tool Head Connection UQCS	Part Number	UPC	Holder Length		Minimum Tool Length
42mm Quick-Change Boring and Milling Bar with End Mill Tool Holder											
DST-UQCS42-04 0168-DT63	63100	42	4	DT63	128	UQCS42	DST-UQCS-EMH42-ER20	63222	50	8.5	186.5
DST-UQCS42-04 0168-DT80	63056		4	DT80	128						186.5
DST-UQCS42-06 0252-DT63	63101		6	DT63	212						270.5
DST-UQCS42-06 0252-DT80	63057		6	DT80	212						270.5
DST-UQCS42-08 0336-DT63	63102		8	DT63	296						354.5
DST-UQCS42-08 0336-DT80	63103		8	DT80	296						354.5
DST-UQCS42-10 0420-DT63	63104		10	DT63	380						438.5
DST-UQCS42-10 0420-DT80	63105		10	DT80	380						438.5
50mm Quick-Change Boring and Milling Bar with End Mill Tool Holder											
DST-UQCS50-04 0200-DT63	63106	50	4	DT63	150	UQCS50	DST-UQCS-EMH50-ER25	63223	55	15	220
DST-UQCS50-04 0200-DT80	63107		4	DT80	150						220
DST-UQCS50-06 0300-DT63	63108		6	DT63	250						320
DST-UQCS50-06 0300-DT80	63109		6	DT80	250						320
DST-UQCS50-08 0400-DT80	63110		8	DT80	350						420
DST-UQCS50-10 0500-DT80	63111		10	DT80	450						520
63mm Quick-Change Boring and Milling Bar with End Mill Tool Holder											
DST-UQCS63-04 0252-DT63	63112	63	4	DT63	197.05	UQCS63	DST-UQCS-EMH63-ER32	63224	60	20	277.05
DST-UQCS63-04 0252-DT80	63113		4	DT80	197.05						277.05
DST-UQCS63-06 0378-DT63	63114		6	DT63	323.05						403.05
DST-UQCS63-06 0378-DT80	63115		6	DT80	323.05						403.05
DST-UQCS63-08 0504-DT80	63116		8	DT80	449.05						529.05
DST-UQCS63-10 0630-DT80	63117		10	DT80	575.05						655.05

- All dimensions are in mm unless otherwise specified.



- Please refer page 49 for Spare Parts.

QUICK-CHANGE END MILL TOOL HOLDER							ULTRA PRECISION ER COLLETS				
Part Number	UPC	Bar Diameter	Flange Diameter	Head Length HL	Tool Head Connection UQCS	Weight (kg)	ER Collet	Size	Range		
									Metric	Inch	
42mm Quick-Change ER20 Tool Holder											
DST-UQCS-EMH42-ER20	63222	42	42	50	UQCS42	0.6	ER20-STIMC	20	0.5 to 13	0.020 to 0.512	
50mm Quick-Change ER25 Tool Holder											
DST-UQCS-EMH50-ER25	63223	50	50	55	UQCS50	0.8	ER25-STIMC	25	0.5 to 16	0.020 to 0.630	
63mm Quick-Change ER32 Tool Holder											
DST-UQCS-EMH63-ER32	63224	63	63	60	UQCS63	1.2	ER32-STIMC	32	1.5 to 20	0.059 to 0.787	

- All dimensions are in mm unless otherwise specified.

ULTRA PRECISION ER COLLETS

- Evenly distributed cutting edges for high performance machining.
- 16 slots, deburred and polished.
- Increased grip force with reduced friction to collet seat.
- Improve system performance and lower cost per piece when used with a quality chuck.

16 Slits for Uniform Gripping



Ultra Precision 0.0002" TIR



ULTRA PRECISION ER 20 COLLETS

Part Number	UPC	Metric Range	Inch Range
ER20-STIMC-10	46353	0.5 to 1	0.020 to 0.039
ER20-STIMC-15	46354	1 to 1.5	0.039 to 0.059
ER20-STIMC-20	46355	1.5 to 2	0.059 to 0.079
ER20-STIMC-30	46356	2 to 3	0.079 to 0.118
ER20-STIMC-0937	46386	1.9 to 2.4	0.075 to 0.094
ER20-STIMC-0125	46387	2.2 to 3.2	0.087 to 0.125
ER20-STIMC-40	46358	3 to 4	0.118 to 0.157
ER20-STIMC-0187	46388	3.8 to 4.8	0.150 to 0.188
ER20-STIMC-50	46359	4 to 5	0.157 to 0.197
ER20-STIMC-60	46360	5 to 6	0.197 to 0.236
ER20-STIMC-0250	46389	5.4 to 6.4	0.213 to 0.250
ER20-STIMC-70	46361	6 to 7	0.236 to 0.276
ER20-STIMC-80	46362	7 to 8	0.276 to 0.315
ER20-STIMC-90	46363	8 to 9	0.315 to 0.354
ER20-STIMC-375	46390	8.5 to 9.5	0.335 to 0.375
ER20-STIMC-100	46364	9 to 10	0.354 to 0.394
ER20-STIMC-110	46365	10 to 11	0.394 to 0.433
ER20-STIMC-120	46367	11 to 12	0.433 to 0.472
ER20-STIMC-0500	46391	11.7 to 12.7	0.461 to 0.500
ER20-STIMC-130	46368	12 to 13	0.472 to 0.512

ULTRA PRECISION ER 25 COLLETS

Part Number	UPC	Metric Range	Inch Range
ER25-STIMC-10	46428	0.5 to 1	0.020 to 0.039
ER25-STIMC-15	46429	1 to 1.5	0.039 to 0.059
ER25-STIMC-20	46430	1.5 to 2	0.059 to 0.079
ER25-STIMC-0937	46499	2 to 3	0.079 to 0.118
ER25-STIMC-30	46431	1.9 to 2.4	0.075 to 0.094
ER25-STIMC-0125	46500	2.2 to 3.2	0.087 to 0.125
ER25-STIMC-40	46433	3 to 4	0.118 to 0.157
ER25-STIMC-0187	46501	3.8 to 4.8	0.150 to 0.188
ER25-STIMC-50	46434	4 to 5	0.157 to 0.197
ER25-STIMC-60	46435	5 to 6	0.197 to 0.236
ER25-STIMC-0250	46502	5.4 to 6.4	0.213 to 0.250
ER25-STIMC-70	46436	6 to 7	0.236 to 0.276
ER25-STIMC-80	46437	7 to 8	0.276 to 0.315
ER25-STIMC-90	46438	8 to 9	0.315 to 0.354
ER25-STIMC-0375	46503	8.5 to 9.5	0.335 to 0.375
ER25-STIMC-100	46439	9 to 10	0.354 to 0.394
ER25-STIMC-110	46440	10 to 11	0.394 to 0.433
ER25-STIMC-120	46442	11 to 12	0.433 to 0.472
ER25-STIMC-0500	46517	11.7 to 12.7	0.461 to 0.500
ER25-STIMC-130	46443	12 to 13	0.472 to 0.512
ER25-STIMC-140	46444	13 to 14	0.512 to 0.551
ER25-STIMC-150	46445	14 to 15	0.551 to 0.591
ER25-STIMC-0625	46518	14.9 to 15.9	0.586 to 0.625
ER25-STIMC-160	46446	15 to 16	0.591 to 0.63

ULTRA PRECISION ER 32 COLLETS

Part Number	UPC	Metric Range	Inch Range
ER32-STIMC-20	46521	1.5 to 2	0.059 to 0.079
ER32-STIMC-0937	46543	1.9 to 2.4	0.075 to 0.094
ER32-STIMC-30	46522	2 to 3	0.079 to 0.118
ER32-STIMC-0125	46544	2.2 to 3.2	0.086 to 0.125
ER32-STIMC-40	46524	3 to 4	0.118 to 0.157
ER32-STIMC-0187	46545	3.8 to 4.8	0.148 to 0.188
ER32-STIMC-50	46525	4 to 5	0.157 to 0.197
ER32-STIMC-60	46526	5 to 6	0.197 to 0.236
ER32-STIMC-0250	46546	5.4 to 6.4	0.211 to 0.25
ER32-STIMC-70	46527	6 to 7	0.236 to 0.276
ER32-STIMC-80	46528	7 to 8	0.276 to 0.315
ER32-STIMC-90	46529	8 to 9	0.315 to 0.354
ER32-STIMC-0375	46547	8.5 to 9.5	0.336 to 0.375
ER32-STIMC-100	46530	9 to 10	0.354 to 0.394
ER32-STIMC-110	46531	10 to 11	0.394 to 0.433
ER32-STIMC-120	46533	11 to 12	0.433 to 0.472
ER32-STIMC-0500	46569	11.7 to 12.7	0.461 to 0.5
ER32-STIMC-130	46534	12 to 13	0.472 to 0.512
ER32-STIMC-140	46535	13 to 14	0.512 to 0.551
ER32-STIMC-150	46536	14 to 15	0.551 to 0.591
ER32-STIMC-0625	46570	14.9 to 15.9	0.586 to 0.625
ER32-STIMC-160	46537	15 to 16	0.591 to 0.63
ER32-STIMC-170	46538	16 to 17	0.63 to 0.669
ER32-STIMC-180	46539	17 to 18	0.669 to 0.709
ER32-STIMC-190	46540	18 to 19	0.709 to 0.748
ER32-STIMC-0750	46571	18.1 to 19.1	0.713 to 0.75
ER32-STIMC-200	46542	19 to 20	0.748 to 0.787

INTEGRAL BORING AND MILLING BAR SYSTEM



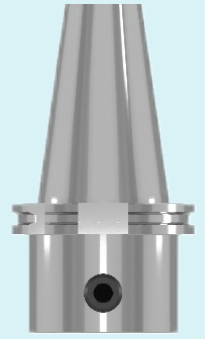
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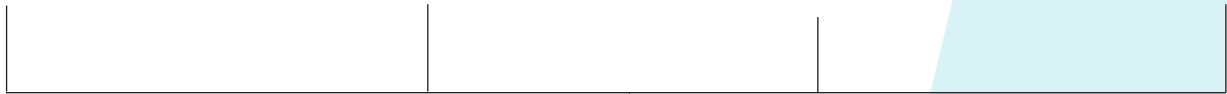
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INTEGRAL SINGLE INSERT
FINISHING BORING
SYSTEM

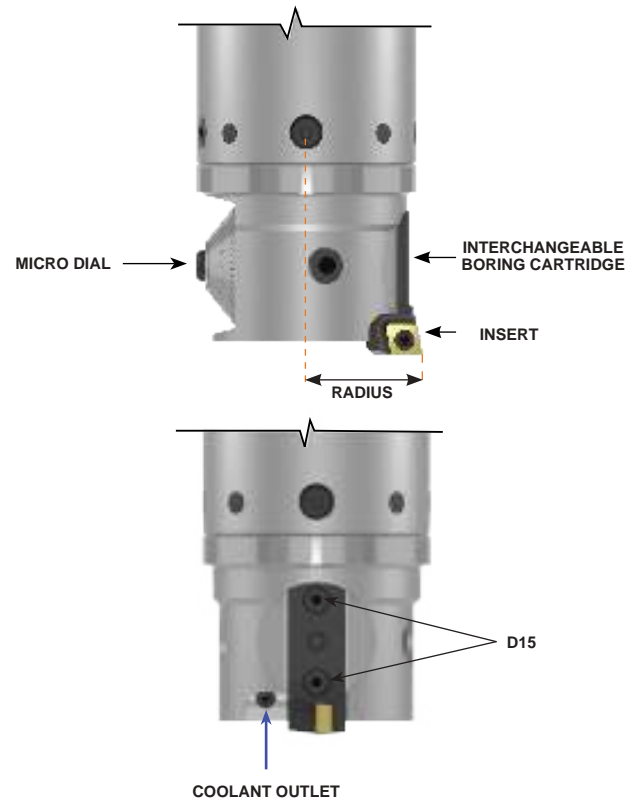
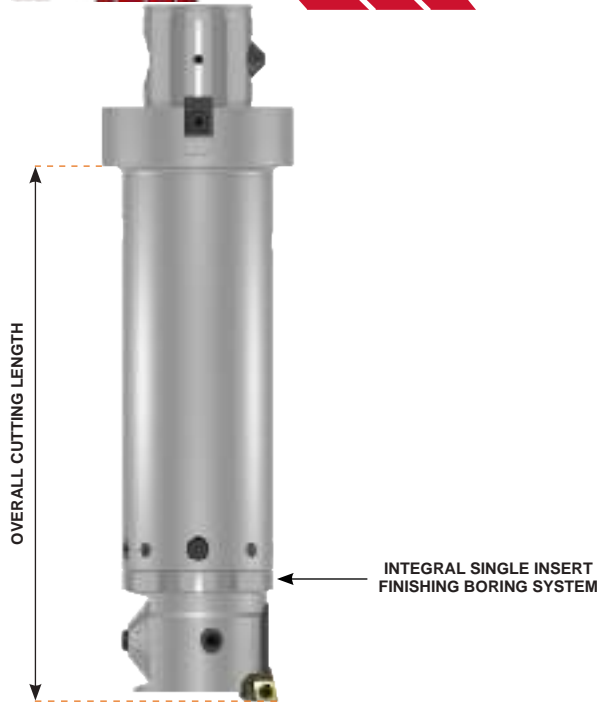
INTEGRAL TWIN INSERT
ROUGHING BORING
SYSTEM

INTEGRAL STEP INSERT
ROUGHING BORING
SYSTEM

INTEGRAL END MILL
TOOL HOLDER
SYSTEM

INTEGRAL FACE MILL
ADAPTOR
SYSTEM

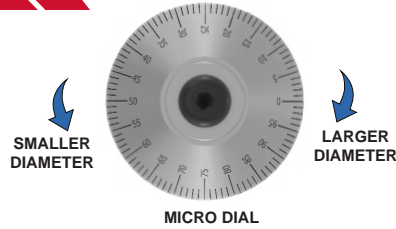
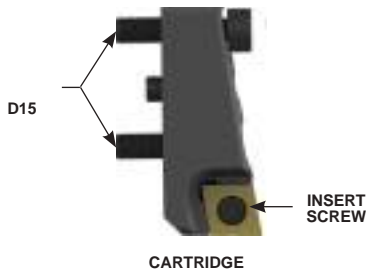




- Please refer page 35 for Interchangeable Finish Boring Cartridge Information.
 - Please refer to page 45 for spare parts.

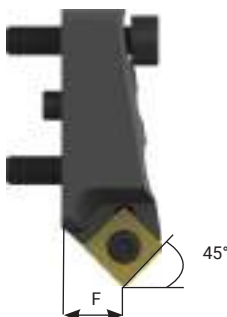
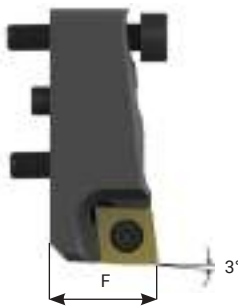
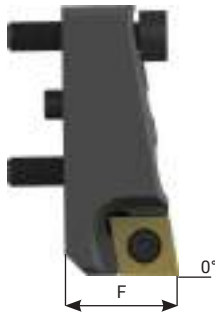
INTEGRAL SINGLE INSERT FINISHING BORING SYSTEM SPECIFICATION					INTERCHANGEABLE FINISH BORING CARTRIDGE							
Part Number	UPC	Overall Cutting Length	Bar Diameter	Wt. (kg)	Finishing Small Bore Cartridge		Finishing Medium Bore Cartridge		Finishing Large Bore Cartridge		Boring Range	
					Metric	Inch	Metric	Inch	Metric	Inch	Metric	Inch
42mm Integral Single Insert Finishing Boring System												
DST-ISFB42-04 0168-DT63	63146	168	42	3.4	48 to 61	1.890 to 2.402	DST-42FBC-S48.61-SCFCL06 DST-42FBC-S48.61-SCJCL06 DST-42FBC-S48.61-STFCL11 DST-42FBC-S48.61-SSDCN06	58 to 71	2.283 to 2.795	DST-42FBC-L68.81-SCFCL06 DST-42FBC-L68.81-SCJCL06 DST-42FBC-L68.81-STFCL11 DST-42FBC-L68.81-SSDCN06	68 to 81	2.677 to 3.189
DST-ISFB42-04 0168-DT80	63072	168		4.1								
DST-ISFB42-06 0252-DT63	63147	252		4.3								
DST-ISFB42-06 0252-DT80	63073	252		5.0								
DST-ISFB42-08 0336-DT63	63148	336		5.5								
DST-ISFB42-08 0336-DT80	63149	336		6.4								
DST-ISFB42-10 0420-DT63	63074	420		6.8								
DST-ISFB42-10 0420-DT80	63150	420		7.5								
50mm Integral Single Insert Finishing Boring System												
DST-ISFB50-04 0200-DT63	63151	200	50	6.0	56 to 71	2.205 to 2.795	DST-50FBC-S56.71-SCFCL09 DST-50FBC-S56.71-SCJCL09 DST-50FBC-S56.71-STFCL11 DST-50FBC-S56.71-SSDCN09	68 to 83	2.677 to 3.268	DST-50FBC-L80.95-SCFCL09 DST-50FBC-L80.95-SCJCL09 DST-50FBC-L80.95-STFCL11 DST-50FBC-L80.95-SSDCN09	80 to 95	3.150 to 3.740
DST-ISFB50-04 0200-DT80	63152	200		6.6								
DST-ISFB50-06 0300-DT63	63153	300		7.4								
DST-ISFB50-06 0300-DT80	63154	300		8.0								
DST-ISFB50-08 0400-DT80	63155	400		9.6								
DST-ISFB50-10 0500-DT80	63156	500		11.6								
63mm Integral Single Insert Finishing Boring System												
DST-ISFB63-04 0252-DT63	63157	252	63	8.3	68 to 88	2.677 to 3.465	DST-63FBC-S68.88-SCFCL09 DST-63FBC-S68.88-SCJCL09 DST-63FBC-S68.88-STFCL16 DST-63FBC-S68.88-SSDCN09	82 to 102	3.228 to 4.106	DST-63FBC-L96.116-SCFCL09 DST-63FBC-L96.116-SCJCL09 DST-63FBC-L96.116-STFCL16 DST-63FBC-L96.116-SSDCN09	96 to 116	3.780 to 4.564
DST-ISFB63-04 0252-DT80	63158	252		9.5								
DST-ISFB63-06 0378-DT63	63159	378		12.1								
DST-ISFB63-06 0378-DT80	63160	378		13.4								
DST-ISFB63-08 0504-DT80	63161	504		17.2								
DST-ISFB63-10 0630-DT80	63162	630		20.6								

- All dimensions are in mm unless otherwise specified.



MICRO DIAL SPECIFICATIONS					
Micro Dial Graduation		Insert Movement		Cutting Diameter	
Dial Turn	No. of Lines	Metric	Inch	Metric	Inch
1/100	1	0.0050	0.000197	0.010	0.000394
1/4	25	0.1250	0.004921	0.250	0.009843
1/2	50	0.2500	0.009843	0.500	0.019685
3/4	75	0.3750	0.014764	0.750	0.029528
1	100	0.5000	0.019685	1.000	0.039370

- Please refer page 45 for D15 Cartridge Locking Screws.



INTERCHANGEABLE FINISH BORING CARTRIDGE SPECIFICATIONS

Part Number	UPC	Integral Finishing Boring Head	Boring Range		F	Insert		Wt. (Kg)
			Metric	Inch		Geometry	Screw	
42mm SCFCL06 Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-SCFCL06	63257	DST-ISFB42	48 to 61	1.890 to 2.402	12	CCMT-0602	TS-25.45-6M2	0.018
DST-42FBC-M58.71-SCFCL06	63258		58 to 71	2.283 to 2.795	17			0.032
DST-42FBC-L68.81-SCFCL06	63259		68 to 81	2.677 to 3.189	22			0.045
50mm SCFCL09 Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-SCFCL09	63269	DST-ISFB50	56 to 71	2.205 to 2.795	13	CCMT-09T304	TS-4.7-8M1	0.030
DST-50FBC-M68.83-SCFCL09	63270		68 to 83	2.677 to 3.268	19			0.038
DST-50FBC-L80.95-SCFCL06	63271		80 to 95	3.150 to 3.740	25			0.054
63mm SCFCL12 Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-SCFCL12	63281	DST-ISFB63	68 to 88	2.677 to 3.465	16	CCMT-1204	TS-5.8-10M1	0.025
DST-63FBC-M82.102-SCFCL12	63282		82 to 102	3.228 to 4.106	23			0.045
DST-63FBC-L96.116-SCFCL12	63283		96 to 116	3.780 to 4.564	30			0.064

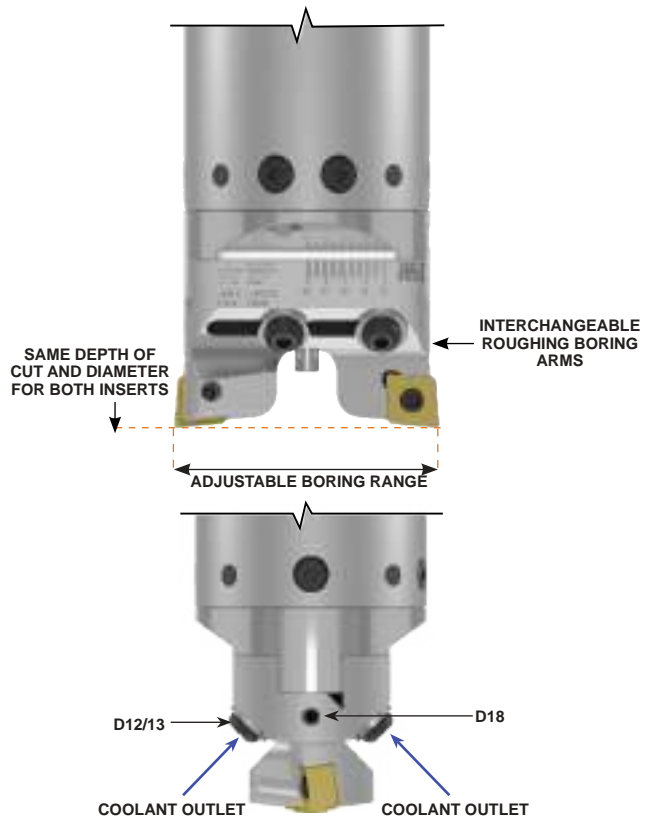
42mm SCJCL06-7° Insert Clearance Angle 3° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-SCJCL06	63260	DST-ISFB42	48 to 61	1.890 to 2.402	12	CCMT-0602	TS-25.45-6M2	0.019
DST-42FBC-M58.71-SCJCL06	63261		58 to 71	2.283 to 2.795	17			0.033
DST-42FBC-L68.81-SCJCL06	63262		68 to 81	2.677 to 3.189	22			0.046
50mm SCJCL09-7° Insert Clearance Angle 3° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-SCJCL09	63272	DST-ISFB50	56 to 71	2.205 to 2.795	13	CCMT-09T304	TS-4.7-8TM1	0.022
DST-50FBC-M68.83-SCJCL09	63273		68 to 83	2.677 to 3.268	19			0.040
DST-50FBC-L80.95-SCJCL09	63274		80 to 95	3.150 to 3.740	25			0.056
63mm SCJCL12-7° Insert Clearance Angle 3° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-SCJCL12	63284	DST-ISFB63	68 to 88	2.677 to 3.465	16	CCMT-1204	TS-5.8-10M1	0.027
DST-63FBC-M82.102-SCJCL12	63285		82 to 102	3.228 to 4.106	23			0.047
DST-63FBC-L96.116-SCJCL12	63286		96 to 116	3.780 to 4.564	30			0.065

42mm STFCL11-7° Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-STFCL11	63263	DST-ISFB42	48 to 61	1.890 to 2.402	12	TCMT-1102	TS-25.45-6M2	0.017
DST-42FBC-M58.71-STFCL11	63264		58 to 71	2.283 to 2.795	17			0.031
DST-42FBC-L68.81-STFCL11	63265		68 to 81	2.677 to 3.189	22			0.044
50mm STFCL11-7° Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-STFCL11	63275	DST-ISFB50	56 to 71	2.205 to 2.795	13	TCMT-1102	TS-25.45-6M2	0.020
DST-50FBC-M68.83-STFCL11	63276		68 to 83	2.677 to 3.268	19			0.037
DST-50FBC-L80.95-STFCL11	63277		80 to 95	3.150 to 3.740	25			0.053
63mm STFCL16-7° Insert Clearance Angle 0° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-STFCL16	63287	DST-ISFB63	68 to 88	2.677 to 3.465	16	TCMT-16T3	TS-4.7-8TM1	0.024
DST-63FBC-M82.102-STFCL16	63288		82 to 102	3.228 to 4.106	23			0.044
DST-63FBC-L96.116-STFCL16	63289		96 to 116	3.780 to 4.564	30			0.063

42mm SSDCN06-Insert Clearance Angle 45° Leading Angle, Finishing Boring Head Cartridge								
DST-42FBC-S48.61-SSDCN06	63266	DST-ISFB42	48 to 61	1.890 to 2.402	12	SCMT-0602	TS-25.45-6M2	0.015
DST-42FBC-M58.71-SSDCN06	63267		58 to 71	2.283 to 2.795	17			0.029
DST-42FBC-L68.81-SSDCN06	63268		68 to 81	2.677 to 3.189	22			0.042
50mm SSDCN09-Insert Clearance Angle 45° Leading Angle, Finishing Boring Head Cartridge								
DST-50FBC-S56.71-SSDCN09	63278	DST-ISFB50	56 to 71	2.205 to 2.795	13	SCMT-09T3	TS-4.7-8TM1	0.018
DST-50FBC-M68.83-SSDCN09	63279		68 to 83	2.677 to 3.268	19			0.035
DST-50FBC-L80.95-SSDCN09	63280		80 to 95	3.150 to 3.740	25			0.051
63mm SSDCN12-Insert Clearance Angle 45° Leading Angle, Finishing Boring Head Cartridge								
DST-63FBC-S68.88-SSDCN12	63290	DST-ISFB63	68 to 88	2.677 to 3.465	16	SCMT-1204	TS-5.8-10M1	0.022
DST-63FBC-M82.102-SSDCN12	63291		82 to 102	3.228 to 4.106	23			0.042
DST-63FBC-L96.116-SSDCN12	63292		96 to 116	3.780 to 4.564	30			0.060

- All dimensions are in mm unless otherwise specified.

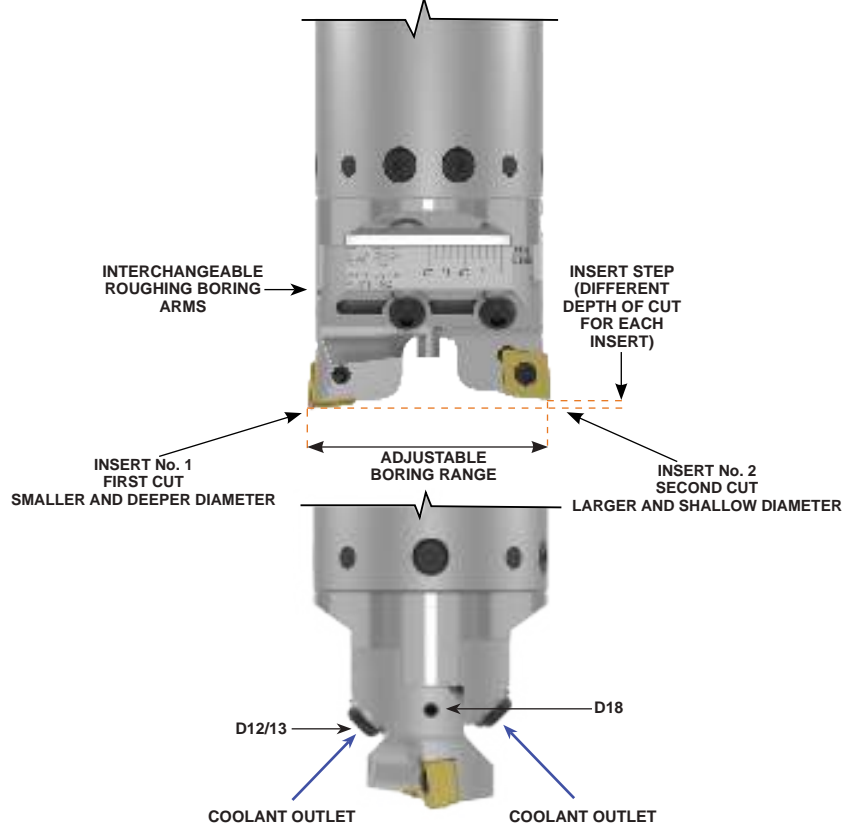
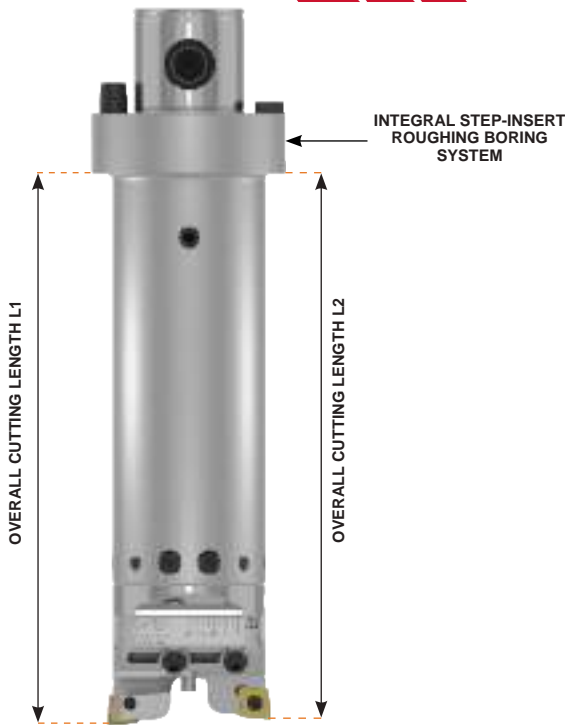




- Please refer page 38 for Interchangeable Double Insert Arm Set.
 - Please refer page 46 for Spare Parts.

INTEGRAL TWIN INSERT ROUGHING BORING SYSTEM SPECIFICATIONS					INTERCHANGEABLE ROUGHING BORING ARMS								
Part Number	UPC	Bar Diameter	Overall Cutting Length	Wt. (kg)	Roughing Small Bore Double Insert Arm Set	Boring Range		Roughing Medium Bore Double Insert Arm Set	Boring Range		Roughing Large Bore Double Insert Arm Set	Boring Range	
						Metric	Inch		Metric	Inch		Metric	Inch
42mm Integral Twin Insert Roughing Boring System													
DST-ITRB42-04 0168-DT63	63118	42	168	3.2	DST-42RBA-S48.61-SCGCL06 DST-42RBA-S48.61-SCLCL06 DST-42RBA-S48.61-SCRCL06	48 to 61	1.890 to 2.402	DST-42RBA-M58.71-SCGCL06 DST-42RBA-M58.71-SCLCL06 DST-42RBA-M58.71-SCRCL06	58 to 71	2.283 to 2.795	DST-42RBA-L68.81-SCGCL06 DST-42RBA-L68.81-SCLCL06 DST-42RBA-L68.81-SCRCL06	68 to 81	2.677 to 3.189
DST-ITRB42-04 0168-DT80	63060		168	3.9									
DST-ITRB42-06 0252-DT63	63119		252	4.1									
DST-ITRB42-06 0252-DT80	63061		252	4.8									
DST-ITRB42-08 0336-DT63	63120		336	5.3									
DST-ITRB42-08 0336-DT80	63121		336	6.2									
DST-ITRB42-10 0420-DT63	63062		420	6.6									
DST-ITRB42-10 0420-DT80	63063		420	7.3									
50mm Integral Twin Insert Roughing Boring System													
DST-ITRB50-04 0200-DT63	63122	50	200	5.5	DST-50RBA-S56.71-SCGCL09 DST-50RBA-S56.71-SCLCL09 DST-50RBA-S56.71-SCRCL09	56 to 71	2.205 to 2.795	DST-50RBA-M68.83-SCGCL09 DST-50RBA-M68.83-SCLCL09 DST-50RBA-M68.83-SCRCL09	68 to 83	2.677 to 3.268	DST-50RBA-L80.95-SCGCL09 DST-50RBA-L80.95-SCLCL09 DST-50RBA-L80.95-SCRCL09	80 to 95	3.150 to 3.740
DST-ITRB50-04 0200-DT80	63123		200	6.1									
DST-ITRB50-06 0300-DT63	63124		300	6.9									
DST-ITRB50-06 0300-DT80	63125		300	7.5									
DST-ITRB50-08 0400-DT80	63126		400	9.1									
DST-ITRB50-10 0500-DT80	63064		500	11.1									
63mm Integral Twin Insert Roughing Boring System													
DST-ITRB63-04 0252-DT63	63127	63	252	7.2	DST-63RBA-S69.89-SCGNL12 DST-63RBA-S69.89-SCRNL12 DST-63RBA-S69.89-SCGCL12 DST-63RBA-S69.89-SCLCL12	69 to 89	2.717 to 3.504	DST-63RBA-M82.102-SCGNL12 DST-63RBA-M82.102-SCRNL12 DST-63RBA-M82.102-SCGCL12 DST-63RBA-M82.102-SCLCL12	82 to 102	3.228 to 4.106	DST-63RBA-L96.116-SCGNL12 DST-63RBA-L96.116-SCRNL12 DST-63RBA-L96.116-SCGCL12 DST-63RBA-L96.116-SCLCL12	96 to 116	3.780 to 4.564
DST-ITRB63-04 0252-DT80	63128		252	8.4									
DST-ITRB63-06 0378-DT63	63129		378	11.0									
DST-ITRB63-06 0378-DT80	63130		378	12.3									
DST-ITRB63-08 0504-DT80	63131		504	16.1									
DST-ITRB63-10 0630-DT80	63065		630	19.5									

- All dimensions are in mm unless otherwise specified.

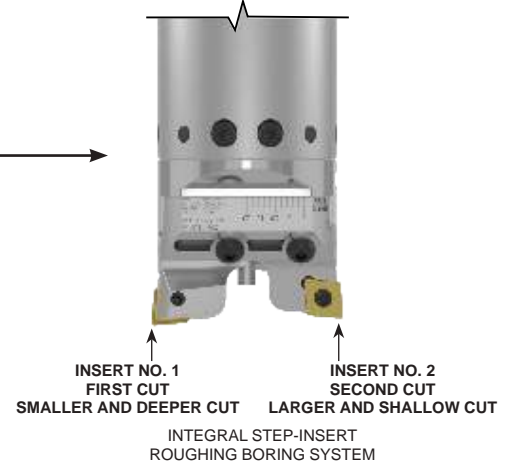
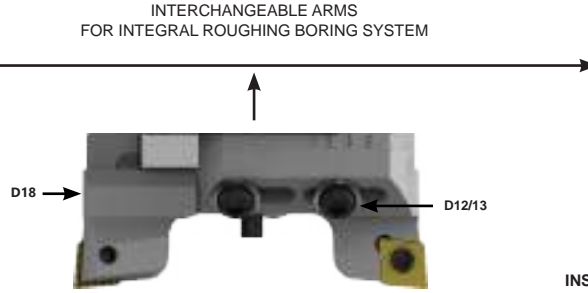
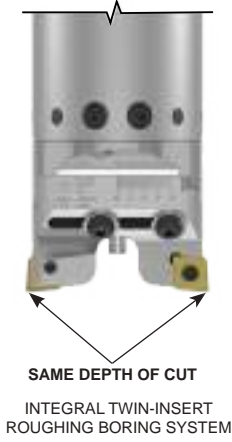


- Please refer page 38 for Interchangeable Double Insert Arm Set.
 - Please refer page 47 for Spare Parts.

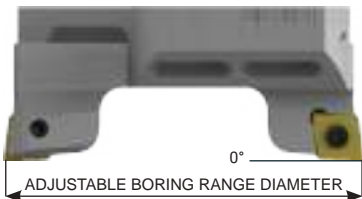
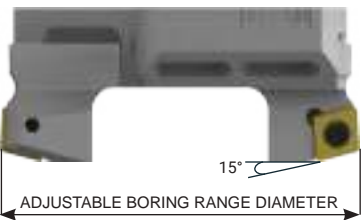
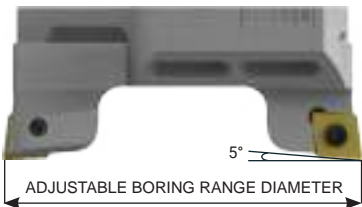
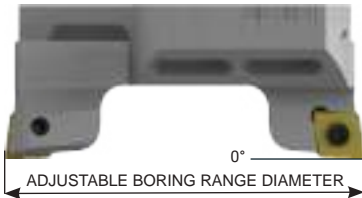
INTEGRAL STEP INSERT ROUGHING BORING SYSTEM SPECIFICATIONS					INTERCHANGEABLE ROUGHING BORING ARMS									
Part Number	UPC	Bar Diameter	Overall Cutting Length		Wt. (Kg)	Roughing Small Bore Double Insert Arm Set	Boring Range		Roughing Medium Bore Double Insert Arm Set	Boring Range		Roughing Large Bore Double Insert Arm Set	Boring Range	
			L1	L2			Metric	Inch		Metric	Inch		Metric	Inch
42mm Integral Step Insert Roughing Boring System														
DST-ISRB42-04 0168-DT63	63132	42	168	167.8	3.2	DST-42RBA-S48.61-SCGCL06 DST-42RBA-S48.61-SCLCL06 DST-42RBA-S48.61-SCRCL06	48 to 61	1.890 to 2.402	DST-42RBA-M58.71-SCGCL06 DST-42RBA-M58.71-SCLCL06 DST-42RBA-M58.71-SCRCL06	58 to 71	2.283 to 2.795	DST-42RBA-L68.81-SCGCL06 DST-42RBA-L68.81-SCLCL06 DST-42RBA-L68.81-SCRCL06	68 to 81	2.677 to 3.189
DST-ISRB42-04 0168-DT80	63066		168	167.8	3.9									
DST-ISRB42-06 0252-DT63	63133		252	251.8	4.1									
DST-ISRB42-06 0252-DT80	63067		252	251.8	4.8									
DST-ISRB42-08 0336-DT63	63134		336	335.8	5.3									
DST-ISRB42-08 0336-DT80	63135		336	335.8	6.2									
DST-ISRB42-10 0420-DT63	63068		420	419.8	6.6									
DST-ISRB42-10 0420-DT80	63069		420	419.8	7.3									
50mm Integral Step Insert Roughing Boring System														
DST-ISRB50-04 0200-DT63	63136	50	200	199.75	5.5	DST-50RBA-S56.71-SCGCL09 DST-50RBA-S56.71-SCLCL09 DST-50RBA-S56.71-SCRCL09	56 to 71	2.205 to 2.795	DST-50RBA-M68.83-SCGCL09 DST-50RBA-M68.83-SCLCL09 DST-50RBA-M68.83-SCRCL09	68 to 83	2.677 to 3.268	DST-50RBA-L80.95-SCGCL09 DST-50RBA-L80.95-SCLCL09 DST-50RBA-L80.95-SCRCL09	80 to 95	3.150 to 3.740
DST-ISRB50-04 0200-DT80	63137		200	199.75	6.1									
DST-ISRB50-06 0300-DT63	63138		300	299.75	6.9									
DST-ISRB50-06 0300-DT80	63139		300	299.75	7.5									
DST-ISRB50-08 0400-DT80	63140		400	399.75	9.1									
DST-ISRB50-10 0500-DT80	63070		500	499.75	11.1									
63mm Integral Step Insert Roughing Boring System														
DST-ISRB63-04 0252-DT63	63141	63	252	251.7	7.2	DST-63RBA-S69.89-SCGNL12 DST-63RBA-S69.89-SCRNL12 DST-63RBA-S69.89-SCGCL12 DST-63RBA-S69.89-SCLCL12	69 to 89	2.717 to 3.504	DST-63RBA-M82.102-SCGNL12 DST-63RBA-M82.102-SCRNL12 DST-63RBA-M82.102-SCGCL12 DST-63RBA-M82.102-SCLCL12	82 to 102	3.228 to 4.106	DST-63RBA-L96.116-SCGNL12 DST-63RBA-L96.116-SCRNL12 DST-63RBA-L96.116-SCGCL12 DST-63RBA-L96.116-SCLCL12	96 to 116	3.780 to 4.564
DST-ISRB63-04 0252-DT80	63142		252	251.7	8.4									
DST-ISRB63-06 0378-DT63	63143		378	377.7	11.0									
DST-ISRB63-06 0378-DT80	63144		378	377.7	12.3									
DST-ISRB63-08 0504-DT80	63145		504	503.7	16.1									
DST-ISRB63-10 0630-DT80	63071		630	629.7	19.5									

- All dimensions are in mm unless otherwise specified.





- Please refer page 46 and 47 for D12/13 and D18



INTERCHANGEABLE ROUGHING BORING ARMS SPECIFICATIONS

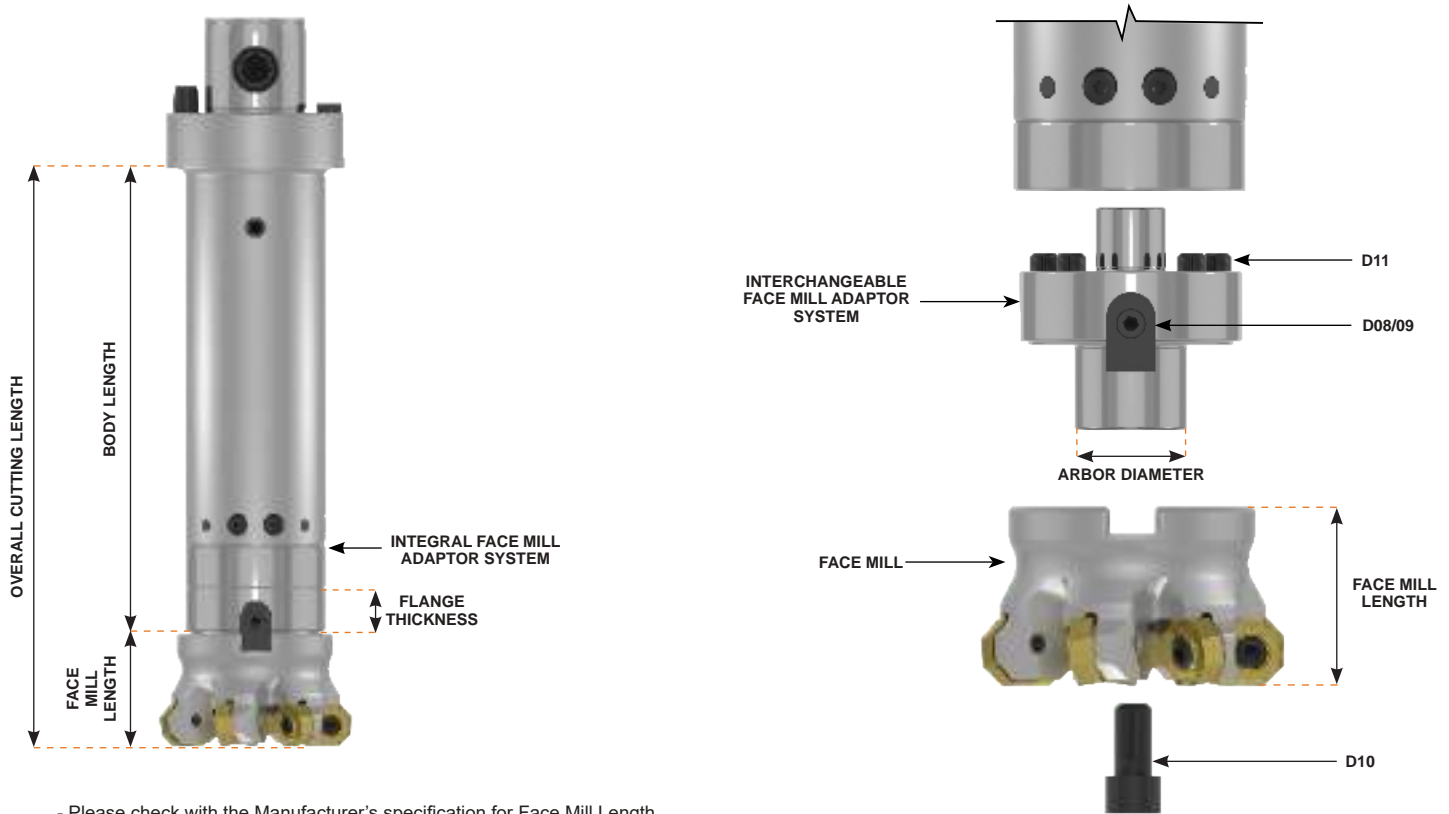
Part Number	UPC	Integral Roughing Boring System	Boring Range		Insert		Wt. (Kg)
			Metric	Inch	Geometry	Screw	
42mm SCGCL06 0°, Roughing Boring Head Arm Set							
DST-42RBA-S48.81-SCGCL06	63227	DST-ITRB42 DST-ISR42	48 to 61	1.890 to 2.402	CCMT-0602	TS-25.45-6M2	0.240
DST-42RBA-M58.71-SCGCL06	63228		58 to 71	2.283 to 2.795			0.290
DST-42RBA-L68.81-SCGCL06	63229		68 to 81	2.677 to 3.189			0.340
50mm SCGCL09 0°, Roughing Boring Head Arm Set							
DST-50RBA-S56.71-SCGCL09	63236	DST-ITRB50 DST-ISR50	56 to 71	2.205 to 2.795	CCMT-09T304	TS-4.7-8M1	0.280
DST-50RBA-M68.83-SCGCL09	63237		68 to 83	2.677 to 3.268			0.350
DST-50RBA-L80.95-SCGCL09	63238		80 to 95	3.150 to 3.740			0.400
63mm SCGCL12 0°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCGCL12	63251	DST-ITRB63 DST-ISR63	69 to 89	2.717 to 3.504	CCMT-1204	TS-5.8-10M1	0.330
DST-63RBA-M82.102-SCGCL12	63252		82 to 102	3.228 to 4.106			0.440
DST-63RBA-L96.116-SCGCL12	63253		96 to 116	3.780 to 4.564			0.500

42mm SCLCL06 5°, Roughing Boring Head Arm Set							
DST-RBA42-S48.61-SCLCL06	63230	DST-ITRB42 DST-ISR42	48 to 61	1.890 to 2.402	CCMT-0602	TS-25.45-6M2	0.240
DST-RBA42-M58.71-SCLCL06	63231		58 to 71	2.283 to 2.795			0.290
DST-RBA42-L68.81-SCLCL06	63232		68 to 81	2.677 to 3.189			0.340
50mm SCLCL09 5°, Roughing Boring Head Arm Set							
DST-50RBA-S56.71-SCLCL09	63239	DST-ITRB50 DST-ISR50	56 to 71	2.205 to 2.795	CCMT-09T304	TS-4.7-8M1	0.280
DST-50RBA-M68.83-SCLCL09	63240		68 to 83	2.677 to 3.268			0.350
DST-50RBA-L80.95-SCLCL09	63241		80 to 95	3.150 to 3.740			0.400
63mm SCLCL12 5°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCLCL12	63254	DST-ITRB63 DST-ISR63	69 to 89	2.717 to 3.504	CCMT-1204	TS-5.8-10M1	0.280
DST-63RBA-M82.102-SCLCL12	63255		82 to 102	3.228 to 4.106			0.350
DST-63RBA-L96.116-SCLCL12	63256		96 to 116	3.780 to 4.564			0.400

42mm SCRCL06 15°, Roughing Boring Head Arm Set							
DST-42RBA-S48.61-SCRCL06	63233	DST-ITRB42 DST-ISR42	48 to 61	1.890 to 2.402	CCMT-0602	TS-25.45-6M2	0.240
DST-42RBA-M58.71-SCRCL06	63234		58 to 71	2.283 to 2.795			0.290
DST-42RBA-L68.81-SCRCL06	63235		68 to 81	2.677 to 3.189			0.340
50mm SCRCL09 15°, Roughing Boring Head Arm Set							
DST-50RBA-S56.71-SCRCL09	63242	DST-ITRB50 DST-ISR50	56 to 71	2.205 to 2.795	CCMT-09T304	TS-4.7-8M1	0.280
DST-50RBA-M68.83-SCRCL09	63243		68 to 83	2.677 to 3.268			0.350
DST-50RBA-L80.95-SCRCL09	63244		80 to 95	3.150 to 3.740			0.400
63mm SCRNL12 15°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCRNL12	63248	DST-ITRB63 DST-ISR63	69 to 89	2.717 to 3.504	CNMG-1204	TS-1032-5M1	0.280
DST-63RBA-M80.102-SCRNL12	63249		82 to 102	3.228 to 4.106			0.350
DST-63RBA-L96.116-SCRNL12	63250		96 to 116	3.780 to 4.564			0.400

63mm SCGNL12 0°, Roughing Boring Head Arm Set							
DST-63RBA-S69.89-SCGNL12	63245	DST-ITRB63 DST-ISR63	69 to 89	2.717 to 3.504	CNMG-1204	TS-1032-5M1	0.280
DST-63RBA-M82.102-SCGNL12	63246		82 to 102	3.228 to 4.106			0.350
DST-63RBA-L96.116-SCGNL12	63247		96 to 116	3.780 to 4.564			0.400

- All dimensions are in mm unless otherwise specified.

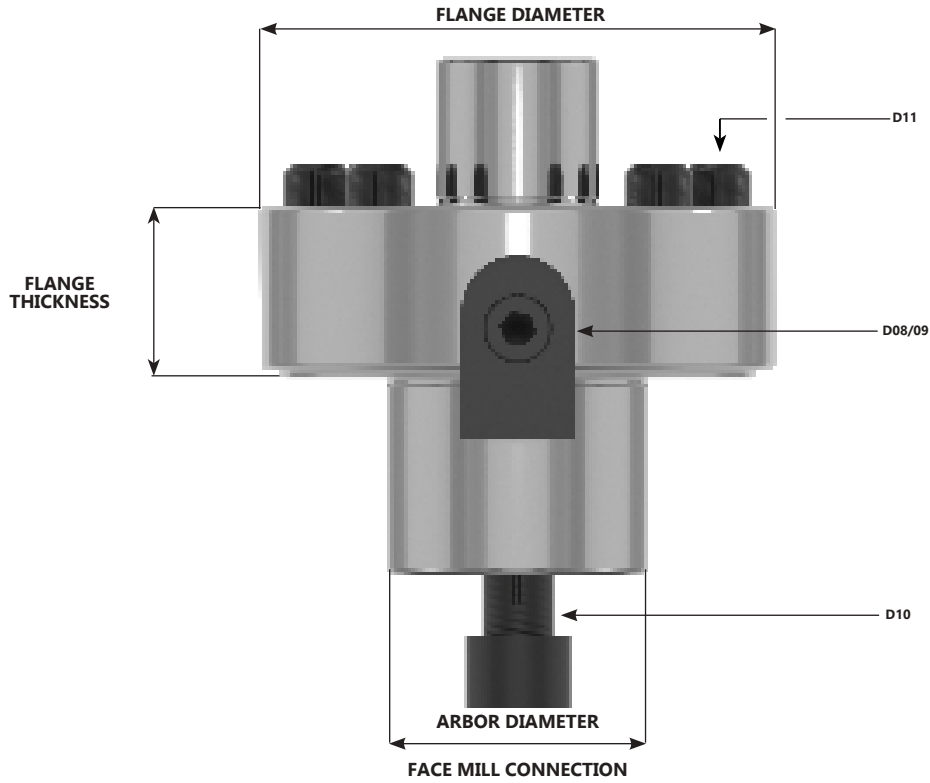


- Please check with the Manufacturer's specification for Face Mill Length.
- Please refer page 40 for Interchangeable Face Mill Adaptors Information.
- Please refer page 48 for spare parts.

INTEGRAL FACE MILL ADAPTOR SYSTEM SPECIFICATIONS						INTERCHANGEABLE FACE MILL ADAPTOR				
Part Number	UPC	Bar Diameter	Body Length	Arbor Diameter		Minimum Face Mill Length	Interchangeable Face Mill Adaptor - Metric		Interchangeable Face Mill Adaptor - Inch	
				Metric	Inch		Part Number	Flange Thickness	Part Number	Flange Thickness
42mm Integral Face Mill Adaptor System										
DST-IFMB42-04 0168-DT63	63180	42	131.65	13 16 22	0.750 1.000	36.35	DST-IFMB-FMA42-M13 DST-IFMB-FMA42-M16 DST-IFMB-FMA42-M22	13	DST-IFMB-FMA42-I0750 DST-IFMB-FMA42-I1000	0.591
DST-IFMB42-04 0168-DT80	63078		131.65							
DST-IFMB42-06 0252-DT63	63181		215.65							
DST-IFMB42-06 0252-DT80	63079		215.65							
DST-IFMB42-08 0336-DT63	63182		299.65							
DST-IFMB42-08 0336-DT80	63183		299.65							
50mm Integral Face Mill Adaptor System										
DST-IFMB50-04 0200-DT63	63184	50	156.45	16 22 27	0.750 1.000	43.55	DST-IFMB-FMA50-M16 DST-IFMB-FMA50-M22 DST-IFMB-FMA50-M27	16	DST-IFMB-FMA50-I0750 DST-IFMB-FMA50-I1000	0.630
DST-IFMB50-04 0200-DT80	63185		156.45							
DST-IFMB50-06 0300-DT63	63186		256.45							
DST-IFMB50-06 0300-DT80	63187		256.45							
DST-IFMB50-08 0400-DT80	63188		356.45							
DST-IFMB50-08 0400-DT80	63189		356.45							
63mm Integral Face Mill Adaptor System										
DST-IFMB63-04 0252-DT63	63190	63	209.2	22 27 32 40	0.750 1.000 1.500	42.80	DST-IFMB-FMA63-M22 DST-IFMB-FMA63-M27 DST-IFMB-FMA63-M32 DST-IFMB-FMA63-M40	21	DST-IFMB-FMA63-I0750 DST-IFMB-FMA63-I1000 DST-IFMB-FMA63-I1500	0.827
DST-IFMB63-04 0252-DT80	63191		209.2							
DST-IFMB63-06 0378-DT63	63192		335.2							
DST-IFMB63-06 0378-DT80	63193		335.2							
DST-IFMB63-08 0504-DT80	63194		461.2							

- All dimensions are in mm unless otherwise specified.



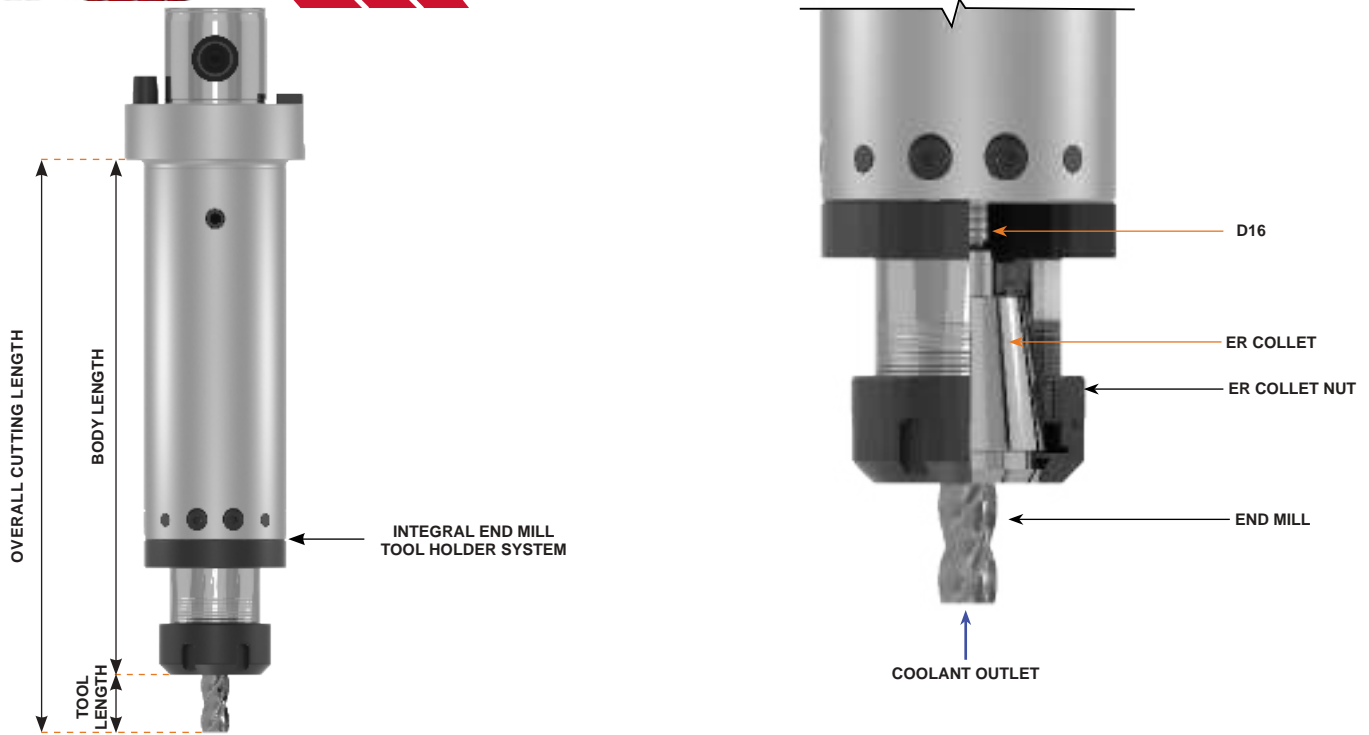


- Please refer page 48 for spare parts.

METRIC						
Interchangeable Face Mill Adaptor Specifications						
Part Number	UPC	Bar Diameter	Arbor Diameter	Flange Diameter	Flange Thickness	Weight (kg)
42mm-Solution Tool-Interchangeable Metric Face Mill Adaptor						
DST-IFMB-FMA42-M13	63318	42	13	42	13	0.26
DST-IFMB-FMA42-M16	63319		16			0.26
DST-IFMB-FMA42-M22	63320		22			0.30
50mm-Solution Tool-Interchangeable Metric Face Mill Adaptor						
DST-IFMB-FMA50-M16	63321	50	16	50	16	0.41
DST-IFMB-FMA50-M22	63322		22			0.43
DST-IFMB-FMA50-M27	63323		27			0.47
63mm-Solution Tool-Interchangeable Metric Face Mill Adaptor						
DST-IFMB-FMA63-M16	63324	63	16	63	21	0.74
DST-IFMB-FMA63-M22	63325		22			0.76
DST-IFMB-FMA63-M27	63326		27			0.78
DST-IFMB-FMA63-M32	63327		32			0.90
DST-IFMB-FMA63-M40	63328		40			0.98

INCH						
Interchangeable Face Mill Adaptor Specifications						
Part Number	UPC	Bar Diameter	Arbor Diameter	Flange Diameter	Flange Thickness	Weight (kg)
42mm-Solution Tool-Interchangeable Inch Face Mill Adaptor						
DST-IFMB-FMA42-I0750	63311	42	0.750	1.654	0.591	0.28
DST-IFMB-FMA42-I1000	63312		1.000	1.654		0.32
50mm-Solution Tool-Interchangeable Inch Face Mill Adaptor						
DST-IFMB-FMA50-I0750	63313	50	0.750	1.969	0.630	0.41
DST-IFMB-FMA50-I1000	63314		1.000	1.969		0.45
63mm-Solution Tool-Interchangeable Inch Face Mill Adaptor						
DST-IFMB-FMA63-I0750	63315	63	0.750	2.480	0.827	0.74
DST-IFMB-FMA63-I1000	63316		1.000	2.480		0.76
DST-IFMB-FMA63-I1500	63317		1.500	3.750		0.90

- All dimensions are in mm unless otherwise specified.



- Please check for Tool Length with the Manufacturer's specification.
- Overall Cutting Length = Body Length + Tool Length
- The minimum tool length is mentioned to have a nominal boring length according to the boring ratio.
- The maximum tool length will vary according to the machining material and the diameter of the end mill.
- Please refer page 49 for Spare Parts.

INTEGRAL END MILL TOOL HOLDER SYSTEM								
Part Number	UPC	Body Length	Bar Diameter	Minimum Tool Length	ER Collet		Weight (kg)	
					Size	Range		
						Metric		Inch
42mm Integral ER20 Collet Tool Holder System								
DST-IEMB42-04 0168-DT63	63163	159.5	42	8.5	20	2 to 13	.0625 to .5000	3.2
DST-IEMB42-04 0168-DT80	63075	159.5						3.9
DST-IEMB42-06 0252-DT63	63164	243.5						4.2
DST-IEMB42-06 0252-DT80	63076	243.5						4.8
DST-IEMB42-08 0336-DT63	63165	327.5						5.3
DST-IEMB42-08 0336-DT80	63166	327.5						6.3
DST-IEMB42-10 0420-DT63	63077	411.5						6.6
DST-IEMB42-10 0420-DT80	63167	411.5						7.3
50mm Integral ER20 Collet Tool Holder System								
DST-IEMB50-04 0200-DT63	63168	185	50	15	25	2 to 16	.0625 to .6250	5.4
DST-IEMB50-04 0200-DT80	63169	185						6.1
DST-IEMB50-06 0300-DT63	63170	285						6.8
DST-IEMB50-06 0300-DT80	63171	285						7.4
DST-IEMB50-08 0400-DT80	63172	385						9.1
DST-IEMB50-10 0500-DT80	63173	485						11.1
63mm Integral ER20 Collet Tool Holder System								
DST-IEMB63-04 0252-DT63	63174	232	63	20	32	4 to 26	.0937 to .7500	6.8
DST-IEMB63-04 0252-DT80	63175	232						8.0
DST-IEMB63-06 0378-DT63	63176	358						10.6
DST-IEMB63-06 0378-DT80	63177	358						11.9
DST-IEMB63-08 0504-DT80	63178	484						15.7
DST-IEMB63-10 0630-DT80	63179	610						19.1

- All dimensions are in mm unless otherwise specified.



- Evenly distributed cutting edges for high performance machining.
- 16 slots, deburred and polished.
- Increased grip force with reduced friction to collet seat.
- Improve system performance and lower cost per piece when used with a quality chuck.

16 Slits for Uniform Gripping



Ultra Precision 0.0002" TIR



ULTRA PRECISION ER 20 COLLETS

Part Number	UPC	Metric Range	Inch Range
ER20-STIMC-10	46353	0.5 to 1	0.020 to 0.039
ER20-STIMC-15	46354	1 to 1.5	0.039 to 0.059
ER20-STIMC-20	46355	1.5 to 2	0.059 to 0.079
ER20-STIMC-30	46356	2 to 3	0.079 to 0.118
ER20-STIMC-0937	46386	1.9 to 2.4	0.075 to 0.094
ER20-STIMC-0125	46387	2.2 to 3.2	0.087 to 0.125
ER20-STIMC-40	46358	3 to 4	0.118 to 0.157
ER20-STIMC-0187	46388	3.8 to 4.8	0.150 to 0.188
ER20-STIMC-50	46359	4 to 5	0.157 to 0.197
ER20-STIMC-60	46360	5 to 6	0.197 to 0.236
ER20-STIMC-0250	46389	5.4 to 6.4	0.213 to 0.250
ER20-STIMC-70	46361	6 to 7	0.236 to 0.276
ER20-STIMC-80	46362	7 to 8	0.276 to 0.315
ER20-STIMC-90	46363	8 to 9	0.315 to 0.354
ER20-STIMC-375	46390	8.5 to 9.5	0.335 to 0.375
ER20-STIMC-100	46364	9 to 10	0.354 to 0.394
ER20-STIMC-110	46365	10 to 11	0.394 to 0.433
ER20-STIMC-120	46367	11 to 12	0.433 to 0.472
ER20-STIMC-0500	46391	11.7 to 12.7	0.461 to 0.500
ER20-STIMC-130	46368	12 to 13	0.472 to 0.512

ULTRA PRECISION ER 25 COLLETS

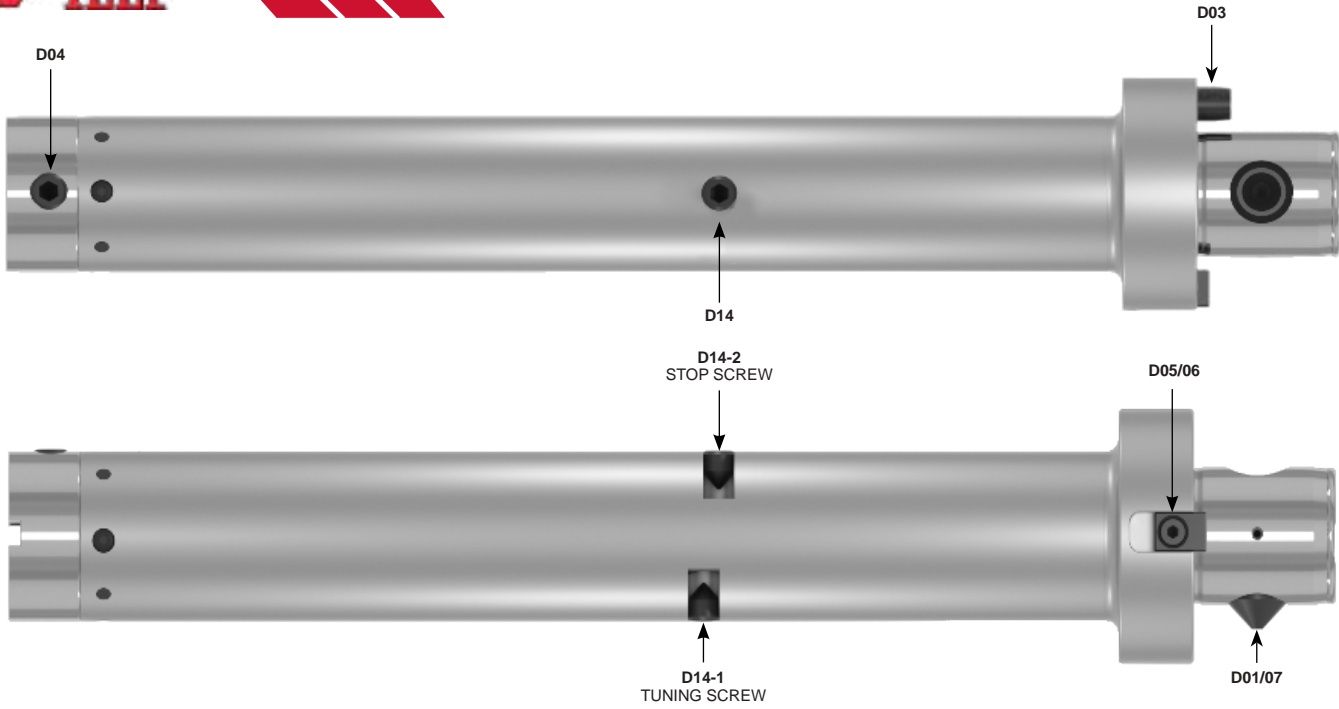
Part Number	UPC	Metric Range	Inch Range
ER25-STIMC-10	46428	0.5 to 1	0.020 to 0.039
ER25-STIMC-15	46429	1 to 1.5	0.039 to 0.059
ER25-STIMC-20	46430	1.5 to 2	0.059 to 0.079
ER25-STIMC-0937	46499	2 to 3	0.079 to 0.118
ER25-STIMC-30	46431	1.9 to 2.4	0.075 to 0.094
ER25-STIMC-0125	46500	2.2 to 3.2	0.087 to 0.125
ER25-STIMC-40	46433	3 to 4	0.118 to 0.157
ER25-STIMC-0187	46501	3.8 to 4.8	0.150 to 0.188
ER25-STIMC-50	46434	4 to 5	0.157 to 0.197
ER25-STIMC-60	46435	5 to 6	0.197 to 0.236
ER25-STIMC-0250	46502	5.4 to 6.4	0.213 to 0.250
ER25-STIMC-70	46436	6 to 7	0.236 to 0.276
ER25-STIMC-80	46437	7 to 8	0.276 to 0.315
ER25-STIMC-90	46438	8 to 9	0.315 to 0.354
ER25-STIMC-0375	46503	8.5 to 9.5	0.335 to 0.375
ER25-STIMC-100	46439	9 to 10	0.354 to 0.394
ER25-STIMC-110	46440	10 to 11	0.394 to 0.433
ER25-STIMC-120	46442	11 to 12	0.433 to 0.472
ER25-STIMC-0500	46517	11.7 to 12.7	0.461 to 0.500
ER25-STIMC-130	46443	12 to 13	0.472 to 0.512
ER25-STIMC-140	46444	13 to 14	0.512 to 0.551
ER25-STIMC-150	46445	14 to 15	0.551 to 0.591
ER25-STIMC-0625	46518	14.9 to 15.9	0.586 to 0.625
ER25-STIMC-160	46446	15 to 16	0.591 to 0.63

ULTRA PRECISION ER 32 COLLETS

Part Number	UPC	Metric Range	Inch Range
ER32-STIMC-20	46521	1.5 to 2	0.059 to 0.079
ER32-STIMC-0937	46543	1.9 to 2.4	0.075 to 0.094
ER32-STIMC-30	46522	2 to 3	0.079 to 0.118
ER32-STIMC-0125	46544	2.2 to 3.2	0.086 to 0.125
ER32-STIMC-40	46524	3 to 4	0.118 to 0.157
ER32-STIMC-0187	46545	3.8 to 4.8	0.148 to 0.188
ER32-STIMC-50	46525	4 to 5	0.157 to 0.197
ER32-STIMC-60	46526	5 to 6	0.197 to 0.236
ER32-STIMC-0250	46546	5.4 to 6.4	0.211 to 0.25
ER32-STIMC-70	46527	6 to 7	0.236 to 0.276
ER32-STIMC-80	46528	7 to 8	0.276 to 0.315
ER32-STIMC-90	46529	8 to 9	0.315 to 0.354
ER32-STIMC-0375	46547	8.5 to 9.5	0.336 to 0.375
ER32-STIMC-100	46530	9 to 10	0.354 to 0.394
ER32-STIMC-110	46531	10 to 11	0.394 to 0.433
ER32-STIMC-120	46533	11 to 12	0.433 to 0.472
ER32-STIMC-0500	46569	11.7 to 12.7	0.461 to 0.5
ER32-STIMC-130	46534	12 to 13	0.472 to 0.512
ER32-STIMC-140	46535	13 to 14	0.512 to 0.551
ER32-STIMC-150	46536	14 to 15	0.551 to 0.591
ER32-STIMC-0625	46570	14.9 to 15.9	0.586 to 0.625
ER32-STIMC-160	46537	15 to 16	0.591 to 0.63
ER32-STIMC-170	46538	16 to 17	0.63 to 0.669
ER32-STIMC-180	46539	17 to 18	0.669 to 0.709
ER32-STIMC-190	46540	18 to 19	0.709 to 0.748
ER32-STIMC-0750	46571	18.1 to 19.1	0.713 to 0.75
ER32-STIMC-200	46542	19 to 20	0.748 to 0.787

SPARE PARTS



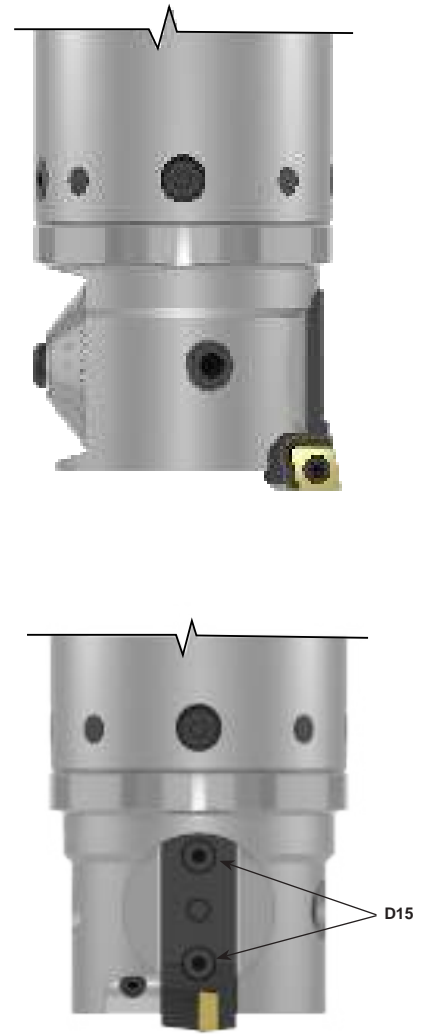


UQCS Milling & Boring Bar		D01/07 Floating Taper Pin Set		D03 Orientation Taper Pin		D04 Locking Taper Pin		D05/06 Driving Key Set		D14-1 & D14-2 Bar Tuning & Stop Screws	
Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC
42mm - Solution Tool - Universal Boring and Milling Bar - Spare Parts											
DST-UQCS42-04 0168-DT63	63100	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-42-24 LTS	63361	D05/06-63-25 DKS	63371	DST-MAPS 6-11	63572
DST-UQCS42-04 0252-DT80	63056	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-42-24 LTS	63361	D05/06-80-25 DKS	63372	DST-MAPS 6-11	63572
DST-UQCS42-06 0252-DT63	63101	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-42-24 LTS	63361	D05/06-63-25 DKS	63371	DST-MAPS 6-7	63571
DST-UQCS42-06 0252-DT80	63057	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-42-24 LTS	63361	D05/06-80-25 DKS	63372	DST-MAPS 6-7	63571
DST-UQCS42-08 0336-DT63	63102	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-42-24 LTS	63361	D05/06-63-25 DKS	63371	DST-MAPS 6-7	63571
DST-UQCS42-08 0336-DT80	63103	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-42-24 LTS	63361	D05/06-80-25 DKS	63372	DST-MAPS 6-7	63571
DST-UQCS42-10 0420-DT63	63104	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-42-24 LTS	63361	D05/06-63-25 DKS	63371	DST-MAPS 6-7	63571
DST-UQCS42-10 0420-DT80	63105	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-42-24 LTS	63361	D05/06-80-25 DKS	63372	DST-MAPS 6-7	63571
50mm - Solution Tool - Universal Boring and Milling Bar - Spare Parts											
DST-UQCS50-04 0200-DT63	63106	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-50-24 LTS	63362	D05/06-63-25 DKS	63371	DST-MAPS 6-11	63572
DST-UQCS50-04 0200-DT80	63107	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-50-24 LTS	63362	D05/06-80-25 DKS	63372	DST-MAPS 6-11	63572
DST-UQCS50-06 0300-DT63	63108	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-50-24 LTS	63362	D05/06-63-25 DKS	63371	DST-MAPS 6-7	63571
DST-UQCS50-06 0300-DT80	63109	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-50-24 LTS	63362	D05/06-80-25 DKS	63372	DST-MAPS 6-7	63571
DST-UQCS50-08 0400-DT63	63058	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-50-24 LTS	63362	D05/06-63-25 DKS	63371	DST-MAPS 6-7	63571
DST-UQCS50-08 0400-DT80	63110	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-50-24 LTS	63362	D05/06-80-25 DKS	63372	DST-MAPS 6-7	63571
DST-UQCS50-10 0500-DT63	63059	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-50-24 LTS	63362	D05/06-63-25 DKS	63371	DST-MAPS 6-7	63571
DST-UQCS50-10 0500-DT80	63111	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-50-24 LTS	63362	D05/06-80-25 DKS	63372	DST-MAPS 6-7	63571
63mm - Solution Tool - Universal Boring and Milling Bar - Spare Parts											
DST-UQCS63-04 0252-DT63	63112	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-63-24 LTS	63363	D05/06-63-25 DKS	63371	DST-MAPS 6-11	63572
DST-UQCS63-04 0252-DT80	63113	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-63-24 LTS	63363	D05/06-80-25 DKS	63372	DST-MAPS 6-11	63572
DST-UQCS63-06 0378-DT63	63114	D01/07-63-21 FTSP	63339	D03-63-23 OTP	63355	D04-63-24 LTS	63363	D05/06-63-25 DKS	63371	DST-MAPS 6-11	63572
DST-UQCS63-06 0378-DT80	63115	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-63-24 LTS	63363	D05/06-80-25 DKS	63372	DST-MAPS 6-11	63572
DST-UQCS63-08 0504-DT80	63116	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-63-24 LTS	63363	D05/06-80-25 DKS	63372	DST-MAPS 6-11	63572
DST-UQCS63-10 0630-DT80	63117	D01/07-80-21 FTSP	63340	D03-80-23 OTP	63356	D04-63-24 LTS	63363	D05/06-80-25 DKS	63372	DST-MAPS 6-11	63572

Quick-Change System

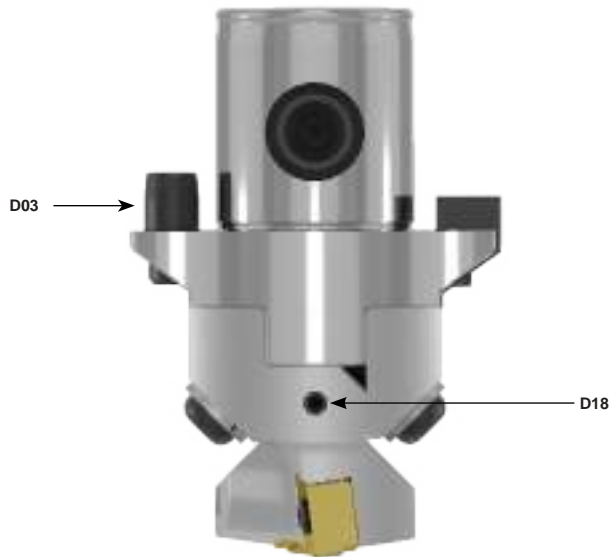
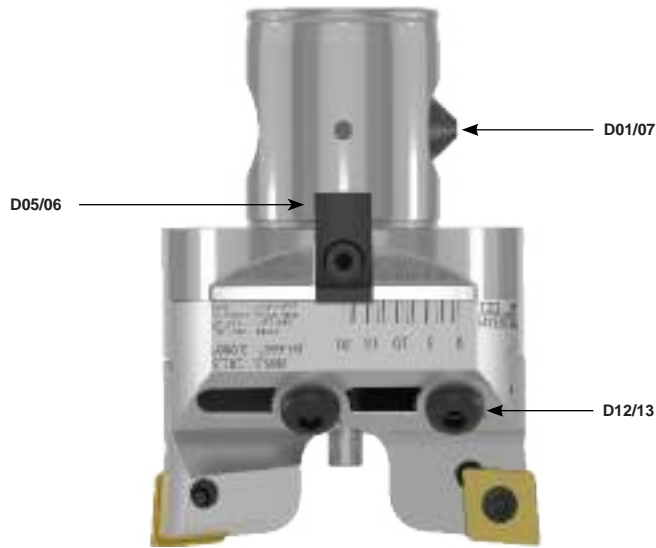


Integral System

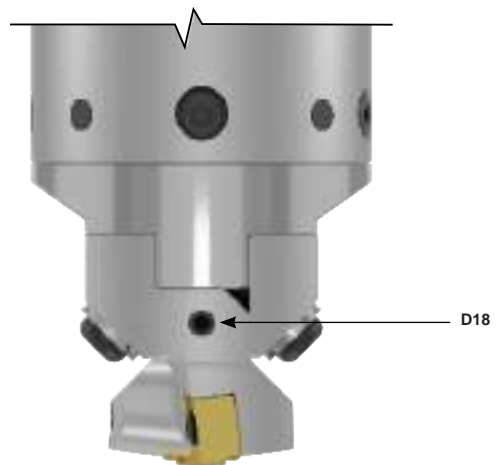
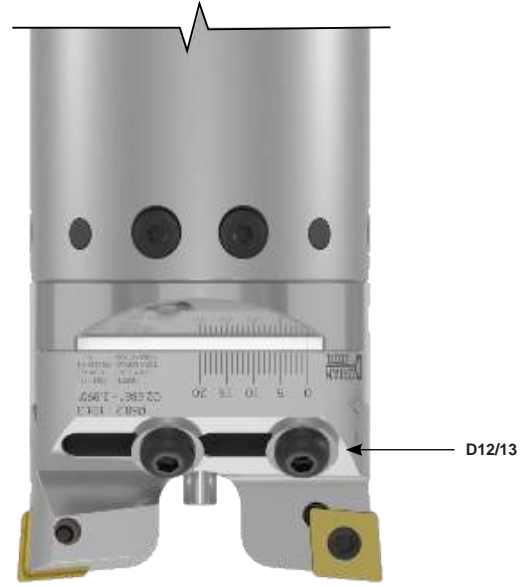


Single Insert Finishing Boring Tool Head		D01/07 Floating Taper Pin Set		D03 Orientation Taper Pin		D05/06 Driving Key Set		D15 Finishing Boring Cartridge Locking Screw Set	
Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC
DST-UQCS-FBH42	63198	D01/07-42-21 FTPS	63337	D03-42-21 OTP	63353	D05/06-42-21 DKS	63369	D15-42-SFBCSS	63422
								D15-42-MFBCSS	63423
								D15-42-LFBCSS	63424
DST-UQCS-FBH50	63199	D01/07-50-21 FTPS	63338	D03-50-21 OTP	63354	D05/06-50-21 DKS	63370	D15-50-SFBCSS	63425
								D15-50-MFBCSS	63426
								D15-50-LFBCSS	63427
DST-UQCS-FBH63	63200	D01/07-63-21 FTPS	63339	D03-63-21 OTP	63355	D05/06-63-21 DKS	63371	D15-63-SFBCSS	63428
								D15-63-MFBCSS	63429
								D15-63-LFBCSS	63430

Quick-Change System

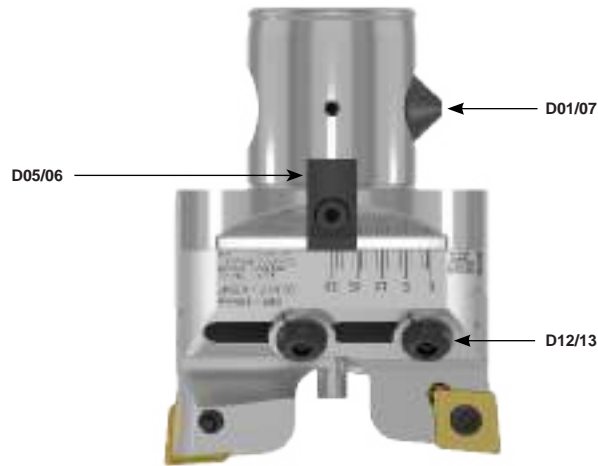


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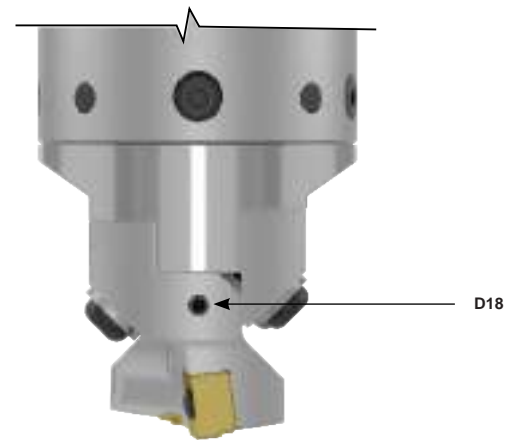


Twin Insert Roughing Boring Tool Head		D01/07 Floating Taper Pin Set		D03 Orientation Taper Pin		D05/06 Driving Key Set		D12/13 Boring Arm Locking Coolant Screw Set		D18 Arm's Diameter Adjustment Screw	
Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC
DST-UQCS-TRH42	63206	D01/07-42-21 FTFS	63337	D03-42-21 OTP	63353	D05/06-42-21 DKS	63369	D12/13-42-BHCS	63400	D18-42-AADS	63408
DST-UQCS-TRH50	63207	D01/07-50-21 FTFS	63338	D03-50-21 OTP	63354	D05/06-50-21 DKS	63370	D12/13-50-BHCS	63401	D18-50-AADS	63409
DST-UQCS-TRH63	63208	D01/07-63-21 FTFS	63339	D03-63-21 OTP	63355	D05/06-50-21 DKS	63371	D12/13-63-BHCS	63402	D18-63-AADS	63410

Quick-Change System

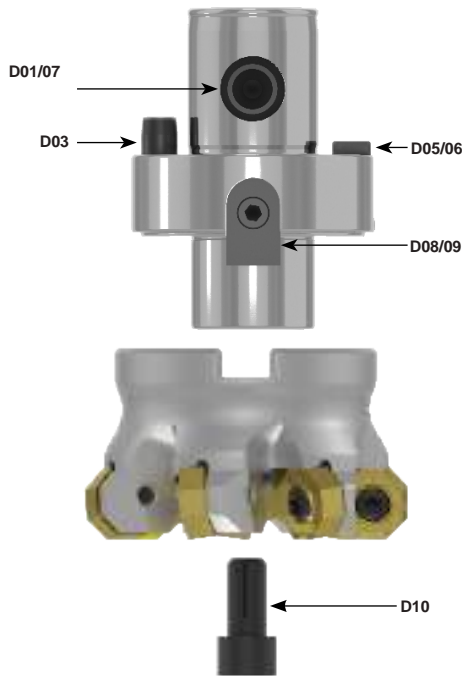


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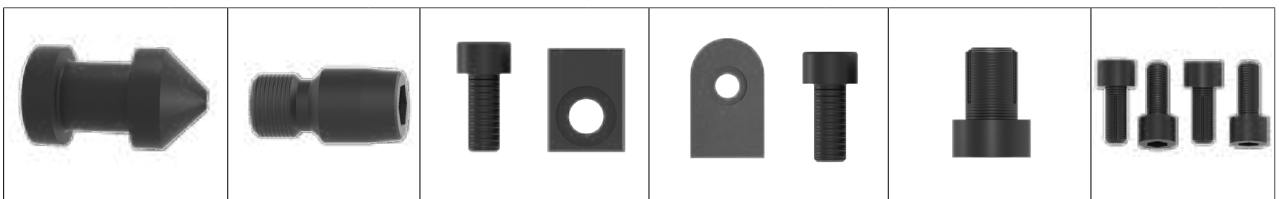
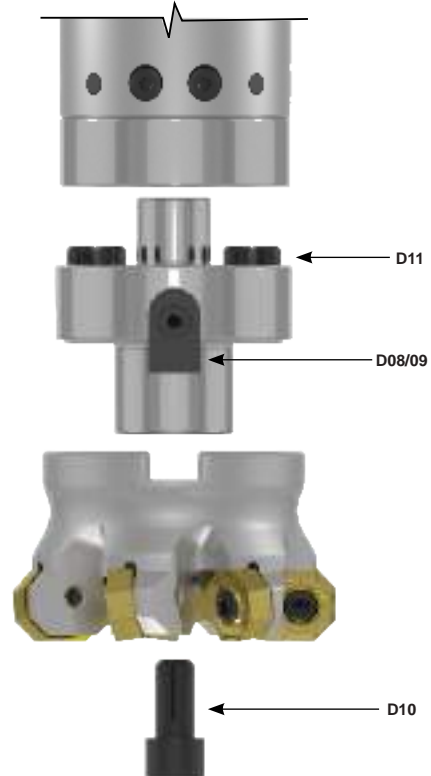


Step Insert Roughing Boring Tool Head		D01/07 Floating Taper Pin Set		UQCS-D03 Orientation Taper Pin		UQCS-D05/06 Driving Key Set		D12/13 Boring Arm Locking Coolant Screw Set		D18 Arm's Diameter Adjustment Screw	
Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC
DST-UQCS-SRH042	63214	D01/07-42-21 FTPS	63337	D03-42-21 OTP	63353	D05/06-42-21 DKS	63369	D12/13-42-BHCS	63400	D18-42-AADS	63408
DST-UQCS-SRH050	63215	D01/07-50-21 FTPS	63338	D03-50-21 OTP	63354	D05/06-50-21 DKS	63370	D12/13-50-BHCS	63401	D18-50-AADS	63409
DST-UQCS-SRH063	63216	D01/07-63-21 FTPS	63339	D03-63-21 OTP	63355	D05/06-63-21 DKS	63371	D12/13-63-BHCS	63402	D18-63-AADS	63410

Quick-Change System



Integral System



Face Mill Adaptor System	D01/07 Floating Taper Pin Set	D03 Orientation Taper Pin	D05/06 Driving Key Set	D08/09 Face Mill Driving Key Set	D10 Face Mill Locking Screw	D11 Interchangeable Adaptor Locking Screw
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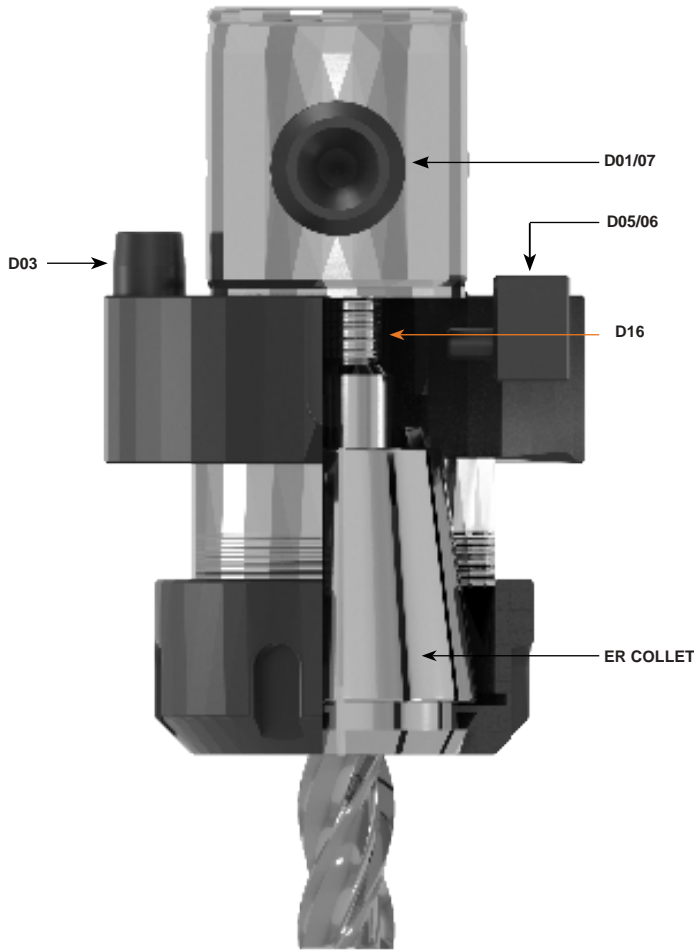
INCH

Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC
DST-UQCS-FMA42-I0750	63293	D01/07-42-21 FTFS	63337	D03-42-21 OTP	63353	D05/06-42-21 DKS	63369	D08/09-0750-FMDKS	63383	D10-0.75-FMLS	63445	D11-42-IALSS	63392
DST-UQCS-FMA42-I1000	63294							D08/09-1000-FMDKS	63384	D10-1.00-FMLS	63437		
DST-UQCS-FMA50-I0750	63295	D01/07-50-21 FTFS	63338	D03-50-21 OTP	63354	D05/06-50-21 DKS	63370	D08/09-0750-FMDKS	63383	D10-0.75-FMLS	63445	D11-50-IALSS	63393
DST-UQCS-FMA50-I1000	63296							D08/09-1000-FMDKS	63384	D10-1.00-FMLS	63437		
DST-UQCS-FMA63-I0750	63297	D01/07-63-21 FTFS	63339	D03-63-21 OTP	63355	D05/06-63-21 DKS	63371	D08/09-0750-FMDKS	63383	D10-0.75-FMLS	63445	D11-63-IALSS	63394
DST-UQCS-FMA63-I1000	63298							D08/09-1000-FMDKS	63384	D10-1.00-FMLS	63437		
DST-UQCS-FMA63-I1500	63299							D08/09-1500-FMDKS	63385	D10-1.50-FMLS	63438		

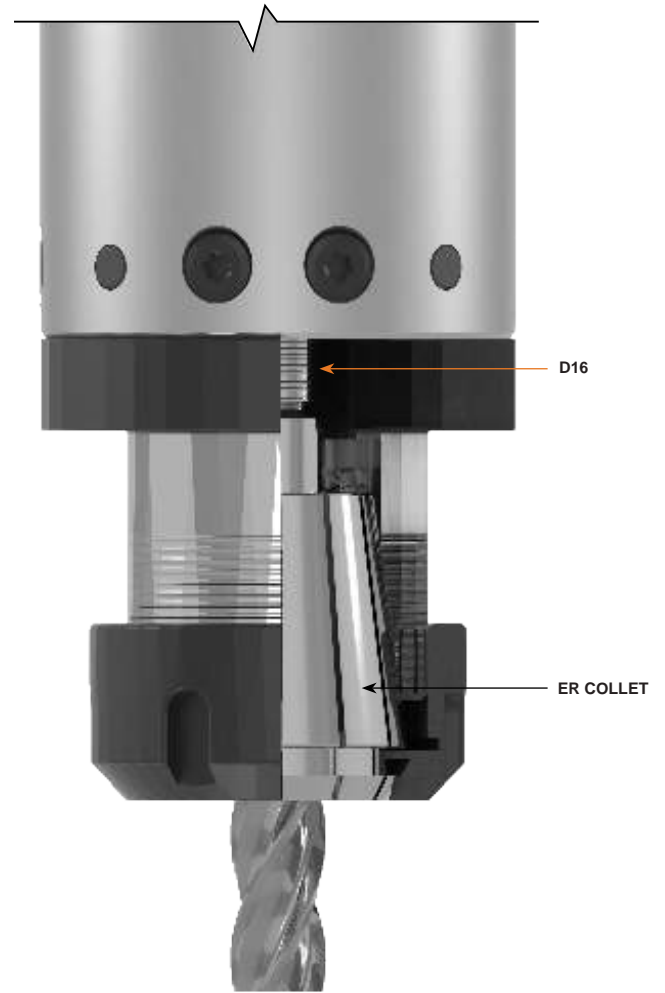
METRIC

Description	UPC	Description	UPC	Description	UPC	Description	UPC	Description	UPC	Description	UPC	Description	UPC
DST-UQCS-FMA42-M13	63300	D01/07-42-21 FTFS	63337	D03-42-21 OTP	63353	D05/06-42-21 DKS	63369	D08/09-13M-FMDKS	63386	D10-13-FMLS	63439	D11-42-IALSS	63392
DST-UQCS-FMA42-M16	63301							D08/09-16M-FMDKS	63387	D10-16-FMLS	63440		
DST-UQCS-FMA42-M22	63302	D01/07-50-21 FTFS	63338	D03-50-21 OTP	63354	D05/06-50-21 DKS	63370	D08/09-22M-FMDKS	63388	D10-22-FMLS	63441	D11-50-IALSS	63393
DST-UQCS-FMA50-M16	63303							D08/09-16M-FMDKS	63387	D10-16-FMLS	63440		
DST-UQCS-FMA50-M22	63304							D08/09-22M-FMDKS	63388	D10-22-FMLS	63441		
DST-UQCS-FMA50-M27	63305	D01/07-63-21 FTFS	63339	D03-63-21 OTP	63355	D05/06-63-21 DKS	63371	D08/09-27M-FMDKS	63389	D10-27-FMLS	63442	D11-63-IALSS	63394
DST-UQCS-FMA63-M16	63306							D08/09-16M-FMDKS	63387	D10-16-FMLS	63440		
DST-UQCS-FMA63-M22	63307							D08/09-22M-FMDKS	63388	D10-22-FMLS	63441		
DST-UQCS-FMA63-M27	63308							D08/09-27M-FMDKS	63389	D10-27-FMLS	63442		
DST-UQCS-FMA63-M32	63309	D01/07-63-21 FTFS	63339	D03-63-21 OTP	63355	D05/06-63-21 DKS	63371	D08/09-32M-FMDKS	63390	D10-32-FMLS	63443	D11-63-IALSS	63394
DST-UQCS-FMA63-M40	63310							D08/09-40M-FMDKS	63391	D10-40-FMLS	63444		

Quick-Change System



Integral System



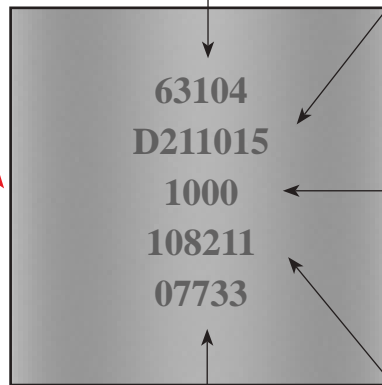
End Mill Tool Head		D01/07 Floating Taper Pin Set		D03 Orientation Taper Pin		D05/06 Driving Key Set		D16 End Mill Stop Screw		ER Collet
Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Part Number	UPC	Please refer pages 32 & 42
DST-UQCS-EMH42-ER20	63206	D01/07-42-21 FTPS	63337	D03-42-21 OTP	63353	D05/06-42-21 DKS	63369	D16-42-EMSS	63449	
DST-UQCS-EMH50-ER25	63207	D01/07-50-21 FTPS	63338	D03-50-21 OTP	63354	D05/06-50-21 DKS	63370	D16-50-EMSS	63450	
DST-UQCS-EMH63-ER32	63208	D01/07-63-21 FTPS	63339	D03-63-21 OTP	63355	D05/06-63-21 DKS	63371	D16-63-EMSS	63451	



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UNIVERSAL PRODUCT
CODE (UPC) NUMBER
5-DIGIT CODE

MANUFACTURED DATE
D-YYMMDD



MANUFACTURING CODE
4-DIGIT CODE

EMPLOYEE INSPECTION
CODE
5-DIGIT CODE

DORIAN TOOL CODE
6-DIGIT CODE





Milling Solution Tool Form

Please check the appropriate boxes below and fill in the required information and attach any tooling or part prints that are necessary - fax: 888-508-7055 or email: sales@doriantool.com

Application Data:

1. Material Information:

Carbon Steel & Alloy Steel

High-Temp Alloys

Stainless Steel

Hardened Steel

Cast Iron

Other: _____

Aluminium & Non-Ferrous Materials

Hardness: _____ HRC

Surface Finish Desired: _____ Ra

2. Machine Information:

Machine Orientation: Horizontal Vertical

Machine Make/Model: _____ Tool Holder Type & Size: _____

3. Type of Operation:

A. Boring

Finish Boring	→	Starting Hole Diameter: _____	Depth of Bore: _____
Rough Boring	→	Ending Hole Diameter: _____	Surface Finish: _____
		Diametrical Tolerance: _____	

B. Milling

End Milling		Cutting Diameter: _____	Cutting Length: _____
Face Milling	→	Tool Cutting Edge Angle: _____	Reach: _____
Side Milling		Pocket Dimensions: _____ x _____ x _____ (L x W x H)	

4. Machining Print Included: Yes No

**For the best tool recommendation and optimal cutting parameters for a specific application, please submit the manufacturing print.*

Milling Solution Tool!™ Technical Support			
Customer Information		Dorian Tool Recommendation	
Company:		Part Number	Part Description
Contact:			UPC
Phone:			
E-mail:			



Introduction

Table of Contents	3
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Product Technical Information

Product Offering Overview	4
Integral System	4
Quick-Change System	4
Anti-Vibration Solution Tool Introduction	5
Principle	5
Purpose	5
Universal Boring and Milling Bar	6
Tool Head Selection Guide	7
Tool Holder Selection Guide	8
Quick Change System	10
Quick-Change System Connection	11
Through System Coolant	11
Quick-Change Finishing Boring Head	15
Quick-Change Roughing Boring Heads	19
Quick-Change Face Mill Adaptor & Milling Cutters	25
Quick-Change End Mill Tool Holder	29
Integral Boring And Milling Bar System	33
Spare Parts	43
Quality Control	50
Milling Solution Tool Form	51

Product Index

Toolholders - Machine Spindle Connections	9
HSK Toolholder	9
SK Toolholder	9
CAT Toolholder	9
BT Toolholder	9
Universal Boring and Milling Bar Specification	12
42mm ST - Universal B & M Bar - Quick-Change System	12
50mm ST - Universal B & M Bar - Quick-Change System	12
63mm ST - Universal B & M Bar - Quick-Change System	12
Universal Boring and Milling Bar	
Quick-Change System Bar Specifications	13
42 mm ST - Universal Quick-Change B & M Bar Specifications	13
50 mm ST - Universal Quick-Change B & M Bar Specifications	13
63 mm ST - Universal Quick-Change B & M Bar Specifications	13
Quick-Change Single Insert Finishing Boring Head	
Overall Cutting Length	16
42mm Quick-Change B & M Bar with Single Insert Tool Head	16
50mm Quick-Change B & M Bar with Single Insert Tool Head	16
63mm Quick-Change B & M Bar with Single Insert Tool Head	16
Quick-Change Single Insert Finishing Boring Head	17
42mm Quick-Change Single Insert Finishing Boring Head	17
50mm Quick-Change Single Insert Finishing Boring Head	17
63mm Quick-Change Single Insert Finishing Boring Head	17
Quick - Change Single Insert Finishing Boring Head - Cartridge	18
42mm SCFCL06 0° Lead Angle, Finishing Boring Cartridge	18
50mm SCFCL09 0° Lead Angle, Finishing Boring Cartridge	18
63mm SCFCL12 0° Lead Angle, Finishing Boring Cartridge	18
42mm SCJCL06 3° Lead Angle, Finishing Boring Cartridge	18
50mm SCJCL09 3° Lead Angle, Finishing Boring Cartridge	18
63mm SCJCL12 3° Lead Angle, Finishing Boring Cartridge	18
42mm STFCL11 0° Lead Angle, Finishing Boring Cartridge	18
50mm STFCL11 0° Lead Angle, Finishing Boring Cartridge	18
63mm STFCL16 0° Lead Angle, Finishing Boring Cartridge	18
42mm SSDCN06 45° Lead Angle, Finishing Boring Cartridge	18
50mm SSDCN09 45° Lead Angle, Finishing Boring Cartridge	18
63mm SSDCN12 45° Lead Angle, Finishing Boring Cartridge	18
Micro Dial Specifications	18
Quick-Change Twin-Insert Roughing Boring Head	
Overall Cutting Length	20
42mm Quick-Change B & M Bar with Twin Insert Tool Head	20
50mm Quick-Change B & M Bar with Twin Insert Tool Head	20
63mm Quick-Change B & M Bar with Twin Insert Tool Head	20
Quick-Change Twin-Insert Roughing Boring Head	21

42mm Quick-Change Twin Insert Roughing Boring Head	21
50mm Quick-Change Twin Insert Roughing Boring Head	21
63mm Quick-Change Twin Insert Roughing Boring Head	21
Quick-Change Step-Insert Roughing Boring Head	
Overall Cutting Length	22
42mm Quick-Change B & M Bar with Step Insert Tool Head	22
50mm Quick-Change B & M Bar with Step Insert Tool Head	22
63mm Quick-Change B & M Bar with Step Insert Tool Head	22
Quick-Change Step-Insert Roughing Boring Head	23
42mm Quick-Change Step Insert Roughing Boring Head	23
50mm Quick-Change Step Insert Roughing Boring Head	23
63mm Quick-Change Step Insert Roughing Boring Head	23
Quick - Change Twin and Step Insert Roughing Head	
Interchangeable Arms	24
42mm SCGCL06 0° Lead Angle, Roughing Boring Arm Set	24
50mm SCGCL09 0° Lead Angle, Roughing Boring Arm Set	24
63mm SCGCL12 0° Lead Angle, Roughing Boring Arm Set	24
42mm SCLCL06 5° Lead Angle, Roughing Boring Arm Set	24
50mm SCLCL09 5° Lead Angle, Roughing Boring Arm Set	24
63mm SCLCL12 5° Lead Angle, Roughing Boring Arm Set	24
42mm SCRCL06 15° Lead Angle, Roughing Boring Arm Set	24
50mm SCRCL09 15° Lead Angle, Roughing Boring Arm Set	24
63mm SCRNL12 15° Lead Angle, Roughing Boring Arm Set	24
63mm SCGNL12 0° Lead Angle, Roughing Boring Arm Set	24
Quick-Change Face Mill Adaptor System	
Overall Cutting Length	26
42mm Quick-Change B & M Bar with Face Mill Adaptor	26
50mm Quick-Change B & M Bar with Face Mill Adaptor	26
63mm Quick-Change B & M Bar with Face Mill Adaptor	26
Quick-Change Face Mill Adaptor System	27
Metric	27
42mm Quick-Change Face Mill Adaptor	27
50mm Quick-Change Face Mill Adaptor	27
63mm Quick-Change Face Mill Adaptor	27
Inch	27
42mm Quick-Change Face Mill Adaptor	27
50mm Quick-Change Face Mill Adaptor	27
63mm Quick-Change Face Mill Adaptor	27
Quick-Change End Mill Tool Holder	
Overall Cutting Length	30
42mm Quick-Change B & M Bar with End Mill Tool Holder	30
50mm Quick-Change B & M Bar with End Mill Tool Holder	30
63mm Quick-Change B & M Bar with End Mill Tool Holder	30
Quick-Change End Mill Tool Holder	31
42mm Quick-Change ER20 Tool Holder	31
50mm Quick-Change ER20 Tool Holder	31
63mm Quick-Change ER20 Tool Holder	31
Ultra Precision ER Collets	32, 42
Ultra Precision ER 20 Collets	32, 42
Ultra Precision ER 25 Collets	32, 42
Ultra Precision ER 32 Collets	32, 42
Integral Single Insert Finishing Boring System	34
42mm Integral Single Insert Finishing Boring System	34
50mm Integral Single Insert Finishing Boring System	34
63mm Integral Single Insert Finishing Boring System	34
Integral Single Insert Finishing Boring System - Cartridge	35
42mm SCFCL06 0° Lead Angle, Finishing Boring Cartridge	35
50mm SCFCL09 0° Lead Angle, Finishing Boring Cartridge	35
63mm SCFCL12 0° Lead Angle, Finishing Boring Cartridge	35
42mm SCJCL06 3° Lead Angle, Finishing Boring Cartridge	35
50mm SCJCL09 3° Lead Angle, Finishing Boring Cartridge	35
63mm SCJCL12 3° Lead Angle, Finishing Boring Cartridge	35
42mm STFCL11 0° Lead Angle, Finishing Boring Cartridge	35
50mm STFCL11 0° Lead Angle, Finishing Boring Cartridge	35
63mm STFCL16 0° Lead Angle, Finishing Boring Cartridge	35
42mm SSDCN06 45° Lead Angle, Finishing Boring Cartridge	35
50mm SSDCN09 45° Lead Angle, Finishing Boring Cartridge	35
63mm SSDCN12 45° Lead Angle, Finishing Boring Cartridge	35
Micro Dial Specifications	35
Integral Twin Insert Roughing Boring System	36
42mm Integral Twin Insert Roughing Boring System	36
50mm Integral Twin Insert Roughing Boring System	36
63mm Integral Twin Insert Roughing Boring System	36
Integral Step Insert Roughing Boring System	37
42mm Integral Step Insert Roughing Boring System	37
50mm Integral Step Insert Roughing Boring System	37
63mm Integral Step Insert Roughing Boring System	37
Integral Twin and Step Insert Roughing System	
Interchangeable Arms	38

42mm SCGCL06 0° Lead Angle, Roughing Boring Arm Set	38
50mm SCGCL09 0° Lead Angle, Roughing Boring Arm Set	38
63mm SCGCL12 0° Lead Angle, Roughing Boring Arm Set	38
42mm SCLCL06 5° Lead Angle, Roughing Boring Arm Set	38
50mm SCLCL09 5° Lead Angle, Roughing Boring Arm Set	38
63mm SCLCL12 5° Lead Angle, Roughing Boring Arm Set	38
42mm SCRCL06 15° Lead Angle, Roughing Boring Arm Set	38
50mm SCRCL09 15° Lead Angle, Roughing Boring Arm Set	38
63mm SCRNL12 15° Lead Angle, Roughing Boring Arm Set	38
63mm SCGNL12 0° Lead Angle, Roughing Boring Arm Set	38
Integral Face Mill Adaptor System	39
42mm Integral Face Mill Adaptor System	39
50mm Integral Face Mill Adaptor System	39
63mm Integral Face Mill Adaptor System	39
Interchangeable Face Mill Adaptor	40
Metric	40
42mm Interchangeable Metric Face Mill Adaptor	40
50mm Interchangeable Metric Face Mill Adaptor	40
63mm Interchangeable Metric Face Mill Adaptor	40
Inch	40
42mm Interchangeable Inch Face Mill Adaptor	40
50mm Interchangeable Inch Face Mill Adaptor	40
63mm Interchangeable Inch Face Mill Adaptor	40
Integral End Mill Tool Holder System	41
42mm Integral ER20 Collet Tool Holder System	41
50mm Integral ER20 Collet Tool Holder System	41
63mm Integral ER20 Collet Tool Holder System	41
Spare Parts	44
D01/07 Floating Taper Pin Set	44, 45, 46, 47, 48, 49
D03 Orientation Taper Pin	44, 45, 46, 47, 48, 49
D04 Locking Taper Pin	44
D05/06 Driving Key Set	44, 45, 46, 47, 48, 49
D08/09 Face Mill Driving Key Set	48
D10 Face Mill Locking Screw	48
D11 Interchangeable Adaptor Locking Screw	48
D12/13 Boring Arm Locking Coolant Screw Set	46, 47
D14-1 & D14-2 Bar Tuning & Stop Screws	44
D15 Finishing Boring Cartridge Locking Screw Set	45
D16 End Mill Stop Screw	49
D18 Arm's Diameter Adjustment Screw	46, 47

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