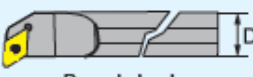
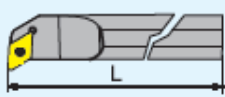
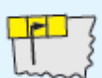
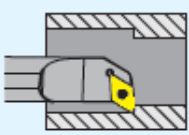
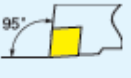
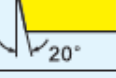
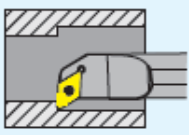
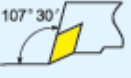
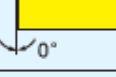


# Identification System for Internal Turning Toolholders (Boring Bars)

<https://www.carbidemart.com/toforintubba.html>

| Boring bars type                      | Boring bars diameter                                                                                                                                               | Boring bars length                                                                                                  | Insert shape                                                                                           |                                                                                                        |
|---------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|
| Steel with cooling hole<br><b>A</b>   | <br>Round shanks:<br>shown in 1/16" increments                                    | <br>L                              | <br>80°<br><b>C</b> | <br>55°<br><b>D</b> |
| Carbide<br><b>C</b>                   | 04 = 0.250"<br>05 = 0.3125"<br>06 = 0.375"<br>08 = 0.500"<br>10 = 0.625"<br>12 = 0.750"<br>16 = 1.000"<br>20 = 1.250"<br>24 = 1.500"<br>32 = 2.000"<br>40 = 2.500" | H = 4"<br>J = 4-1/2"<br>K = 5"<br>M = 6"<br>Q = 7"<br>R = 8"<br>S = 10"<br>T = 12"<br>U = 14"<br>V = 16"<br>Y = 20" | <br>55°<br><b>K</b> | <br><b>R</b>        |
| Carbide with cooling hole<br><b>E</b> |                                                                                                                                                                    |                                                                                                                     | <br>90°<br><b>S</b> | <br>60°<br><b>T</b> |
| Steel<br><b>S</b>                     |                                                                                                                                                                    |                                                                                                                     | <br>35°<br><b>V</b> | <br>80°<br><b>W</b> |

**S 16 T - S C L C R - 3**

| Insert mounting method                                                                               | Boring bars style                                                                                            | Insert clearance angle                                                                                 | Cutting direction                                                                                    | Insert I.C size                                                                                                             |
|------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|
| <br>P-Lever Clamp | <br>75°<br><b>K</b>       | <br>5°<br><b>B</b>  | <br>L-Left hand  | <br>Number of 1/8" of inscribed circle |
| <br>M-multi Clamp | <br>90°<br><b>F</b>       | <br>7°<br><b>C</b>  |                                                                                                      | 2 = 0.250"                                                                                                                  |
| <br>S-Screw Clamp | <br>93°<br><b>U</b>       | <br>15°<br><b>D</b> |                                                                                                      | 3 = 0.375"                                                                                                                  |
| <br>C-Top Clamp   | <br>95°<br><b>L</b>       | <br>20°<br><b>E</b> | <br>R-Right hand | 4 = 0.500"                                                                                                                  |
|                                                                                                      | <br>107° 3/4°<br><b>Q</b> | <br>0°<br><b>N</b>  |                                                                                                      | 5 = 0.625"                                                                                                                  |
|                                                                                                      |                                                                                                              | <br>11°<br><b>P</b> |                                                                                                      | 6 = 0.750"                                                                                                                  |
|                                                                                                      |                                                                                                              |                                                                                                        |                                                                                                      | 7 = 0.875"                                                                                                                  |
|                                                                                                      |                                                                                                              |                                                                                                        |                                                                                                      | 8 = 1.000"                                                                                                                  |