

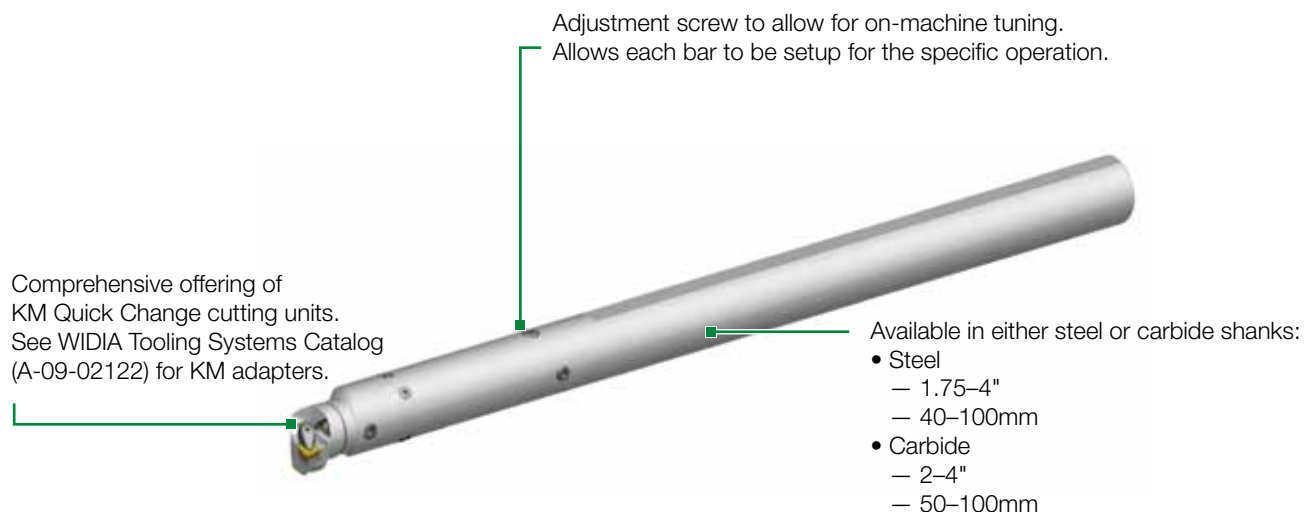
Tunable Boring Bars
ADVANCES 2015

WIDIA ™

Tunable Boring Bars with Front End KM™ Quick Change Adapter

Reduce vibrations and enhance productivity in deep boring applications with KM Quick Change heads and tunable boring bars.

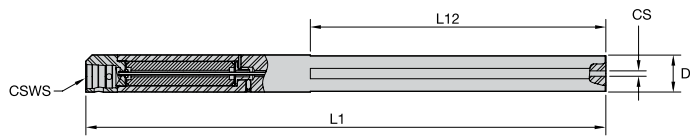
Tunable Boring Bars



Features	Function	Benefit
Robust internal clamping package	<ul style="list-style-type: none"> • Eliminates chatter and vibration. • Higher metal removal rate. • Larger depths of cut. 	<ul style="list-style-type: none"> • High surface quality. • Low scrap rate. • Increased productivity. • Reduced noise exposure.
Tunable clamping mechanism	Bar can tuned on the machine with just turning a screw	Optimized damping characteristics for all kinds of machining conditions.
KM™ Quick Change front end adapter	<ul style="list-style-type: none"> • Ridged clamping system. • Wide selection of KM Quick Change cutting units. 	Flexible system reduces tooling inventory and setup times.

■ Tuning Procedure

1. Loosen the two locking screws on the bar.
2. Turn the adjusting screw in the positive direction until it becomes snug. The adjusting screw becomes snug when it locks the tuner mass.
3. Turn the screw one complete turn in the negative direction and take a test cut.
4. Repeat Step 3 until chatter is eliminated.
5. Once chatter is eliminated, note that chatter starts between the current screw setting and one turn in the positive direction. Make 1/4 turn adjustments within this range, taking test cuts for each setting, until you can identify the adjusting screw setting that causes chatter to start.
6. Once the adjusting screw setting that causes chatter is determined, back the adjusting screw off a 1/2 turn in the negative direction.
7. Tighten both clamping screws and take a test cut to confirm desired results.



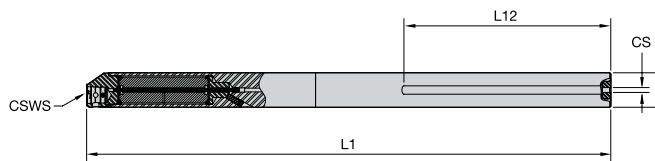
Tunable steel shank with through coolant and front end KM™ clamping unit.



■ D...TTB-KM • Inch

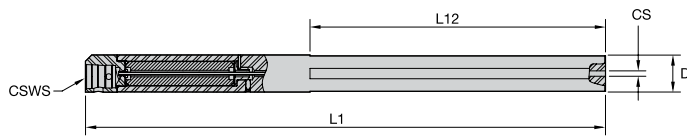
order number	catalog number	D	L1	CS	L12	L1 min	CSWS system size
3637915	D28TTB26KM40	1.750	24.44	1/4-18 NPT	15.75	13.50	KM40
3637916	D32TTB29KM40	2.000	27.44	1/4-18 NPT	18.50	13.38	KM40
3637917	D40TTB36KM40	2.500	34.45	1/4-18 NPT	24.75	16.00	KM40
3638033	D48TTB45KM63	3.000	42.23	1/4-18 NPT	24.00	21.70	KM63
3638034	D64TTB58KM63	4.000	56.24	3/8-18 NPT	20.00	27.62	KM63

- Carbide tunable boring bar with KM™ Quick Change connection.



■ G-KM-TTB • Inch

order number	catalog number	D	L1	CS	L12	CSWS system size
3954294	G32TTB41KM40	2.000	39.45	3/8-18 NPT	12.00	KM40
3954295	G40TTB51KM40	2.500	49.45	3/8-18 NPT	15.00	KM40
3954296	G48TTB63KM63	3.000	58.56	3/8-18 NPT	18.00	KM63
3954297	G64TTB79KM63	4.000	76.56	3/8-18 NPT	24.00	KM63



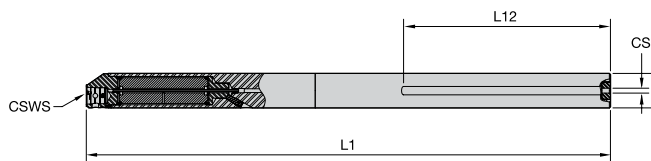
Tunable steel shank with through coolant and front end KM™ clamping unit.



■ D...TTB-KM • Metric

order number	catalog number	D	L1	CS	L12	L1 min	CSWS system size
3637636	D40MTTB560KM40	40	520	RP 3/8-19	305	330	KM40
3637637	D50MTTB737KM40	50	697	RP 3/8-19	470	337	KM40
3637638	D60MTTB1000KM40	60	976	RP 3/8-19	686	396	KM40
3642134	D80MTTB1120KM63	80	1060	RP 3/8-19	610	560	KM63
3642135	D100MTTB1330KM63	100	1384	RP 3/8-19	622	695	KM63

- Carbide tunable boring bar with KM Quick Change connection.



■ G-KM-TTB • Metric

order number	catalog number	D	L1	CS	L12	CSWS system size
3954298	G50MTTB1026KM40	50	986	RP 3/8-19	300	KM40
3954299	G60MTTB1226KM40	60	1186	RP 3/8-19	381	KM40
3954300	G80MTTB1564KM63	80	1504	RP 3/8-19	480	KM63
3954301	G100MTTB2066KM63	100	1975	RP 3/8-19	600	KM63

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