

Precision Finish Boring

Small Diameter Boring .078" to 1.342" (2mm to 34mm)

SMALL DIAMETER BORING HEADS FOR TOOL ROOM OR PRODUCTION



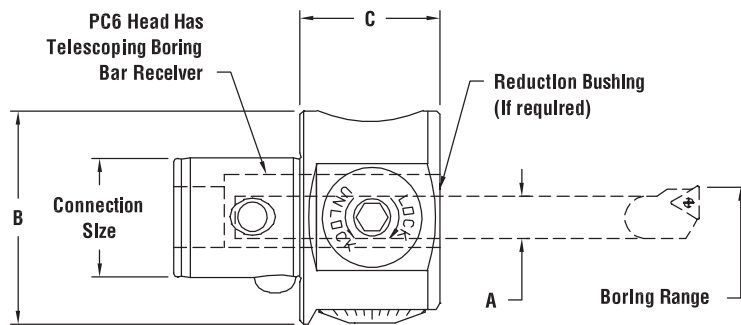
PC6-2015TR shown here.

Recommended up to .984 for Production.

- A .0001" vernier is standard on all heads eliminating the need to purchase expensive .0001" heads.
- Micrometer spindle provides .001" per dial graduation for fast, accurate set-up and adjustment, and reduced scrap.
- No movement between lock and unlock eliminates setting errors common to other systems.
- Well balanced, fully encased in head tool carrier can be run at high speeds.
- Bored-through tool receiver (TR only) allows the boring tool to be telescoped for optimum rigidity.
- All system components with through-hole permits through-spindle coolant.



Vernier Scale with reference marks. See page 145.



INCH GRADUATED UNITS

.001" per dial graduation with .0001" Vernier

Part Number	Bore Range Min.	Bore Range Max.	Connection Size	A	B	C	Radial Adjust.	Weight (lbs.)
PC4-2015	.078	.790	PC4	.500	2.00	1.50	.100	1.0
PC6-2015P	.078	.984	PC6	.625	2.52	1.65	.100	2.8
PC6-2015TR	.078	1.342	PC6	.625	2.52	1.65	.312	2.4

METRIC GRADUATED UNITS

.02 mm per dial graduation with .002 mm Vernier

Part Number	Bore Range Min.	Bore Range Max.	Connection Size	A	B	C	Radial Adjust.	Weight (lbs.)
PC4-2005	2	20	PC4	12.7	50.8	38.1	2.5	1.0
PC4-201205	2	20	PC4	12	50.8	38.1	2.5	.5
PC6-2005P	2	25	PC6	15.875	64	42	2.5	2.8
PC6-2005TR	2	34	PC6	15.875	64	42	7.92	2.4
PC6-201605	2	34	PC6	16	64	42	7.92	2.4

Part numbers in **bold face** are in-stock items.

*Range can be extended by using boring bars not available in this catalog.
To establish maximum diameter for each boring bar: Boring bar minimum diameter +2x adjustment.

Precision Finish Boring

Small Diameter Boring Screws, Pins & Wrenches

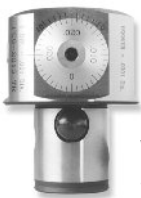


BORING

SMALL DIAMETER BORING HEAD



Wrench
018-105.



Vernier
Scale side.



Slide Lock
Screw side.



Clamp
Screws side.



Oil side.

SMALL DIAMETER BORING HEAD

Part Number	Boring Bar Holder Screw	Slide Lock Screw	Wrench	PC Pin
PC4-2015	029-517	029-018	018-105	PCP-004
PC6-2015 (X)	029-089	029-089	018-105	PCP-S06

Part numbers in **bold face** are in-stock items.

Precision Finish Boring

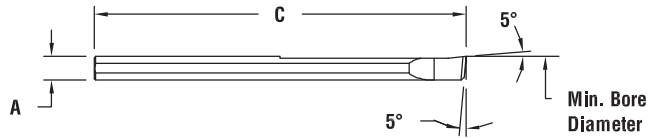
Small Diameter Boring Bars & Holders

.118" to .315" (2mm to 8mm)

BORING BARS



Boring Bar
CB2-0778-393-KW10
shown here.



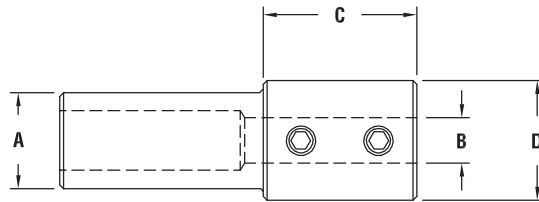
BORING BARS .118" - .315" DIAMETER

Part Number	Bore Dia. Min.	Bore Dia. Max.	Boring Bar Holder	Depth	Max. Bore A (Dia.)	C Length	Grade
CB2-078-393-KW10	.078 (2)	.118 (3)	50RBX-02MM	.393 (10)	.078 (2)	1.97 (50)	Carbide
CB3-118-590-KW10	.118 (3)	.157 (4)	50RBX-03MM	.590 (15)	.118 (3)	1.97 (50)	Carbide
CB4-157-787-KW10	.157 (4)	.196 (5)	50RBX-04MM	.787 (20)	.157 (4)	2.36 (60)	Carbide
CB4-157-787-TC60	.157 (4)	.196 (5)	50RBX-04MM	.787 (20)	.157 (4)	2.36 (60)	Cermet
CB5-196-984-KW10	.196 (5)	.236 (6)	50RBX-05MM	.984 (25)	.196 (5)	2.76 (70)	Carbide
CB5-196-984-TC60	.196 (5)	.236 (6)	50RBX-05MM	.984 (25)	.196 (5)	2.76 (70)	Cermet
CB6-236-1180-KW10	.236 (6)	.275 (7)	50RBX-06MM	1.180 (30)	.236 (6)	2.76 (70)	Carbide
CB6-236-1180-TC60	.236 (6)	.275 (7)	50RBX-06MM	1.180 (30)	.236 (6)	2.76 (70)	Cermet
CB7-275-1377-KW10	.275 (7)	.315 (8)	50RBX-07MM	1.377 (35)	.275 (7)	3.15 (80)	Carbide
CB7-275-1377-TC60	.275 (7)	.315 (8)	50RBX-07MM	1.377 (35)	.275 (7)	3.15 (80)	Cermet

METRIC BORING BAR HOLDER



Boring Bar Holder
50RBX-02MM
shown here.



BORING BAR HOLDER

Part Number	A	B	C	D
50RBX-02MM	.500	2MM	.62	.62
50RBX-03MM	.500	3MM	.62	.62
50RBX-04MM	.500	4MM	.62	.62
50RBX-05MM	.500	5MM	.62	.62
50RBX-06MM	.500	6MM	.62	.62
50RBX-07MM	.500	7MM	.62	.62

Part numbers in **bold face** are in-stock items.

Precision Finish Boring

Small Diameter Boring Bars & Bushings



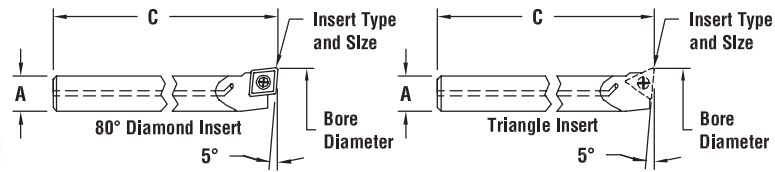
.188" to 1.000" (4.78mm to 25.4mm)

BORING

BORING BARS



Boring Bar
SB37-43T105
shown here.



BORING BARS .188" - 1.000" DIAMETER

Part Number	Coolant Part Number	Bore Diameter Min.	Bore Diameter Max.*	Reduction Bushing	Max. Bore Depth	A (Dia.)	C	Bar Material	Insert Type/Size	Insert Screw	Insert Screw Wrench
CB15-18C056	CB15-18C056C	.188	.218	XXRB-156	1.50	.156	6.00	Carbide	CDCD 05	028-919	018-002
SB18-18C052	-	.188	.218	XXRB-187	.50	.187	2.50	Steel	CDCD 05	028-919	018-002
CB18-21C054	-	.218	.232	XXRB-187	2.00	.187	4.00	Carbide	CDCD 05	028-919	018-002
SB18-23C052	-	.232	.300	XXRB-187	1.00	.187	2.50	Steel	CDCD 05	028-919	018-002
CB18-23C054	CB18-23C054C	.232	.300	XXRB-187	2.00	.187	4.00	Carbide	CDCD 05	028-919	018-002
SB18-28T053	-	.280	.300	XXRB-187	1.00	.187	3.50	Steel	TDAB 05	028-920	018-007
CB18-29T054	CB18-29T054C	.290	.310	XXRB-187	2.00	.187	4.00	Carbide	TDAB 05	028-920	018-007
SB25-29C053	-	.290	.310	XXRB-250	1.25	.250	3.00	Steel	CDCD 05	028-919	018-002
SB25-30T054	-	.300	.362	XXRB-250	1.25	.250	4.00	Steel	TDAB 05	028-920	018-007
CB25-30C054	CB25-30C054C	.300	.362	XXRB-250	2.50	.250	4.00	Carbide	CDCD 05	028-919	018-002
CB25-31T054	CB25-31T054C	.310	.372	XXRB-250	2.50	.250	4.00	Carbide	TDAB 05	028-920	018-007
SB31-36T054	-	.362	.430	XXRB-312	1.75	.312	4.00	Steel	TDAB 05	028-920	018-007
CB31-37T056	CB31-37T056C	.372	.440	XXRB-312	3.25	.312	6.00	Carbide	TDAB 05	028-920	018-007
SB37-43T105	SB37-43T105C	.430	.580	XXRB-375	2.00	.375	5.00	Steel	TPGH 11	028-921	018-003
CB37-44T107	CB37-44T107C	.440	.590	XXRB-375	4.00	.375	7.00	Carbide	TPGH 11	028-921	018-003
SB50-58T106	SB50-58T106C	.580	.717	XXRB-500	2.50	.500	5.00	Steel	TPGH 11	028-921	018-003
CB50-59T107	CB50-59T107C	.590	.717	XXRB-500	5.00	.500	7.00	Carbide	TPGH 11	028-921	018-003
SB62-71T117	SB62-71T117C	.717	1.000	-	3.50	.625	7.00	Steel	TPGH 11	028-921	018-003
CB62-71T118	CB62-71T118C	.717	1.000	-	6.00	.625	8.00	Carbide	TPGH 11	028-921	018-003
-	CB62-83T117C	.83	1.45	-	3.50	.625	7.00	Carbide	TPGH 11	028-921	018-003
-	SB62-83T114C	.83	1.45	-	2.5	.625	4.00	Steel	TPGH 11	028-921	018-003

Part numbers in **bold face** are in-stock items.

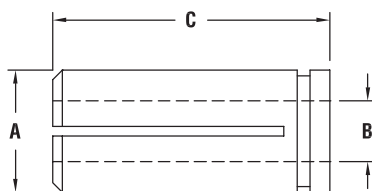
Order Inserts separately (see next page).

*Recommended for Production. For maximum range, see page 124. Minimum bore diameter above is based on a gage insert with .016" nose radius.

REDUCTION BUSHINGS



Reduction Bushing 62RB-250
shown here.



REDUCTION BUSHINGS

Part Number	A	B	C	Weight (lbs.)
50RB-156	.500	.156	1.18	.1
50RB-187	.500	.187	1.18	.1
50RB-250	.500	.250	1.18	.1
50RB-312	.500	.312	1.18	.1
50RB-375	.500	.375	1.18	.1
62RB-08mm	.625	8mm	1.42	.1
62RB-10mm	.625	10mm	1.42	.1
62RB-12mm	.625	12mm	1.42	.1
62RB-156	.625	.156	1.42	.1
62RB-187	.625	.187	1.42	.1
62RB-219	.625	.219	1.42	.1
62RB-250	.625	.250	1.42	.1
62RB-312	.625	.312	1.42	.1
62RB-375	.625	.375	1.42	.1
62RB-438	.625	.438	1.42	.1
62RB-500	.625	.500	1.42	.1

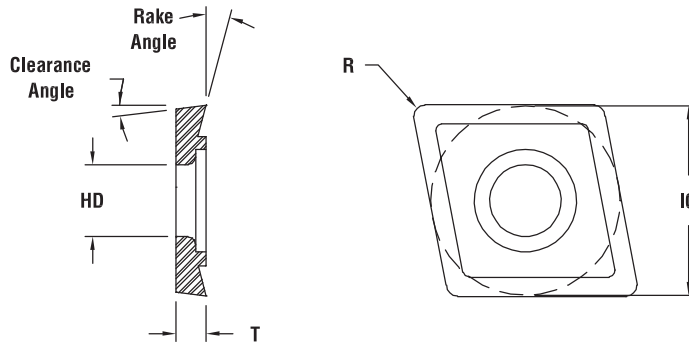
Precision Finish Boring

Small Diameter Boring Inserts – 80° Diamond



80° Diamond Insert
C050700C1G
shown here.

At Parlec, the phrase “measurably better” isn’t just a slogan. It’s a commitment to you. Our philosophy of providing “measurably better” products to our customers guarantees that you will be able to meet all of your quality, cost and delivery requirements.



SIZE CDCD 05

Part Number	IC	Clearance Angle	R	T	Rake Angle	HD	Grade	Type	Periphery
C050700C1G	.156	15°	.007	.040	0°	.084	C1	Uncoated	Ground
C051600C1G	.156	15°	.016	.040	0°	.084	C1	Uncoated	Ground
C050700C2G	.156	15°	.007	.040	0°	.084	C2	Uncoated	Ground
C051600C2G	.156	15°	.016	.040	0°	.084	C2	Uncoated	Ground
C050700TRG	.156	15°	.007	.040	0°	.084	TR	Coated	Ground
C051600TRG	.156	15°	.016	.040	0°	.084	TR	Coated	Ground
C050700CRG	.156	15°	.007	.040	0°	.084	CR	Cermet	Ground
C051600CRG	.156	15°	.016	.040	0°	.084	CR	Cermet	Ground
C050700ALG	.156	15°	.007	.040	0°	.084	AL	Coated	Ground
C051600ALG	.156	15°	.016	.040	0°	.084	AL	Coated	Ground
C050700PCD	.156	15°	.007	.040	0°	.084	PCD	Diamond	Ground
C051600PCD	.156	15°	.016	.040	0°	.084	PCD	Diamond	Ground

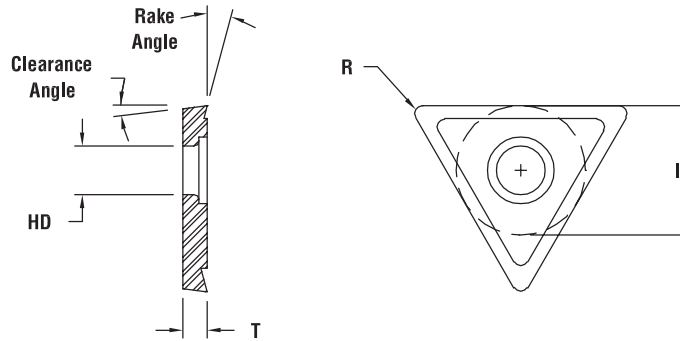
Part numbers in **bold face** are in-stock items.

Precision Finish Boring

Small Diameter Boring Inserts – Triangular



Triangle Insert T050700C1G shown here.



SIZE TDAB 05

Part Number	IC	Clearance Angle	R	T	Rake Angle	HD	Grade	Type	Periphery
T050700C1G	.160	15°	.007	.047	0°	.094	C1	Uncoated	Ground
T051600C1G	.160	15°	.016	.047	0°	.094	C1	Uncoated	Ground
T050700C2G	.160	15°	.007	.047	0°	.094	C2	Uncoated	Ground
T051600C2G	.160	15°	.016	.047	0°	.094	C2	Uncoated	Ground
T050700TRG	.160	15°	.007	.047	0°	.094	TR	Coated	Ground
T051600TRG	.160	15°	.016	.047	0°	.094	TR	Coated	Ground
T050700CRG	.160	15°	.007	.047	0°	.094	CR	Cermet	Ground
T051600CRG	.160	15°	.016	.047	0°	.094	CR	Cermet	Ground
T050700ALG	.160	15°	.007	.047	0°	.094	AL	Coated	Ground
T051600ALG	.160	15°	.016	.047	0°	.094	AL	Coated	Ground
T050700PCD	.160	15°	.007	.047	0°	.094	PCD	Diamond	Ground
T051600PCD	.160	15°	.016	.047	0°	.094	PCD	Diamond	Ground

SIZE TPGH 11

Part Number	IC	Clearance Angle	R	T	Rake Angle	HD	Grade	Type	Periphery
TP110715C1G	.250	11°	.007	.096	15°	.130	C1	Uncoated	Ground
TP111615C1G	.250	11°	.015	.096	15°	.130	C1	Uncoated	Ground
TP110715C2G	.250	11°	.007	.096	15°	.130	C2	Uncoated	Ground
TP111615C2G	.250	11°	.015	.096	15°	.130	C2	Uncoated	Ground
TP110715TRG	.250	11°	.007	.096	15°	.130	TR	Coated	Ground
TP111615TRG	.250	11°	.015	.096	15°	.130	TR	Coated	Ground
TP110715CRG	.250	11°	.007	.096	15°	.130	CR	Cermet	Ground
TP111615CRG	.250	11°	.015	.096	15°	.130	CR	Cermet	Ground
TP110715ALG	.250	11°	.007	.096	15°	.130	AL	Coated	Ground
TP111615ALG	.250	11°	.015	.096	15°	.130	AL	Coated	Ground
TP110700PCD	.250	11°	.007	.096	0°	.130	PCD	Diamond	Ground
TP111600PCD	.250	11°	.015	.096	0°	.130	PCD	Diamond	Ground

Part numbers in **bold face** are in-stock items.