



PATRIOT
HIGH ★ PERFORMANCE

**STEALTH™
BORING BARS**





The patriot who was fearless in the quest to preserve America and is the backbone for the foundation of the new cutting tool portfolio. ARCH Cutting Tools is leveraging its American spirit to offer the ALL-NEW; Patriot High Performance®.

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STEALTH BORING BARS

Tunable Internal Damping Technology



5:1 Up To
14:1 Ratio

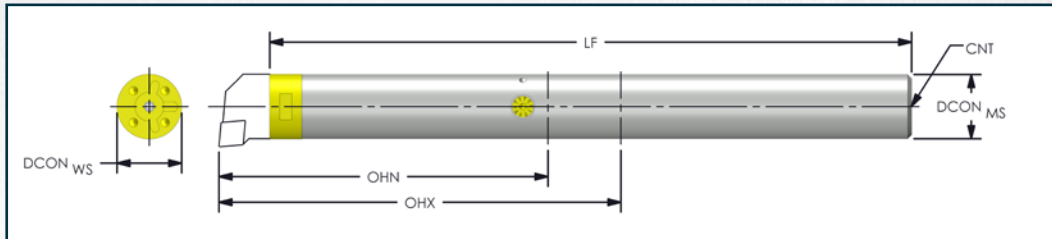
0.500"-4.00" Diameters



Product Highlights:

Tunable Internal Damping Technology provides optimal dynamic stability yielding significant increases in machining performance. Most importantly, the bars pay for themselves quickly by increasing speed and precision. Additionally, you can leave Stealth Tooling "CFT" in the machine and use it for deep or shallow bore applications, thus reducing changeover and setup time.

- Fully tunable boring bar (arrives pre-tuned)
- Labeled dial for ease of tuning
- Quick setup flat located on connection end of bar
- Solves difficult deep boring applications
- Improved surface finish
- Increase output by more aggressive cutting
- Increase tool life from reduced vibration
- Multiple head configurations


MODULAR STEALTH™ BARS IMPERIAL

5:1 Ratio
Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LF	OHN	OHX	Head Bolts	CNT
910-000-013	CFT B1500-9	1.500	1.500	9.000	7.000	7.500	10-24 HB	1/8-27 NPT
910-000-018	CFT B2000-12	2.000	2.000	12.000	7.500	10.000	1/4-20 HB	1/8-27 NPT
910-000-023	CFT B2500-16	2.500	2.500	16.000	8.000	12.500	5/16-18 HB	1/8-27 NPT

7:1 Ratio

910-000-001	CFT B1000-10	1.000	1.000	10.000	5.000	7.000	8-32 HB	1/8-27 NPT
910-000-005	CFT B1250-12	1.250	1.250	12.000	6.250	8.750	10-24 HB	1/8-27 NPT
910-000-009	CFT B1500-15	1.500	1.500	15.000	7.500	10.500	10-24 HB	1/8-27 NPT
910-000-014	CFT B1750-18	1.750	1.750	18.000	8.7500	12.250	1/4-20 HB	1/8-27 NPT
910-000-019	CFT B2000-20	2.000	2.000	20.000	10.000	14.000	1/4-20 HB	1/8-27 NPT
910-000-024	CFT B2500-27	2.500	2.500	27.000	12.500	17.500	5/16-18 HB	1/4-18 NPT
910-000-028	CFT B3000-31	3.000	2.500	31.000	15.000	21.000	5/16-18 HB	1/4-18 NPT

10:1 Ratio

910-000-002	CFT B1000-14	1.000	1.000	14.000	7.000	10.000	8-32 HB	1/8-27 NPT
910-000-006	CFT B1250-16	1.250	1.250	16.000	8.750	12.500	10-24 HB	1/8-27 NPT
910-000-010	CFT B1500-19	1.500	1.500	19.000	10.500	15.000	10-24 HB	1/8-27 NPT
910-000-015	CFT B1750-23	1.750	1.750	23.000	12.250	17.500	1/4-20 HB	1/8-27 NPT
910-000-020	CFT B2000-26	2.000	2.000	26.000	14.000	20.000	1/4-20 HB	1/8-27 NPT
910-000-025	CFT B2500-33	2.500	2.500	33.000	17.500	25.000	5/16-18 HB	1/4-18 NPT
910-000-029	CFT B3000-40	3.000	2.500	40.000	21.000	30.000	5/16-18 HB	1/4-18 NPT
910-000-034	CFT B4000-50	4.000	2.500	50.000	28.000	40.000	5/16-18 HB	1/4-18 NPT

12:1 Ratio

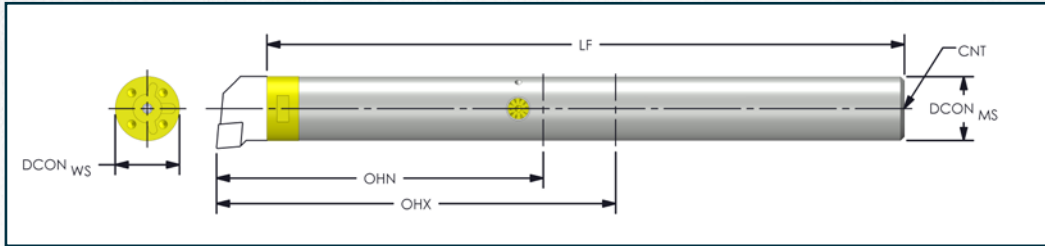
910-000-003	CFT B1000-16	1.000	1.000	16.000	10.875	12.000	8-32 HB	N/A
910-000-058	CFT B1250-18	1.250	1.250	18.000	13.785	15.000	10-24 HB	N/A
910-000-011	CFT B1500-22	1.500	1.500	22.000	16.375	18.000	10-24 HB	N/A
910-000-016	CFT B1750-25	1.750	1.750	25.000	18.060	21.000	1/4-20 HB	N/A
910-000-021	CFT B2000-29	2.000	2.000	29.000	19.375	24.000	1/4-20 HB	N/A

14:1 Ratio

910-000-004	CFT B1000-18	1.000	1.000	18.000	10.875	12.000	8-32 HB	N/A
910-000-008	CFT B1250-21	1.250	1.250	21.000	13.875	15.000	10-24 HB	N/A
910-000-012	CFT B1500-25	1.500	1.500	25.000	16.375	18.000	10-24 HB	N/A
910-000-017	CFT B1750-29	1.750	1.750	29.000	18.060	21.000	1/4-20 HB	N/A
910-000-022	CFT B2000-33	2.000	2.000	33.000	19.375	24.000	1/4-20 HB	N/A



MODULAR STEALTH™ BARS METRIC



7:1 Ratio

Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LF	OHN	OHX	Head Bolts	CNT
910-000-077	CFT B25MM-250	25mm	1.000	250mm	127mm	175mm	8-32 HB	1/8-27 NPT
910-000-079	CFT B32MM-320	32mm	1.250	320mm	159mm	224mm	10-24 HB	1/8-27 NPT
910-000-083	CFT B40MM-400	40mm	1.500	400mm	190mm	280mm	10-24 HB	1/8-27 NPT
910-000-087	CFT B50MM-500	50mm	2.000	500mm	254mm	350mm	1/4-20 HB	1/8-27 NPT
910-000-091	CFT B60MM-600	60mm	2.000	600mm	320mm	420mm	1/4-20 HB	1/8-27 NPT

10:1 Ratio

910-000-078	CFT B25MM-325	25mm	1.000	325mm	178mm	250mm	8-32 HB	1/8-27 NPT
910-000-080	CFT B32MM-416	32mm	1.250	416mm	223mm	320mm	10-24 HB	1/8-27 NPT
910-000-084	CFT B40MM-520	40mm	1.500	520mm	266mm	400mm	10-24 HB	1/8-27 NPT
910-000-088	CFT B50MM-650	50mm	2.000	650mm	356mm	500mm	1/4-20 HB	1/8-27 NPT
910-000-092	CFT B60MM-780	60mm	2.000	780mm	445mm	600mm	1/4-20 HB	1/8-27 NPT

12:1 Ratio

910-000-081	CFT B32MM-480	32mm	1.250	480mm	352mm	384mm	10-24 HB	N/A
910-000-085	CFT B40MM-600	40mm	1.500	600mm	416mm	480mm	10-24 HB	N/A
910-000-089	CFT B50MM-750	50mm	2.000	750mm	492mm	600mm	1/4-20 HB	N/A

14:1 Ratio

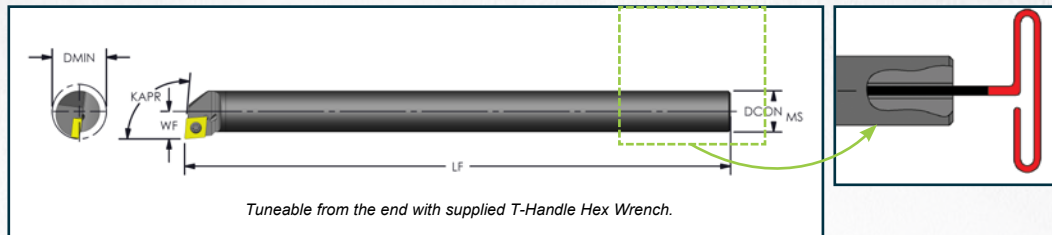
910-000-082	CFT B32MM-544	32mm	1.250	544mm	352mm	448mm	10-24 HB	N/A
910-000-086	CFT B40MM-680	40mm	1.500	680mm	416mm	560mm	10-24 HB	N/A
910-000-090	CFT B50MM-850	50mm	2.000	850mm	492mm	788mm	1/4-20 HB	N/A

PRODUCT #	Head Bolts
968-000-006	8-32 HB
968-000-002	10-24 HB
968-000-001	1/4-20 HB
968-000-004	5/16-18 HB

PACKAGE SIZE OF 1



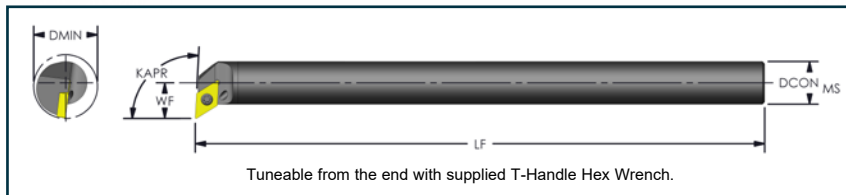
IMPERIAL SOLID BORING BARS



8:1 Ratio
Coolant Thru

SOLID Positive 80° Diamond (KAPR: 95°)

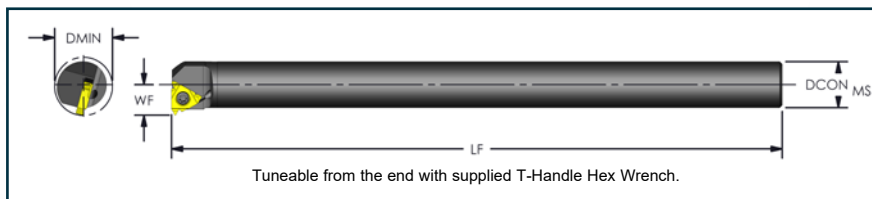
PRODUCT #	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key	Price
910-000-045	D08R SCLCR2	0.500	8.000	0.281	0.580	95.0	CCMT 21.51	MTS-255	T-7	\$653.00
910-000-047	D10X SCLCR3	0.625	9.000	0.406	0.770	95.0	CCMT 32.51	MTS-35	T-15	\$708.00
910-000-050	D12S SCLCR3	0.750	10.000	0.500	0.930	95.0	CCMT 32.51	MTS-35	T-15	\$763.00



8:1 Ratio
Coolant Thru

SOLID Positive 55° Diamond (KAPR: 93°)

PRODUCT #	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key	Price
910-000-046	D08R SDUCR2	0.500	8.000	0.437	0.730	93.0	DCMT 21.51	MTS-255	T-7	\$653.00
910-000-048	D10X SDUCR2	0.625	9.000	0.500	0.850	93.0	DCMT 21.51	MTS-255	T-7	\$708.00
910-000-051	D12S SDUCR3	0.750	10.000	0.625	1.050	93.0	DCMT 32.51	MTS-35	T-15	\$763.00



8:1 Ratio
Coolant Thru

SOLID Threading/Grooving Laydown

PRODUCT #	Designation	DCON MS	LF	WF	DMIN	Insert	Insert Screw	Price
910-000-049	D12S LSER3	0.750	10.000	0.510	0.935	3IR	MTS-35	\$763.00

PRODUCT #	Insert Screws	Price Each
968-000-086	MTS-183	\$3.20
968-000-087	MTS-184	\$3.20
968-000-088	MTS-2	\$2.90
968-000-091	MTS-224	\$3.20
968-000-092	MTS-255	\$3.20
968-000-094	MTS-35	\$3.20
968-000-090	MTS-2.5L	\$2.90
968-000-052	ETS 4-40	\$3.20

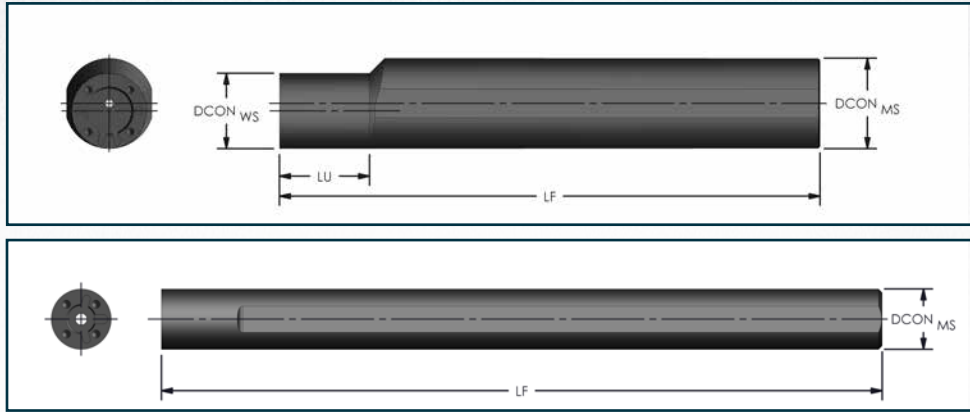
PRODUCT #	Key	Price Each
968-000-156	T-6	\$4.20
968-000-158	T-7	\$3.80
968-000-149	T-10	\$6.50
968-000-151	T-15	\$3.80
968-000-153	T-20	\$4.00

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IMPERIAL MODULAR BARS



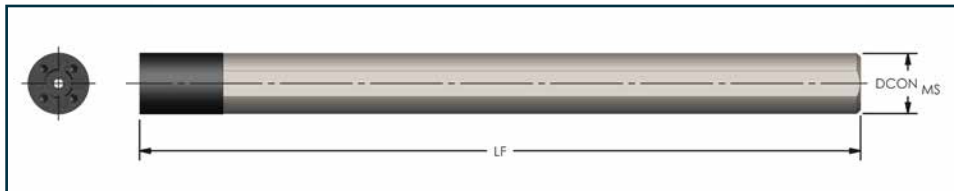
4:1 Ratio

STEEL SHANK

Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LU	LF	Head Bolts
911-000-001	A1000-12	1.000	N/A	N/A	12.000	8-32
911-000-002	A1250-14	1.250	N/A	N/A	14.000	10-24
911-000-003	A1500-14	1.500	N/A	N/A	14.000	10-24
911-000-004	A1750-16	1.750	N/A	N/A	16.000	1/4-20
911-000-026	A2000-10	2.000	N/A	N/A	10.000	1/4-20
911-000-005	A2000-20	2.000	N/A	N/A	20.000	1/4-20
911-000-006	A2500-12	2.500	N/A	N/A	12.000	5/16-18
911-000-007	A2500-24	2.500	N/A	N/A	24.000	5/16-18
911-000-008	A3000-18 *	3.000	2.000	3.000	18.000	5/16-18

* 3" bar takes 2.5" head



8:1 Ratio

CARBIDE SHANK

Coolant Thru

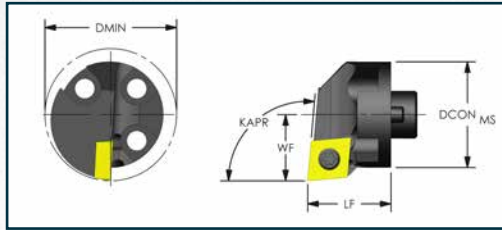
PRODUCT #	Designation	DCONMS	LF	Head Bolts
911-000-016	E1000-12	1.000	12.000	8-32
911-000-017	E1250-14	1.250	14.000	10-24
911-000-018	E1500-14	1.500	14.000	10-24
911-000-019	E1750-16	1.750	16.000	1/4-20
911-000-020	E2000-20	2.000	20.000	1/4-20

PRODUCT #	Head Bolts
968-000-006	8-32 HB
968-000-002	10-24 HB
968-000-001	1/4-20 HB
968-000-004	5/16-18 HB

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IMPERIAL MODULAR HEADS

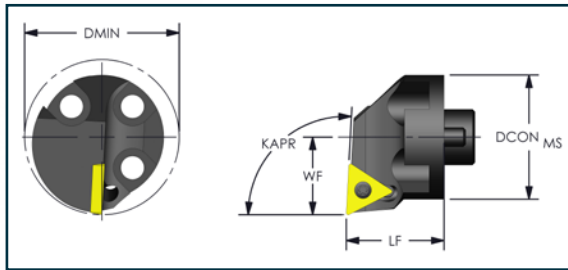


Positive 80° Diamond (KAPR: 93°)

Coolant Thru



PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-014	912-000-015	MH16 SCLCR/L3-CFT	1.000	0.790	0.625	1.200	93.0	CCMT 32.51	MTS-35	T-15
912-000-041	912-000-042	MH20 SCLCR/L3-CFT	1.250	1.250	0.765	1.470	93.0	CCMT 32.51	MTS-35	T-15
912-000-074	912-000-075	MH24 SCLCR/L3-CFT	1.500	1.250	0.890	1.760	93.0	CCMT 32.51	MTS-35	T-15
912-000-110	912-000-111	MH28 SCLCR/L3-CFT	1.750	1.250	1.015	2.030	93.0	CCMT 32.51	MTS-35	T-15
N/A	912-000-076	MH24 SCLCR4-CFT	1.500	1.250	0.890	1.760	93.0	CCMT 432	MTS-4	T-20
N/A	912-000-112	MH28 SCLCR4-CFT	1.750	1.250	1.015	2.030	93.0	CCMT 432	MTS-4	T-20
912-000-156	912-000-157	MH32 SCLCR/L4-CFT	2.000	1.625	1.281	2.400	93.0	CCMT 432	MTS-4	T-20
912-000-195	912-000-196	MH40 SCLCR/L4-CFT	2.500	1.625	1.500	2.800	93.0	CCMT 432	MTS-4	T-20



Positive Triangle (KAPR: 93°)

Coolant Thru



PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-020	912-000-021	MH16 STUCR/L2-CFT	1.000	0.790	0.625	1.200	93.0	TCMT 21.51	MTS-255	T-7
912-000-047	912-000-048	MH20 STUCR/L3-CFT	1.250	1.250	0.765	1.470	93.0	TCMT 32.51	MTS-35	T-15
912-000-081	912-000-082	MH24 STUCR/L3-CFT	1.500	1.250	0.890	1.760	93.0	TCMT 32.51	MTS-35	T-15
912-000-117	912-000-118	MH28 STUCR/L3-CFT	1.750	1.250	1.015	2.030	93.0	TCMT 32.51	MTS-35	T-15
912-000-162	912-000-163	MH32 STUCR/L3-CFT	2.000	1.625	1.281	2.400	93.0	TCMT 32.51	MTS-35	T-15
912-000-201	912-000-202	MH40 STUCR/L3-CFT	2.500	1.625	1.500	2.800	93.0	TCMT 32.51	MTS-35	T-15

PRODUCT #	Insert Screws
968-000-086	MTS-183
968-000-087	MTS-184
968-000-088	MTS-2
968-000-091	MTS-224
968-000-092	MTS-255
968-000-094	MTS-35
968-000-090	MTS-2.5L
968-000-052	ETS 4-40

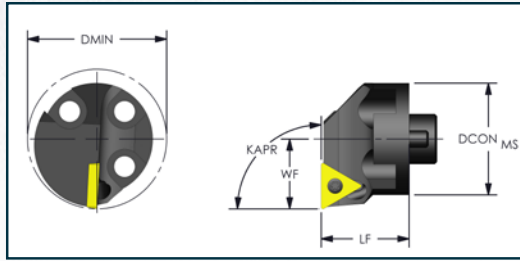
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PRODUCT #	Key
968-000-156	T-6
968-000-158	T-7
968-000-149	T-10
968-000-151	T-15
968-000-153	T-20

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IMPERIAL MODULAR HEADS

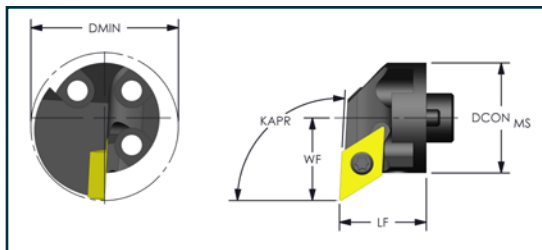


Positive Triangle (KAPR: 90°)

Coolant Thru



PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-018	912-000-019	MH16 STFCR/L2-CFT	1.000	0.790	0.625	1.200	90.0	TCMT 21.51	MTS-255	T-7
912-000-045	912-000-046	MH20 STFCR/L3-CFT	1.250	1.250	0.765	1.470	90.0	TCMT 32.51	MTS-35	T-15
912-000-079	912-000-080	MH24 STFCR/L3-CFT	1.500	1.250	0.890	1.760	90.0	TCMT 32.51	MTS-35	T-15
912-000-115	912-000-116	MH28 STFCR/L3-CFT	1.750	1.250	1.015	2.030	90.0	TCMT 32.51	MTS-35	T-15
912-000-160	912-000-161	MH32 STFCR/L3-CFT	2.000	1.625	1.281	2.400	90.0	TCMT 32.51	MTS-35	T-15
912-000-199	912-000-200	MH40 STFCR/L3-CFT	2.500	1.625	1.500	2.800	90.0	TCMT 32.51	MTS-35	T-15



Positive 55° Diamond (KAPR: 93°) Profiling

Coolant Thru



PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-016	912-000-017	MH16 SDUCR/L3-CFT	1.000	0.790	0.750	1.300	93.0	DCMT 32.51	MTS-35	T-15
912-000-043	912-000-044	MH20 SDUCR/L3-CFT	1.250	1.250	1.000	1.675	93.0	DCMT 32.51	MTS-35	T-15
912-000-077	912-000-078	MH24 SDUCR/L3-CFT	1.500	1.250	1.120	1.920	93.0	DCMT 32.51	MTS-35	T-15
912-000-113	912-000-114	MH28 SDUCR/L3-CFT	1.750	1.250	1.250	2.175	93.0	DCMT 32.51	MTS-35	T-15
912-000-158	912-000-159	MH32 SDUCR/L3-CFT	2.000	1.625	1.375	2.425	93.0	DCMT 32.51	MTS-35	T-15
912-000-197	912-000-198	MH40 SDUCR/L3-CFT	2.500	1.625	1.500	2.800	93.0	DCMT 32.51	MTS-35	T-15

PRODUCT #	Insert Screws
968-000-086	MTS-183
968-000-087	MTS-184
968-000-088	MTS-2
968-000-091	MTS-224
968-000-092	MTS-255
968-000-094	MTS-35
968-000-090	MTS-2.5L
968-000-052	ETS 4-40

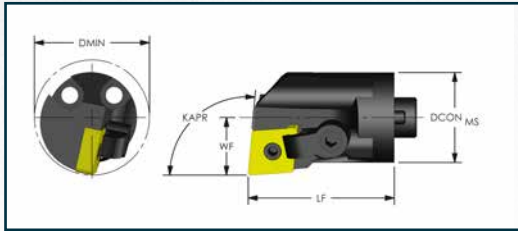
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PRODUCT #	Key
968-000-156	T-6
968-000-158	T-7
968-000-149	T-10
968-000-151	T-15
968-000-153	T-20

PACKAGE SIZE OF 5



IMPERIAL MODULAR HEADS

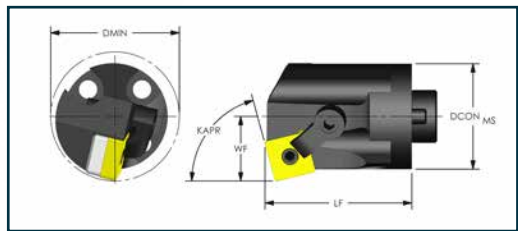


Negative 80° Diamond (KAPR: 95°)



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Shim	Clamp	Clamp Screw	Lock Pin
912-000-003	912-000-004	MH16 MCLNR/L4-CFT	1.000	1.625	0.640	1.200	95.0	CNMG 432	N/A	CL-20	XNS-47	NL-44
912-000-024	912-000-025	MH20 MCLNR/L4-CFT	1.250	1.625	0.765	1.470	95.0	CNMG 432	ICSN-433	CL-20	XNS-47	NL-46
912-000-053	912-000-055	MH24 MCLNR/L4-CFT	1.500	1.625	0.890	1.760	95.0	CNMG 432	ICSN-433	CL-20	XNS-47	NL-46
912-000-087	912-000-088	MH28 MCLNR/L4-CFT	1.750	1.625	1.015	2.010	95.0	CNMG 432	ICSN-433	CL-20	XNS-47	NL-46
912-000-125	912-000-128	MH32 MCLNR/L4-CFT	2.000	1.625	1.281	2.400	95.0	CNMG 432	ICSN-433	CL-20	XNS-47	NL-46
912-000-166	912-000-169	MH40 MCLNR/L4-CFT	2.500	1.625	1.531	2.980	95.0	CNMG 432	ICSN-433	CL-20	XNS-47	NL-46
912-000-054	912-000-056	MH24 MCLNR/L5-CFT	1.250	1.625	0.890	1.760	95.0	CNMG 543	N/A	CL-20	XNS-47	NL-56
912-000-126	912-000-129	MH32 MCLNR/L5-CFT	2.000	1.625	1.281	2.400	95.0	CNMG 543	ICSN-533	CL-12	XNS-510	NL-58
912-000-167	912-000-170	MH40 MCLNR/L5-CFT	2.500	1.625	1.531	2.980	95.0	CNMG 543	ICSN-533	CL-12	XNS-510	NL-58
912-000-127	912-000-130	MH32 MCLNR/L6-CFT	2.000	1.625	1.281	2.400	95.0	CNMG 643	ICSN-633	CL-12	XNS-59	NL-68
912-000-168	912-000-171	MH40 MCLNR/L6-CFT	2.500	1.625	1.531	3.030	95.0	CNMG 643	ICSN-633	CL-12	XNS-59	NL-68



Negative Square (KAPR: 75°)



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Shim	Clamp	Clamp Screw	Lock Pin
912-000-030	912-000-031	MH20 MSKNR/L4-CFT	1.250	1.744	0.765	1.470	75.0	SNMG 432	ISSN-433	CL-20	XNS-47	NL-46
912-000-061	912-000-062	MH24 MSKNR/L4-CFT	1.500	1.744	0.890	1.760	75.0	SNMG 432	ISSN-433	CL-20	XNS-47	NL-46
912-000-093	912-000-094	MH28 MSKNR/L4-CFT	1.750	1.744	1.015	2.010	75.0	SNMG 432	ISSN-433	CL-20	XNS-47	NL-46
912-000-135	912-000-138	MH32 MSKNR/L4-CFT	2.000	1.744	1.281	2.400	75.0	SNMG 432	ISSN-433	CL-20	XNS-47	NL-46
912-000-176	912-000-179	MH40 MSKNR/L4-CFT	2.500	1.804	1.531	3.030	75.0	SNMG 432	ISSN-433	CL-20	XNS-47	NL-46
912-000-136	912-000-139	MH32 MSKNR/L5-CFT	2.000	1.744	1.281	2.400	75.0	SNMG 543	ISSN-533	CL-12	XNS-510	NL-58
912-000-177	912-000-180	MH40 MSKNR/L5-CFT	2.500	1.804	1.531	3.030	75.0	SNMG 543	ISSN-533	CL-12	XNS-510	NL-58
912-000-137	912-000-138	MH32 MSKNR/L6-CFT	2.000	1.744	1.281	2.400	75.0	SNMG 643	ISSN-633	CL-12	XNS-510	NL-68
912-000-178	912-000-181	MH40 MSKNR/L6-CFT	2.500	1.804	1.531	3.030	75.0	SNMG 643	ISSN-633	CL-12	XNS-510	NL-68

PRODUCT #	Clamp
968-000-016	CL-6
968-000-017	CL-7
968-000-020	CL-9
968-000-010	CL-12
968-000-011	CL-19
968-000-012	CL-20

PACKAGE SIZE OF 1

PRODUCT #	Clamp
968-000-013	CL-21
968-000-014	CL-22
968-000-015	CL-30
968-000-018	CL-84
968-000-019	CL-85

PACKAGE SIZE OF 1

PRODUCT #	Clamp Screw
968-000-176	XNS-36
968-000-177	XNS-47
968-000-178	XNS-48
968-000-179	XNS-510
968-000-180	XNS-58
968-000-181	XNS-59

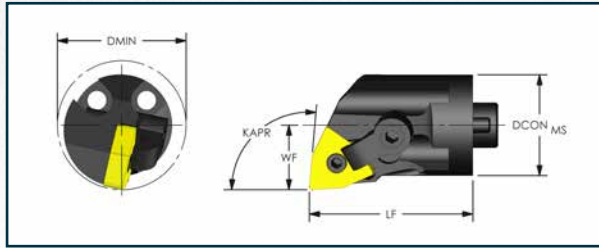
PACKAGE SIZE OF 5

PRODUCT #	Lock Pin
968-000-097	NL-33
968-000-098	NL-33L
968-000-099	NL-34
968-000-100	NL-34L
968-000-101	NL-44
968-000-102	NL-46
968-000-103	NL-56
968-000-104	NL-58
968-000-105	NL-68
968-000-106	NL-68L

PACKAGE SIZE OF 5



IMPERIAL MODULAR HEADS

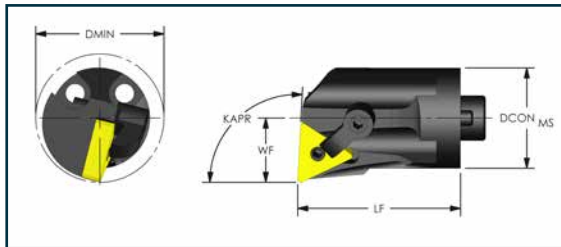


Negative Trigon (KAPR: 95°)



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Shim	Clamp	Clamp Screw	Lock Pin
912-000-012	912-000-013	MH16 MWLNR/L4-CFT	1.000	1.625	0.640	1.200	95.0	WNMG 432	N/A	CL-20	XNS-47	NL-44
912-000-037	912-000-038	MH20 MWLNR/L4-CFT	1.250	1.625	0.765	1.470	95.0	WNMG 432	IWSN-433	CL-20	XNS-47	NL-46
912-000-070	912-000-071	MH24 MWLNR/L4-CFT	1.500	1.625	0.890	1.760	95.0	WNMG 432	IWSN-433	CL-20	XNS-47	NL-46
912-000-102	912-000-103	MH28 MWLNR/L4-CFT	1.750	1.625	1.015	2.010	95.0	WNMG 432	IWSN-433	CL-20	XNS-47	NL-46
912-000-148	912-000-149	MH32 MWLNR/L4-CFT	2.000	1.625	1.281	2.400	95.0	WNMG 432	IWSN-433	CL-20	XNS-47	NL-46
912-000-189	912-000-190	MH40 MWLNR/L4-CFT	2.500	1.625	1.500	2.980	95.0	WNMG 432	IWSN-433	CL-20	XNS-47	NL-46



Negative Triangle (KAPR: 93°)



Coolant Thru

PRODUCT #	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Shim	Clamp	Clamp Screw	Lock Pin
912-000-007	MH16 MTUNR3-CFT	1.000	1.625	0.640	1.200	93.0	TNMG 332	N/A	CL-7	XNS-36	NL-33L
912-000-032	MH20 MTUNR3-CFT	1.250	1.625	0.765	1.470	93.0	TNMG 332	ITSN-323	CL-7	XNS-36	NL-34L
912-000-065	MH24 MTUNR4-CFT	1.500	1.625	0.890	1.760	93.0	TNMG 432	ITSN-433	CL-20	XNS-47	NL-46
912-000-097	MH28 MTUNR4-CFT	1.750	1.625	1.015	2.010	93.0	TNMG 432	ITSN-433	CL-20	XNS-47	NL-46
912-000-143	MH32 MTUNR4-CFT	2.000	1.625	1.281	2.400	93.0	TNMG 432	ITSN-433	CL-20	XNS-47	NL-46
912-000-182	MH40 MTUNR4-CFT	2.500	1.625	1.531	2.900	93.0	TNMG 432	ITSN-433	CL-20	XNS-47	NL-46

PRODUCT #	Clamp
968-000-016	CL-6
968-000-017	CL-7
968-000-020	CL-9
968-000-010	CL-12
968-000-011	CL-19
968-000-012	CL-20

PACKAGE SIZE OF 1

PRODUCT #	Clamp
968-000-013	CL-21
968-000-014	CL-22
968-000-015	CL-30
968-000-018	CL-84
968-000-019	CL-85

PACKAGE SIZE OF 1

PRODUCT #	Clamp Screw
968-000-176	XNS-36
968-000-177	XNS-47
968-000-178	XNS-48
968-000-179	XNS-510
968-000-180	XNS-58
968-000-181	XNS-59

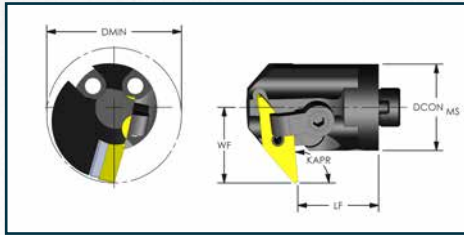
PACKAGE SIZE OF 5

PRODUCT #	Lock Pin
968-000-097	NL-33
968-000-098	NL-33L
968-000-099	NL-34
968-000-100	NL-34L
968-000-101	NL-44
968-000-102	NL-46
968-000-103	NL-56
968-000-104	NL-58
968-000-105	NL-68
968-000-106	NL-68L

PACKAGE SIZE OF 5



IMPERIAL MODULAR HEADS

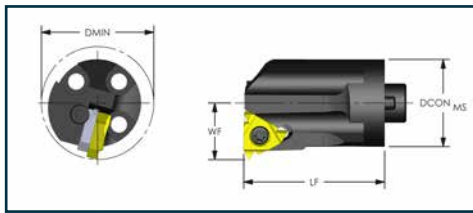


**Negative 35° Diamond (KAPR: 95°)
Back Facing**



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	KAPR	Insert	Shim	Clamp	Clamp Screw	Lock Pin
912-000-010	912-000-011	MH16 MVXNR/L3-CFT	1.000	0.940	0.875	1.435	95.0	VNMG 332	IVSN-322	CL-20	XNS-47	NL-34L
912-000-035	912-000-036	MH20 MVXNR/L3-CFT	1.250	1.000	1.000	1.705	95.0	VNMG 332	IVSN-322	CL-20	XNS-47	NL-34L
912-000-068	912-000-069	MH24 MVXNR/L3-CFT	1.500	1.120	1.125	2.000	95.0	VNMG 332	IVSN-322	CL-20	XNS-47	NL-34L
912-000-100	912-000-101	MH28 MVXNR/L3-CFT	1.750	1.120	1.250	2.250	95.0	VNMG 332	IVSN-322	CL-20	XNS-47	NL-34L
912-000-146	912-000-147	MH32 MVXNR/L3-CFT	2.000	1.120	1.375	2.500	95.0	VNMG 332	IVSN-322	CL-20	XNS-47	NL-34L
912-000-187	912-000-188	MH40 MVXNR/L3-CFT	2.500	1.120	1.750	3.250	95.0	VNMG 332	IVSN-322	CL-20	XNS-47	NL-34L



Threading / Grooving Laydown



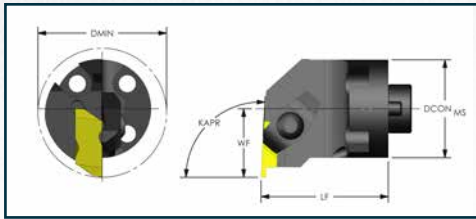
Coolant Thru

PRODUCT #	Designation Right hand	DCON MS	LF	WF	DMIN	Insert	Insert Screw	Anvil Screw	Anvil
912-000-002	MH16 LSER3-CFT	1.000	1.625	0.650	1.200	3IR	SA3T	SY3T	YI3
912-000-023	MH20 LSER3-CFT	1.250	1.625	0.770	1.450	3IR	SA3T	SY3T	YI3
912-000-051	MH24 LSER3-CFT	1.500	1.625	0.900	1.650	3IR	SA3T	SY3T	YI3
912-000-085	MH28 LSER3-CFT	1.750	1.625	1.090	2.020	3IR	SA3T	SY3T	YI3
912-000-122	MH32 LSER3-CFT	2.000	1.625	1.281	2.400	3IR	SA3T	SY3T	YI3
912-000-052	MH24 LSER4-CFT	1.500	1.625	0.978	1.782	4IR	SA4T	SY4T	YI4
912-000-084	MH28 LSER4-CFT	1.750	1.625	1.090	2.020	4IR	SA4T	SY4T	YI4
912-000-123	MH32 LSER4-CFT	2.000	1.625	1.281	2.400	4IR	SA4T	SY4T	YI4
912-000-124	MH32 LSER5-CFT	2.000	1.625	1.281	2.400	5IR	SA5T	SY5T	YI5
912-000-165	MH40 LSER5-CFT	2.500	1.625	1.530	2.800	5IR	SA5T	SY5T	YI5

PRODUCT #	Designation Left hand	DCON MS	LF	WF	DMIN	Insert	Insert Screw	Anvil Screw	Anvil
912-000-001	MH16 LSEL3-CFT	1.000	1.625	0.650	1.200	3IL	SA3T	SY3T	YE3
912-000-022	MH20 LSEL3-CFT	1.250	1.625	0.770	1.450	3IL	SA3T	SY3T	YE3
912-000-049	MH24 LSEL3-CFT	1.500	1.625	0.900	1.650	3IL	SA3T	SY3T	YE3
912-000-083	MH28 LSEL3-CFT	1.750	1.625	1.090	2.020	3IL	SA3T	SY3T	YE3
912-000-119	MH32 LSEL3-CFT	2.000	1.625	1.281	2.400	3IL	SA3T	SY3T	YE3
912-000-051	MH24 LSEL4-CFT	1.500	1.625	0.978	1.782	4IL	SA4T	SY4T	YE4
912-000-086	MH28 LSEL4-CFT	1.750	1.625	1.090	2.020	4IL	SA4T	SY4T	YE4
912-000-120	MH32 LSEL4-CFT	2.000	1.625	1.281	2.400	4IL	SA4T	SY4T	YE4
912-000-121	MH32 LSEL5-CFT	2.000	1.625	1.281	2.400	5IL	SA5T	SY5T	YE5
912-000-164	MH40 LSEL5-CFT	2.500	1.625	1.530	2.800	5IL	SA5T	SY5T	YE5



IMPERIAL MODULAR HEADS



Threading / Grooving Top Notch



Coolant Thru

PRODUCT #	Designation Right Hand	DCON MS	LF	WF	DMIN	Insert	Clamp	Screw
912-000-040	MH20 NER3-CFT	1.250	1.625	0.875	1.750	NG 3L	CM-73	10-32
912-000-073	MH24 NER3-CFT	1.500	1.625	1.000	2.000	NG 3L	CM-73	10-32
912-000-107	MH28 NER3-CFT	1.750	1.625	1.125	2.250	NG 3L	CM-73	10-32
912-000-153	MH32 NER3-CFT	2.000	1.625	1.250	2.410	NG 3L	CM-73	10-32
912-000-108	MH28 NER4-CFT	1.750	1.625	1.250	2.500	NG 4L	CM-73	10-32
912-000-154	MH32 NER4-CFT	2.000	1.625	1.375	2.750	NG 4L	CM-73	10-32
912-000-193	MH40 NER4-CFT	2.500	1.625	1.625	3.250	NG 4L	CM-73	10-32
912-000-109	MH28 NER6-CFT	1.750	1.625	1.250	2.500	NG 6L	CM-121	10-32
912-000-155	MH32 NER6-CFT	2.000	1.625	1.375	2.750	NG 6L	CM-121	10-32
912-000-194	MH40 NER6-CFT	2.500	1.625	1.625	3.250	NG 6L	CM-121	10-32

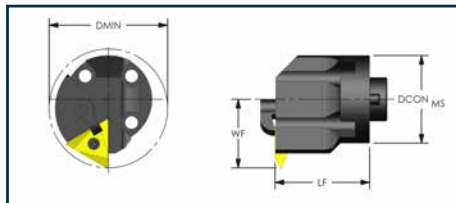
PRODUCT #	Clamp
968-000-025	CM-72
968-000-026	CM-73
968-000-027	CM-74
968-000-028	CM-75
968-000-021	CM-120
968-000-022	CM-121
968-000-023	CM-146
968-000-024	CM-147

PACKAGE SIZE OF 1

PRODUCT #	Clamp Screw
968-000-005	6-32
968-000-003	10-32
968-000-096	MTS-526

PACKAGE SIZE OF 5

PRODUCT #	Designation Left hand	DCON MS	LF	WF	DMIN	Insert	Clamp	Screw
912-000-039	MH20 NEL3-CFT	1.250	1.625	.875	1.750	NG 3R	CM-72	10-32
912-000-072	MH24 NEL3-CFT	1.500	1.625	1.000	2.000	NG 3R	CM-72	10-32
912-000-104	MH28 NEL3-CFT	1.750	1.625	1.125	2.250	NG 3R	CM-72	10-32
912-000-150	MH32 NEL3-CFT	2.000	1.625	1.250	2.410	NG 3R	CM-72	10-32
912-000-105	MH28 NEL4-CFT	1.750	1.625	1.250	2.500	NG 4R	CM-72	10-32
912-000-151	MH32 NEL4-CFT	2.000	1.625	1.375	2.750	NG 4R	CM-72	10-32
912-000-191	MH40 NEL4-CFT	2.500	1.625	1.625	3.250	NG 4R	CM-72	10-32
912-000-106	MH28 NEL6-CFT	1.750	1.625	1.250	2.500	NG 6R	CM-120	10-32
912-000-152	MH32 NEL6-CFT	2.000	1.625	1.375	2.750	NG 6R	CM-120	10-32
912-000-192	MH40 NEL6-CFT	2.500	1.625	1.625	3.250	NG 6R	CM-120	10-32



Threading / Grooving On Edge



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	LF	WF	DMIN	Insert	Clamp	Screw	Lock Pin
912-000-063	912-000-064	MH24 MTHOR/L4-CFT	1.500	1.625	1.173	2.625	TNMA 43	CL-7	XNS-36	NL-44
912-000-095	912-000-096	MH28 MTHOR/L4-CFT	1.750	1.625	1.298	2.750	TNMA 43	CL-7	XNS-36	NL-44
912-000-141	912-000-142	MH32 MTHOR/L4-CFT	2.000	1.625	1.423	2.875	TNMA 43	CL-7	XNS-36	NL-44

PRODUCT #	Clamp Screw
968-000-176	XNS-36
968-000-177	XNS-47
968-000-178	XNS-48
968-000-179	XNS-510
968-000-180	XNS-58
968-000-181	XNS-59

PACKAGE SIZE OF 5

PRODUCT #	Lock Pin
968-000-097	NL-33
968-000-098	NL-33L
968-000-099	NL-34
968-000-100	NL-34L
968-000-101	NL-44
968-000-102	NL-46
968-000-103	NL-56
968-000-104	NL-58
968-000-105	NL-68
968-000-106	NL-68L

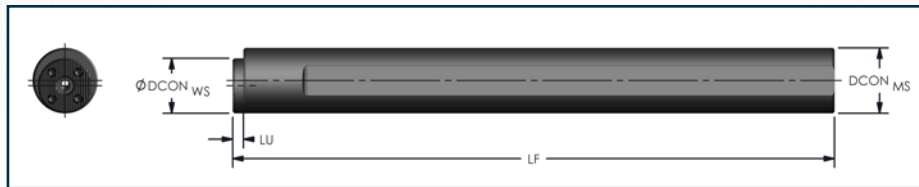
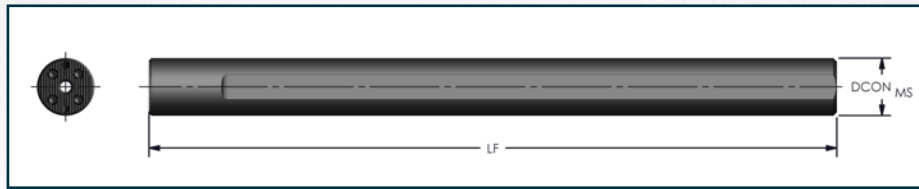
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PRODUCT #	Clamp
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968-000-017	CL-7
968-000-020	CL-9
968-000-010	CL-12
968-000-011	CL-19
968-000-012	CL-20

PACKAGE SIZE OF 1



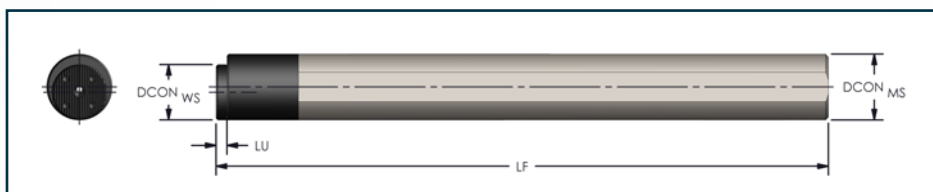
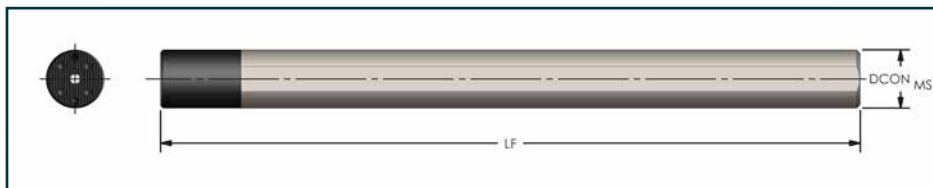
SERRATED MODULAR BARS



STEEL SHANK

4:1 Ratio
Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LU	LF	Head Bolts
911-000-009	AS1000-12	1.000	25mm	N/A	12.000	8-32
911-000-010	AS1250-14	1.250	32mm	N/A	14.000	10-24
911-000-011	AS1500-14	1.500	32mm	0.250	14.000	10-24
911-000-012	AS1750-16	1.750	40mm	0.250	16.000	1/4-20
911-000-013	AS2000-20	2.000	40mm	0.250	20.000	1/4-20
911-000-014	AS2500-12	2.500	40mm	0.250	12.000	1/4-20
911-000-015	AS2500-24	2.500	40mm	0.250	24.000	1/4-20



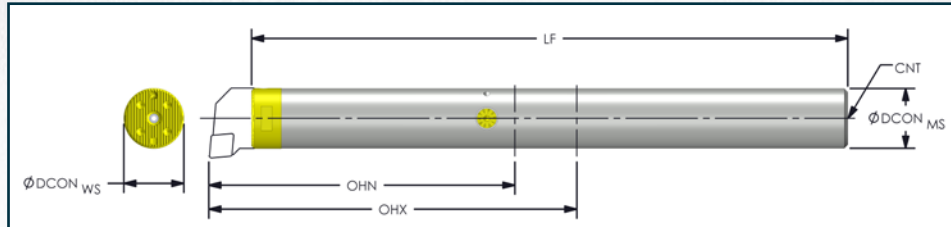
CARBIDE SHANK

8:1 Ratio
Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LU	LF	Head Bolts
911-000-021	ES1000-12	1.000	25mm	N/A	12.000	8-32
911-000-022	ES1250-14	1.250	32mm	N/A	14.000	10-24
911-000-023	ES1500-14	1.500	32mm	0.250	14.000	10-24
911-000-024	ES1750-16	1.750	40mm	0.250	16.000	1/4-20
911-000-025	ES2000-20	2.000	40mm	0.250	20.000	1/4-20



STEALTH™ SERRATED MODULAR BARS



5:1 Ratio

MODULAR BARS

Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LF	OHN	OHX	Head Bolts	CNT
910-000-064	SCFT B1500-9	1.500	32mm	9.000	7.000	7.500	10-24 HB	1/8-27 NPT
910-000-069	SCFT B2000-12	2.000	40mm	12.000	7.500	10.000	1/4-20 HB	1/8-27 NPT
910-000-074	SCFT B2500-16	2.500	40mm	16.000	8.000	12.500	1/4-20 HB	1/8-27 NPT

7:1 Ratio

910-000-052	SCFT B1000-10	1.000	25mm	10.000	5.000	7.000	8-32 HB	1/8-27 NPT
910-000-056	SCFT B1250-12	1.250	32mm	12.000	6.250	8.750	10-24 HB	1/8-27 NPT
910-000-060	SCFT B1500-15	1.500	32mm	15.000	7.500	10.500	10-24 HB	1/8-27 NPT
910-000-065	SCFT B1750-18	1.750	40mm	18.000	8.7500	12.250	1/4-20 HB	1/8-27 NPT
910-000-070	SCFT B2000-20	2.000	40mm	20.000	10.000	14.000	1/4-20 HB	1/8-27 NPT
910-000-075	SCFT B2500-27	2.500	40mm	27.000	12.500	17.500	1/4-20 HB	1/4-18 NPT

10:1 Ratio

910-000-053	SCFT B1000-14	1.000	25mm	14.000	7.000	10.000	8-32 HB	1/8-27 NPT
910-000-057	SCFT B1250-16	1.250	32mm	16.000	8.750	12.500	10-24 HB	1/8-27 NPT
910-000-061	SCFT B1500-19	1.500	32mm	19.000	10.500	15.000	10-24 HB	1/8-27 NPT
910-000-066	SCFT B1750-23	1.750	40mm	23.000	12.250	17.500	1/4-20 HB	1/8-27 NPT
910-000-071	SCFT B2000-26	2.000	40mm	26.000	14.000	20.000	1/4-20 HB	1/8-27 NPT
910-000-076	SCFT B2500-33	2.500	40mm	33.000	17.500	25.000	1/4-20 HB	1/4-18 NPT

12:1 Ratio

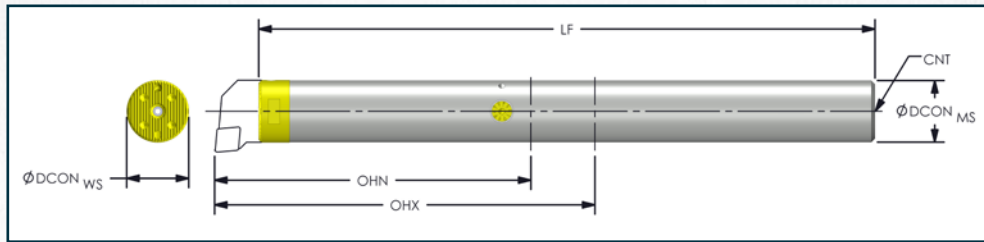
910-000-054	SCFT B1000-16	1.000	25mm	16.000	10.875	12.000	8-32 HB	N/A
910-000-058	SCFT B1250-18	1.250	32mm	18.000	13.785	15.000	10-24 HB	N/A
910-000-062	SCFT B1500-22	1.500	32mm	22.000	16.375	18.000	10-24 HB	N/A
910-000-067	SCFT B1750-25	1.750	40mm	25.000	18.060	21.000	1/4-20 HB	N/A
910-000-072	SCFT B2000-29	2.000	40mm	29.000	19.375	24.000	1/4-20 HB	N/A

14:1 Ratio

910-000-055	SCFT B1000-18	1.000	25mm	18.000	10.875	12.000	8-32 HB	N/A
910-000-059	SCFT B1250-21	1.250	32mm	21.000	13.875	15.000	10-24 HB	N/A
910-000-063	SCFT B1500-25	1.500	32mm	25.000	16.375	18.000	10-24 HB	N/A
910-000-068	SCFT B1750-29	1.750	40mm	29.000	18.060	21.000	1/4-20 HB	N/A
910-000-073	SCFT B2000-33	2.000	40mm	33.000	19.375	24.000	1/4-20 HB	N/A

PRODUCT #	Head Bolts
968-000-006	8-32 HB
968-000-002	10-24 HB
968-000-001	1/4-20 HB
968-000-004	5/16-18 HB

PACKAGE SIZE OF 1


STEALTH™ SERRATED MODULAR BARS

7:1 Ratio

Coolant Thru

PRODUCT #	Designation	DCON MS	DCON WS	LF	OHN	OHX	Head Bolts	CNT
910-000-077	SCFT B25MM-250	25mm	25mm	250mm	127mm	175mm	8-32 HB	1/8-27 NPT
910-000-079	SCFT B32MM-320	32mm	32mm	320mm	159mm	224mm	10-24 HB	1/8-27 NPT
910-000-083	SCFT B40MM-400	40mm	40mm	400mm	190mm	280mm	1/4-20 HB	1/8-27 NPT
910-000-087	SCFT B50MM-500	50mm	40mm	500mm	254mm	350mm	1/4-20 HB	1/8-27 NPT
910-000-091	SCFT B60MM-600	60mm	40mm	600mm	320mm	420mm	1/4-20 HB	1/8-27 NPT

10:1 Ratio

910-000-078	SCFT B25MM-325	25mm	25mm	325mm	178mm	250mm	8-32 HB	1/8-27 NPT
910-000-080	SCFT B32MM-416	32mm	32mm	416mm	223mm	320mm	10-24 HB	1/8-27 NPT
910-000-084	SCFT B40MM-520	40mm	40mm	520mm	266mm	400mm	1/4-20 HB	1/8-27 NPT
910-000-088	SCFT B50MM-650	50mm	40mm	650mm	356mm	500mm	1/4-20 HB	1/8-27 NPT
910-000-092	SCFT B60MM-780	60mm	40mm	780mm	445mm	600mm	1/4-20 HB	1/8-27 NPT

12:1 Ratio

910-000-081	SCFT B32MM-480	32mm	32mm	480mm	352mm	384mm	10-24 HB	N/A
910-000-085	SCFT B40MM-600	40mm	40mm	600mm	416mm	480mm	1/4-20 HB	N/A
910-000-089	SCFT B50MM-750	50mm	40mm	750mm	492mm	600mm	1/4-20 HB	N/A

14:1 Ratio

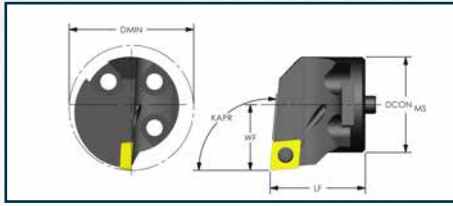
910-000-082	SCFT B32MM-544	32mm	32mm	544mm	352mm	448mm	10-24 HB	N/A
910-000-086	SCFT B40MM-680	40mm	40mm	680mm	416mm	560mm	1/4-20 HB	N/A
910-000-090	SCFT B50MM-850	50mm	40mm	850mm	492mm	788mm	1/4-20 HB	N/A

PRODUCT #	Head Bolts
968-000-006	8-32 HB
968-000-002	10-24 HB
968-000-001	1/4-20 HB
968-000-004	5/16-18 HB

PACKAGE SIZE OF 1



SERRATED MODULAR HEADS

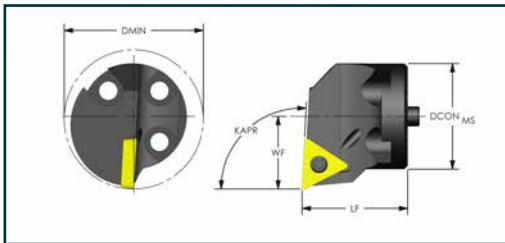


Positive 80° Diamond (KAPR:95°)



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-205	912-000-206	SH16 SCLCR/L3	0.984	25mm	0.787	0.669	1.260	95.0	CCMT 32.52	MTS-35	T-15
912-000-233	912-000-234	SH20 SCLCR/L3	1.260	32mm	1.260	0.866	1.575	95.0	CCMT 32.52	MTS-35	T-15
912-000-263	912-000-264	SH24 SCLCR/L4	1.575	40mm	1.496	1.063	1.968	95.0	CCMT 432	MTS-4	T-20

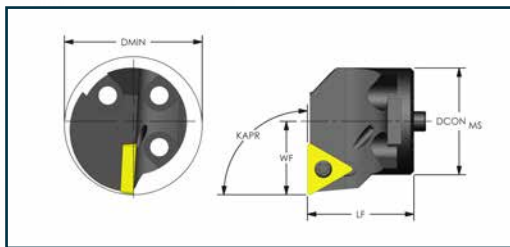


Positive Triangle (KAPR:93°)



Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-215	912-000-216	SH16 STUCR/L2	0.984	25mm	0.787	0.669	1.260	93.0	TCMT 21.51	MTS-255	T-7
912-000-243	912-000-244	SH20 STUCR/L3	1.260	32mm	1.260	0.866	1.575	93.0	TCMT 32.52	MTS-35	T-15
912-000-273	912-000-274	SH24 STUCR/L3	1.575	40mm	1.496	1.063	1.968	93.0	TCMT 32.52	MTS-35	T-15



Positive Triangle (KAPR:90°)



Coolant Thru

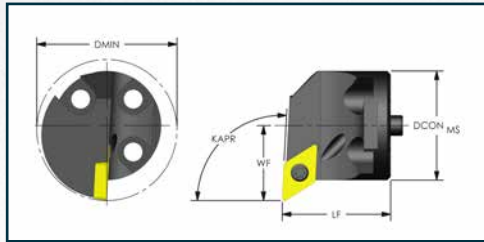
PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-213	912-000-214	SH16 STFCR/L2	0.984	25mm	0.787	0.669	1.260	90.0	TCMT 21.51	MTS-255	T-7
912-000-241	912-000-242	SH20 STFCR/L3	1.260	32mm	1.260	0.866	1.575	90.0	TCMT 32.52	MTS-35	T-15
912-000-271	912-000-272	SH24 STFCR/L3	1.575	40mm	1.496	1.063	1.968	90.0	TCMT 32.52	MTS-35	T-15

PRODUCT #	Insert Screws
968-000-086	MTS-183
968-000-087	MTS-184
968-000-088	MTS-2
968-000-091	MTS-224
968-000-092	MTS-255
968-000-094	MTS-35
968-000-090	MTS-2.5L
968-000-052	ETS 4-40

PACKAGE SIZE OF 5

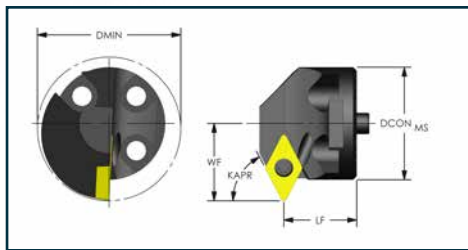
PRODUCT #	Key
968-000-156	T-6
968-000-158	T-7
968-000-149	T-10
968-000-151	T-15
968-000-153	T-20

PACKAGE SIZE OF 5


SERRATED MODULAR HEADS

Positive 55° Diamond (KAPR: 93°) Profiling

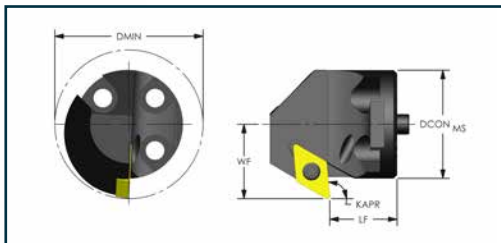
Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-209	912-000-210	SH16 SDUCR/L3	0.984	25mm	0.787	0.669	1.260	93.0	DCMT 32.52	MTS-35	T-15
912-000-237	912-000-238	SH20 SDUCR/L3	1.260	32mm	1.260	0.866	1.575	93.0	DCMT 32.52	MTS-35	T-15
912-000-267	912-000-268	SH24 SDUCR/L3	1.575	40mm	1.260	1.063	1.968	93.0	DCMT 32.52	MTS-35	T-15


Positive 55° Diamond (KAPR: 62.5°) Profiling

Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-207	912-000-208	SH16 SDNCR/L2	0.984	25mm	0.591	0.709	1.299	62.5	DCMT 21.51	MTS-255	T-7
912-000-235	912-000-236	SH20 SDNCR/L3	1.260	32mm	0.787	0.866	1.575	62.5	DCMT 32.52	MTS-35	T-15
912-000-265	912-000-266	SH24 SDNCR/L3	1.575	40mm	0.787	1.063	1.968	62.5	DCMT 32.52	MTS-35	T-15


Positive 55° Diamond (KAPR: 95°) Back Facing

Coolant Thru

PRODUCT # Left hand	PRODUCT # Right hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Insert Screw	Key
912-000-211	912-000-212	SH16 SDXCR/L2	0.984	25mm	0.591	0.709	1.299	95.0	DCMT 21.51	MTS-255	T-7
912-000-239	912-000-240	SH20 SDXCR/L3	1.260	32mm	0.787	0.866	1.575	95.0	DCMT 32.52	MTS-35	T-15
912-000-269	912-000-270	SH24 SDXCR/L3	1.575	40mm	0.787	1.063	1.968	95.0	DCMT 32.52	MTS-35	T-15

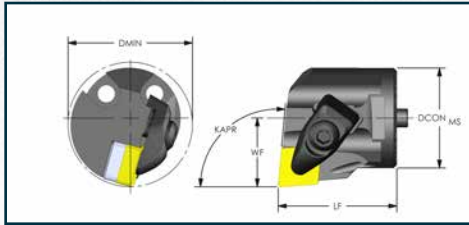
PRODUCT #	Insert Screws
968-000-086	MTS-183
968-000-087	MTS-184
968-000-088	MTS-2
968-000-091	MTS-224
968-000-092	MTS-255
968-000-094	MTS-35
968-000-090	MTS-2.5L
968-000-052	ETS 4-40

PRODUCT #	Key
968-000-156	T-6
968-000-158	T-7
968-000-149	T-10
968-000-151	T-15
968-000-153	T-20

PACKAGE SIZE OF 5
PACKAGE SIZE OF 5



SERRATED MODULAR HEADS

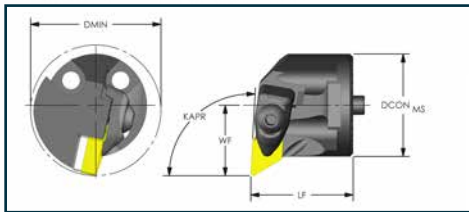


PULLBACK Clamp Negative 80° Diamond (KAPR 95° Lead)



Coolant Thru

PRODUCT # Left Hand	PRODUCT # Right Hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Shim Seat	Shim Screw	Clamp Assy.
912-000-217	912-000-218	SH20 DCLNR/L4	1.260	32mm	1.496	0.866	1.575	95.0	CNMG 432	ICSN-433	PB4-SS	PB4-CA
912-000-245	912-000-246	SH24 DCLNR/L4	1.575	40mm	1.496	1.063	1.968	95.0	CNMG 432	ICSN-433	PB4-SS	PB4-CA

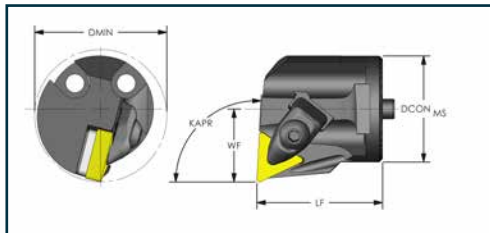


PULLBACK Clamp Negative 55° Diamond (KAPR: 93°)



Coolant Thru

PRODUCT # Left Hand	PRODUCT # Right Hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Shim Seat	Shim Screw	Clamp Assy.
912-000-219	912-000-220	SH20 DDUNR/L3	1.260	32mm	1.260	0.866	1.575	93.0	DNMG 332	IDSN-322	PB3-SS	PB3-CA
912-000-247	912-000-248	SH24 DDUNR/L4	1.575	40mm	1.260	1.063	1.968	93.0	DNMG 432	IDSN-433	PB4-SS	PB4-CA



PULLBACK Clamp Negative Triangle (KAPR: 93°)



Coolant Thru

PRODUCT # Left Hand	PRODUCT # Right Hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	Insert	Shim Seat	Shim Screw	Clamp Assy.
912-000-223	912-000-224	SH20 DTUNR/L3	1.260	32mm	1.496	0.866	1.575	TNMG 332	ITSN-323	PB3-SS	PB3-CA
912-000-251	912-000-252	SH24 DTUNR/L3	1.575	40mm	1.496	1.063	1.968	TNMG 332	ITSN-323	PB3-SS	PB3-CA

PRODUCT #	Shim Seat
968-000-053	ICSN-433
968-000-054	ICSN-533
968-000-055	ICSN-633
968-000-063	ISSN-432
968-000-064	ISSN-433
968-000-065	ISSN-533
968-000-066	ISSN-633
968-000-056	IDSN-322
968-000-057	IDSN-433
968-000-058	IDSN-533
968-000-067	ITSN-323
968-000-068	ITSN-433

PACKAGE SIZE OF 10

PRODUCT #	Shim Seat
968-000-069	ITSN-533
968-000-070	ITSN-636
968-000-071	IVSN-322
968-000-072	IVSN-432
968-000-073	IVSN-433
968-000-074	IWSN-322
968-000-075	IWSN-433
968-000-059	IRSN-32
968-000-060	IRSN-43
968-000-061	IRSN-53
968-000-062	IRSN-63

PACKAGE SIZE OF 10

PRODUCT #	Shim Screw
968-000-109	PB3-SS
968-000-111	PB4-SS

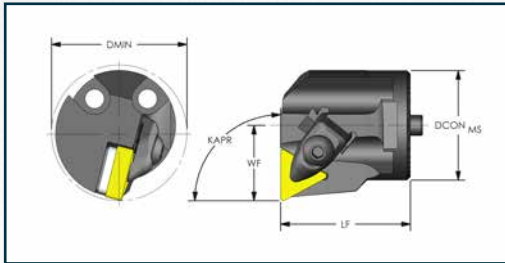
PACKAGE SIZE OF 5

PRODUCT #	Clamp Assy.
968-000-107	PB3-CA
968-000-110	PB4-CA

PACKAGE SIZE OF 1



SERRATED MODULAR HEADS

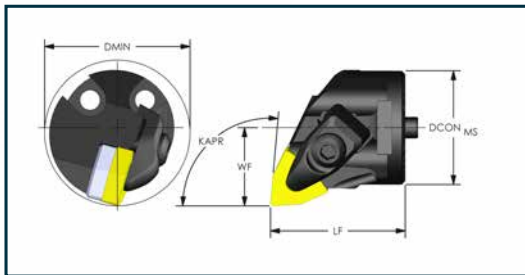


PULLBACK Clamp Negative Triangle (KAPR: 90°)



Coolant Thru

PRODUCT # Left Hand	PRODUCT # Right Hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Shim Seat	Shim Screw	Clamp Assy.
912-000-221	912-000-222	SH20 DTFNR/L3	1.260	32mm	1.496	0.866	1.575	90.0	TNMG 332	ITSN-323	PB3-SS	PB3-CA
912-000-249	912-000-250	SH24 DTFNR/L3	1.575	40mm	1.496	1.063	1.968	90.0	TNMG 332	ITSN-323	PB3-SS	PB3-CA



PULLBACK Clamp Negative Trigon (KAPR: 95°)



Coolant Thru

PRODUCT # Left Hand	PRODUCT # Right Hand	Designation	DCON MS	Coupling Size	LF	WF	DMIN	KAPR	Insert	Shim Seat	Shim Screw	Clamp Assy.
912-000-225	912-000-226	SH20 DWLNR/L4	1.260	32mm	1.496	0.866	1.575	95.0	WNMG 432	IWSN-433	PB4-SS	PB4-CA
912-000-253	912-000-254	SH24 DWLNR/L4	1.575	40mm	1.496	1.063	1.968	95.0	WNMG 432	IWSN-433	PB4-SS	PB4-CA

PRODUCT #	Shim Seat
968-000-053	ICSN-433
968-000-054	ICSN-533
968-000-055	ICSN-633
968-000-063	ISSN-432
968-000-064	ISSN-433
968-000-065	ISSN-533
968-000-066	ISSN-633
968-000-056	IDSN-322
968-000-057	IDSN-433
968-000-058	IDSN-533
968-000-067	ITSN-323
968-000-068	ITSN-433

PACKAGE SIZE OF 10

PRODUCT #	Shim Seat
968-000-069	ITSN-533
968-000-070	ITSN-636
968-000-071	IVSN-322
968-000-072	IVSN-432
968-000-073	IVSN-433
968-000-074	IWSN-322
968-000-075	IWSN-433
968-000-059	IRSN-32
968-000-060	IRSN-43
968-000-061	IRSN-53
968-000-062	IRSN-63

PACKAGE SIZE OF 10

PRODUCT #	Shim Screw
968-000-109	PB3-SS
968-000-111	PB4-SS

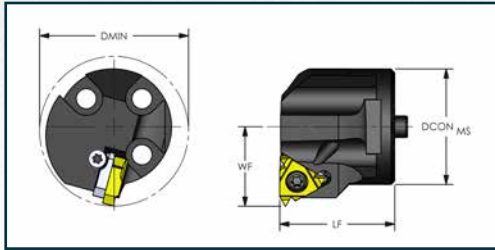
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PRODUCT #	Clamp Assy.
968-000-107	PB3-CA
968-000-110	PB4-CA

PACKAGE SIZE OF 1



SERRATED MODULAR HEADS



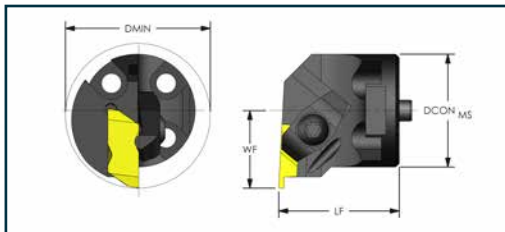
Threading / Grooving Laydown



Coolant Thru

PRODUCT #	Designation Right Hand	DCON MS	Coupling Size	LF	WF	DMIN	Insert	Insert Screw	Anvil Screw	Anvil
912-000-204	SH16 LSER3	.984	25mm	0.984	0.669	1.260	3IR	SA3T	SY3T	YI3
912-000-229	SH20 LSER3	1.260	32mm	1.260	0.866	1.575	3IR	SA3T	SY3T	YI3
912-000-257	SH24 LSER3	1.575	40mm	1.496	1.063	1.968	3IR	SA3T	SY3T	YI3
912-000-230	SH20 LSER4	1.260	32mm	1.260	0.866	1.575	4IR	SA4T	SY4T	YI4
912-000-258	SH24 LSER4	1.575	40mm	1.496	1.063	1.968	4IR	SA4T	SY4T	YI4

PRODUCT #	Designation Left Hand	DCON MS	Coupling Size	LF	WF	DMIN	Insert	Insert Screw	Anvil Screw	Anvil
912-000-203	SH16 LSEL3	.984	25mm	0.984	0.669	1.260	3IL	SA3T	SY3T	YE3
912-000-227	SH20 LSEL3	1.260	32mm	1.260	0.866	1.575	3IL	SA3T	SY3T	YE3
912-000-255	SH24 LSEL3	1.575	40mm	1.496	1.063	1.968	3IL	SA3T	SY3T	YE3
912-000-228	SH20 LSEL4	1.260	32mm	1.260	0.866	1.575	4IL	SA4T	SY4T	YE4
912-000-256	SH24 LSEL4	1.575	40mm	1.496	1.063	1.968	4IL	SA4T	SY4T	YE4



Threading / Grooving Top Notch



Coolant Thru

PRODUCT #	Designation Right Hand	DCON MS	Coupling Size	LF	WF	DMIN	Insert	Clamp	Screw
912-000-232	SH20 NER3	1.260	32mm	1.575	0.866	1.730	NG 3L	CM-73	10-32
912-000-261	SH24 NER3	1.575	40mm	1.575	1.102	2.210	NG 3L	CM-73	10-32
912-000-262	SH24 NER4	1.575	40mm	1.575	1.102	2.210	NG 4L	CM-73	10-32

PRODUCT #	Designation Left Hand	DCON MS	Coupling Size	LF	WF	DMIN	Insert	Clamp	Screw
912-000-231	SH20 NEL3	1.260	32mm	1.575	0.866	1.730	NG 3R	CM-72	10-32
912-000-259	SH24 NEL3	1.575	40mm	1.575	1.102	2.210	NG 3R	CM-72	10-32
912-000-260	SH24 NEL4	1.575	40mm	1.575	1.102	2.210	NG 4R	CM-72	10-32

PRODUCT #	Clamp
968-000-016	CL-6
968-000-017	CL-7
968-000-020	CL-9
968-000-010	CL-12
968-000-011	CL-19
968-000-012	CL-20

PACKAGE SIZE OF 1

PRODUCT #	Clamp
968-000-013	CL-21
968-000-014	CL-22
968-000-015	CL-30
968-000-018	CL-84
968-000-019	CL-85

PACKAGE SIZE OF 1

PRODUCT #	Anvil
968-000-185	YI3
968-000-182	YE3
968-000-187	YI4
968-000-186	YI3M-1.5N
968-000-183	YE4
968-000-188	YI5
968-000-184	YE5

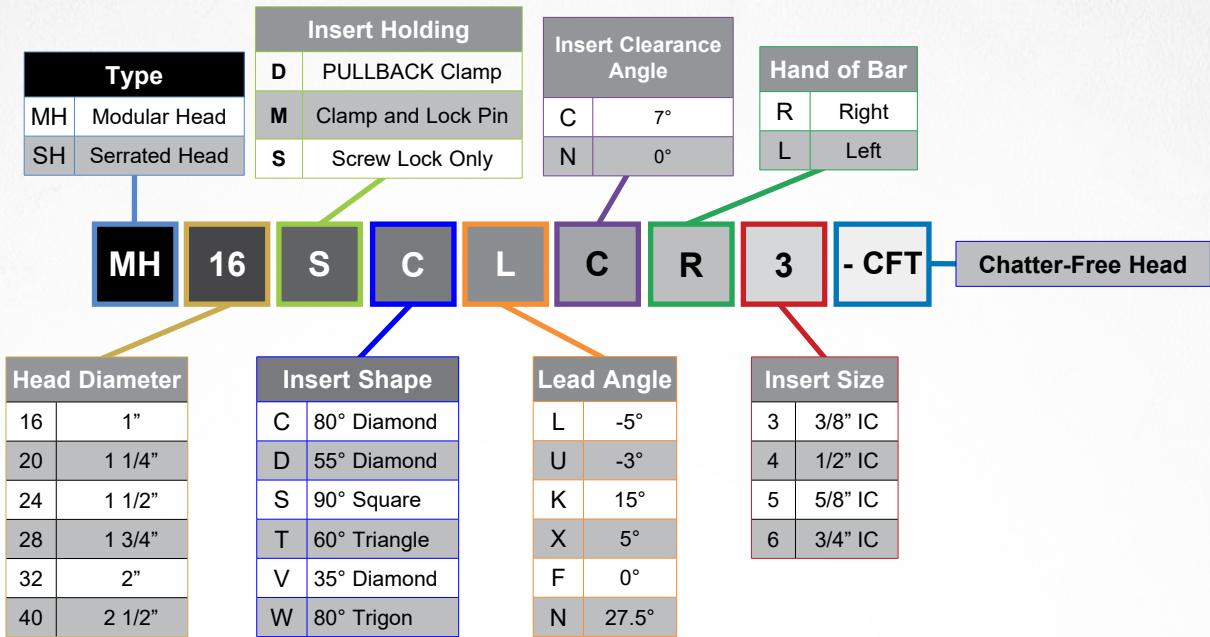
PACKAGE SIZE OF 1

PRODUCT #	Anvil Screw
968-000-146	SY3T
968-000-147	SY4T
968-000-148	SY5T

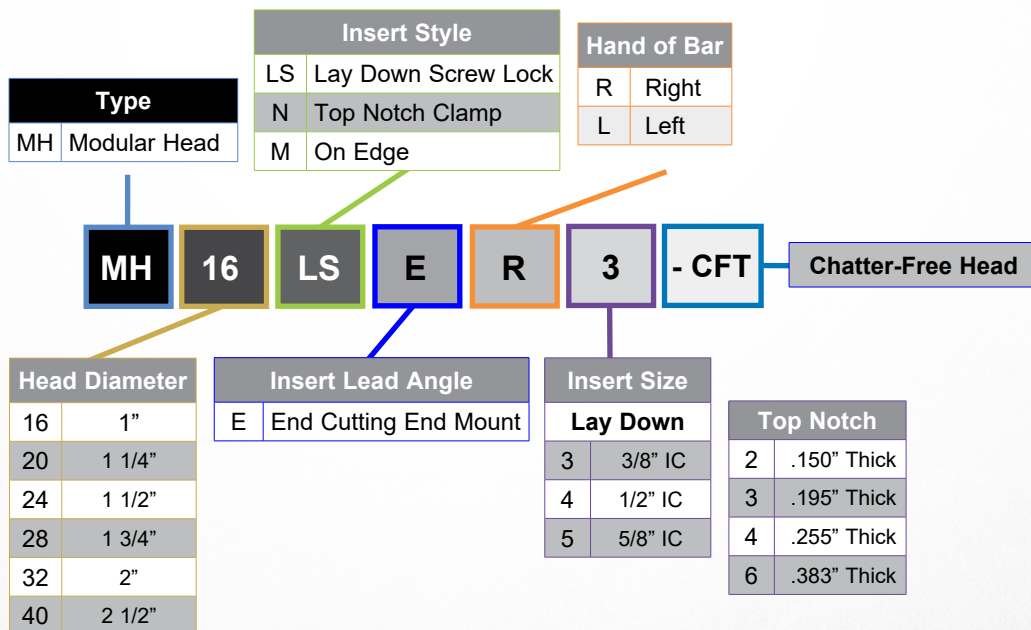
PACKAGE SIZE OF 5

PRODUCT #	Insert Screw
968-000-124	SA3T
968-000-125	SA4T
968-000-126	SA5T

PACKAGE SIZE OF 5



Threading / Grooving

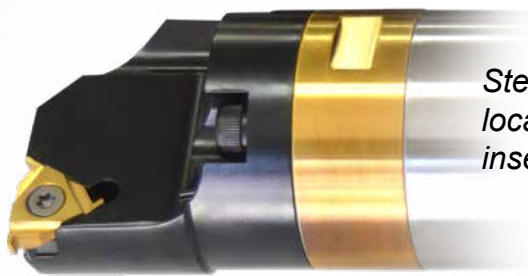


Choosing the largest possible bar size with the shortest overhang will provide rigidity to minimize vibrations.

Make sure to allow clearance for chips.

5:1 Stealth bars are recommended for grooving and threading where forces are higher than in turning.

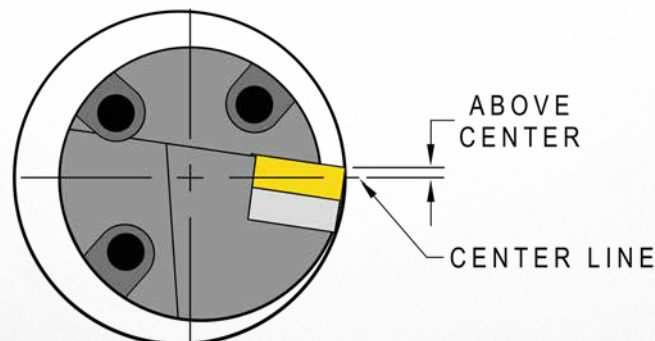
Proper clamping of the bar is crucial to performance.
(Set screws should not come in contact with the bar)



Stealth bars Ø1.0," and larger have a flat located on the gold ring to indicate the insert on the centerline.

Overhang is measured from cutting edge to face of boring bar holder.
Bars should not be extended past the specified diameter to length ratio.
The Bars can be modified to reduce overall length .

To compensate for bar deflection due to extended overhangs, rotating the insert above center line will help.



Split Collar System

To assure the best rigidity of the boring bar, the Split Collar System is the best holder. This process is achieved by locking the bar 360° on the diameter.



Split Bushing System

If set screws are to be used, a split bushing must be placed on the bar before placing in the machine. Set screws will contact the bushing and tighten around the bar.

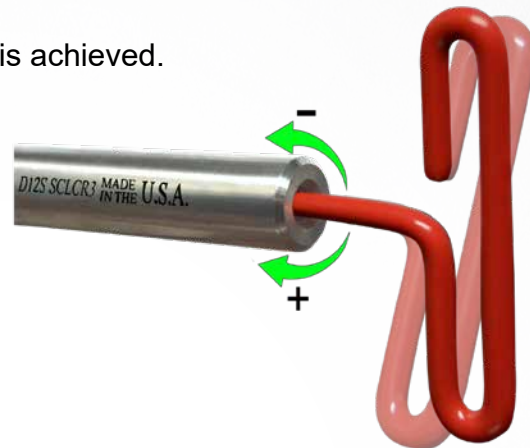


Set Screw Lock System

Do not lock in the boring bar with set screws. This creates very poor rigidity when there is one point of contact.

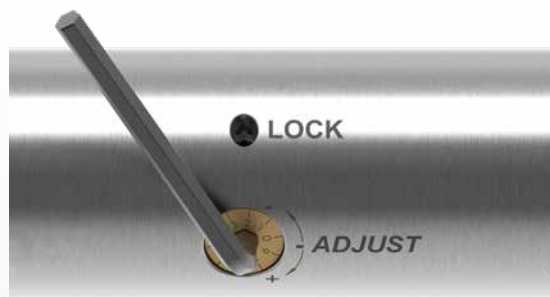
For Bars ϕ .75" and Smaller

1. Make a test cut with the bar.
2. Insert supplied T-handle wrench into the end of the bar.
3. If the pitch of the chatter was high, tighten the adjust screw 1/16 turn.(+)
4. If the pitch of the chatter was low, loosen the adjust screw 1/16turn.(-)
5. Make a test cut with the bar.
6. Repeat step 3 until the desired performance is achieved.

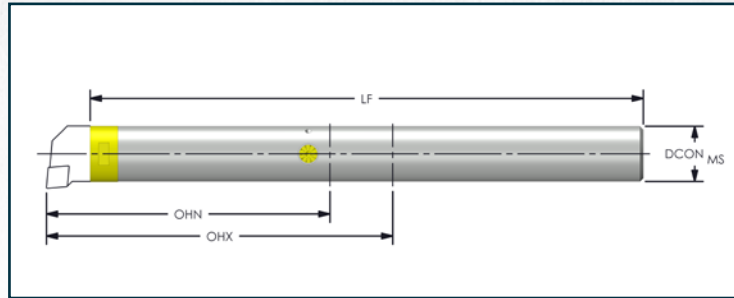


For Bars ϕ 1.0" and Above

1. Make a test cut with the bar.
2. Loosen lock screw two complete turns in the negative direction.
3. If the pitch of the chatter was high, tighten the adjust screw 1/2 digit.(+)
4. If the pitch of the chatter was low, loosen the adjust screw 1/2 digit.(-)
5. Make a test cut with the bar.
6. Repeat step 3 until the desired performance is achieved.
7. Tighten lock screw. DO NOT over tighten lock screw.



HANGOUT SPECS



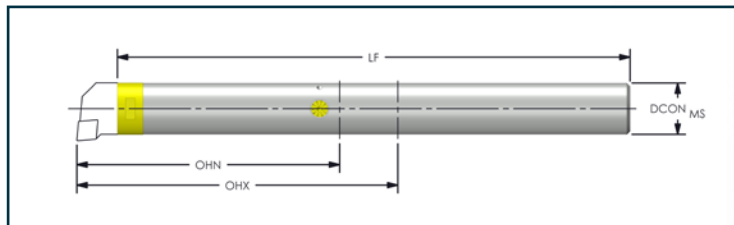
5:1 Ratio

DCONms	OHN	OHX	LF	Weight (LBS)
1.000	5.750	7.50	9.00	4.5
2.000	6.375	10.00	12.00	10.7
2.500	6.750	12.50	16.00	22.8
1.000	5.000	7.00	10.00	2.2
1.250	5.000	8.75	12.00	4.1
1.500	5.750	10.50	15.00	7.5
1.750	6.000	12.25	18.00	11.3
2.000	6.375	14.00	20.00	18.0
2.500	6.750	17.50	27.00	42.0
3.000	12.500	21.00	31.00	63.0
1.000	6.000	10.00	14.00	3.1
1.250	6.750	12.50	16.00	5.7
1.500	9.000	15.00	19.00	11.0
1.750	10.625	17.50	23.00	17.0
2.000	12.375	20.00	26.00	25.0
2.500	15.875	25.00	33.00	42.0
3.000	19.375	30.00	40.00	88.0
4.000	26.375	40.00	50.00	182.0

7:1 Ratio

10:1 Ratio

**HANGOUT SPECS
CARBIDE REINFORCED**



12:1 Ratio

DCONms	OHN	OHX	LF	Weight (LBS)
1.000	9.250	12.00	16.00	5.9
1.250	12.160	15.00	18.00	9.0
1.500	14.750	18.00	22.00	16.4
1.750	16.435	21.00	25.00	25.4
2.000	17.750	24.00	29.00	37.7
1.000	9.250	14.00	18.00	6.9
1.250	12.160	17.50	22.00	10.9
1.500	14.750	21.00	25.00	18.6
1.750	16.435	24.50	29.00	31.0
2.000	17.750	28.00	33.00	44.2

Ultra-Dex®	Kennametal®
MH16 SCLCR3-CFT	H16 SCLCR3
MH16 SCLCL3-CFT	H16 SCLCL3
MH16 MCLNR4-CFT	H16 MCLNR4
MH20 MCLNR4-CFT	H20 MCLNR4
MH24 MCLNR4-CFT	H24 MCLNR4
MH28 MCLNR4-CFT	H28 MCLNR4
MH32 MCLNR4-CFT	H32 MCLNR4
MH40 MCLNR4-CFT	H40 MCLNR4
MH24 MCLNR5-CFT	H24 MCLNR5
MH32 MCLNR5-CFT	H32 MCLNR5
MH40 MCLNR5-CFT	H40 MCLNR5
MH32 MCLNR6-CFT	H32 MCLNR6
MH40 MCLNR6-CFT	H40 MCLNR6
MH16 MCLNL4-CFT	H16 MCLNL4
MH20 MCLNL4-CFT	H20 MCLNL4
MH24 MCLNL4-CFT	H24 MCLNL4
MH28 MCLNL4-CFT	H28 MCLNL4
MH32 MCLNL4-CFT	H32 MCLNL4
MH40 MCLNL4-CFT	H40 MCLNL4
MH24 MCLNL5-CFT	H24 MCLNL5
MH32 MCLNL5-CFT	H32 MCLNL5
MH40 MCLNL5-CFT	H40 MCLNL5
MH32 MCLNL6-CFT	H32 MCLNL6
MH40 MCLNL6-CFT	H40 MCLNL6
MH24 MSKNR4-CFT	H24 MSKNR4
MH28 MSKNR4-CFT	H28 MSKNR4
MH32 MSKNR4-CFT	H32 MSKNR4
MH40 MSKNR6-CFT	H40 MSKNR6
MH20 MSKNL4-CFT	H20 MSKNL4
MH24 MSKNL4-CFT	H24 MSKNL4
MH40 MSKNL6-CFT	H40 MSKNL6
MH20 MWLNR4-CFT	H20 MWLNR4
MH24 MWLNR4-CFT	H24 MWLNR4
MH28 MWLNR4-CFT	H28 MWLNR4
MH32 MWLNR4-CFT	H32 MWLNR4
MH20 MWLNL4-CFT	H20 MWLNL4
MH24 MWLNL4-CFT	H24 MWLNL4
MH28 MWLNL4-CFT	H28 MWLNL4
MH32 MWLNL4-CFT	H32 MWLNL4
MH16 MDUNR3-CFT	H16 MDUNR3
MH24 MDUNR3-CFT	H24 MDUNR3
MH32 MDUNR3-CFT	H32 MDUNR3
MH20 MDUNR4-CFT	H20 MDUNR4
MH24 MDUNR4-CFT	H24 MDUNR4
MH28 MDUNR4-CFT	H28 MDUNR4
MH32 MDUNR4-CFT	H32 MDUNR4
MH40 MDUNR4-CFT	H40 MDUNR4
MH16 MDUNL3-CFT	H16 MDUNL3
MH24 MDUNL3-CFT	H24 MDUNL3

Ultra-Dex®	Kennametal®
MH28 MDUNL4-CFT	H28 MDUNL4
MH32 MDUNL4-CFT	H32 MDUNL4
MH40 MDUNL4-CFT	H40 MDUNL4
MH20 MVUNR3-CFT	H20 MVUNR3
MH24 MVUNR3-CFT	H34 MVUNR3
MH32 MVUNR3-CFT	H32 MVUNR3
MH40 MVUNR3-CFT	H40 MVUNR3
MH20 MVUNL3-CFT	H20 MVUNL3
MH24 MVUNL3-CFT	H24 MVUNL3
MH32 MVUNL3-CFT	H32 MVUNL3
MH40 MVUNL3-CFT	H40 MVUNL3
MH40 MVUNR4-CFT	H40 MVUNR4
MH40 MVUNL4-CFT	H40 MVUNL4
MH16 LSER3-CFT	H16 LSER3
MH20 LSER3-CFT	H20 LSER3
MH24 LSER3-CFT	H24 LSER3
MH32 LSER3-CFT	H32 LSER3
MH24 LSER4-CFT	H24 LSER4
MH32 LSER4-CFT	H32 LSER4
MH32 LSER5-CFT	H32 LSER5
MH40 LSER5-CFT	H40 LSER5
MH16 LSEL3-CFT	H16 LSEL3
MH20 LSEL3-CFT	H20 LSEL3
MH24 LSEL3-CFT	H24 LSEL3
MH24 LSEL4-CFT	H24 LSEL4
MH32 LSEL4-CFT	H32 LSEL4
MH32 LSEL5-CFT	H32 LSEL5
MH40 LSEL5-CFT	H40 LSEL5
MH20 NER3-CFT	H20 NER3W
MH24 NER3-CFT	H24 NER3W
MH28 NER3-CFT	H28 NER3W
MH32 NER3-CFT	H32 NER3W
MH28 NER4-CFT	H28 NER4W
MH32 NER4-CFT	H32 NER4W
MH40 NER4-CFT	H40 NER4W
MH28 NER6-CFT	H28 NER6W
MH32 NER6-CFT	H32 NER6W
MH40 NER6-CFT	H40 NER6W
MH20 NEL3-CFT	H20 NEL3W
MH24 NEL3-CFT	H24 NEL3W
MH28 NEL3-CFT	H28 NEL3W
MH32 NEL3-CFT	H32 NEL3W
MH28 NEL4-CFT	H28 NEL4W
MH32 NEL4-CFT	H32 NEL4W
MH40 NEL4-CFT	H40 NEL4W
MH28 NEL6-CFT	H28 NEL6W
MH32 NEL6-CFT	H32 NEL6W
MH40 NEL6-CFT	H40 NEL6W

Ultra-Dex®	Sandvik®
SH16 SCLCR3	570-SCLCR-25-09
SH20 SCLCR3	570-SCLCR-32-10
SH24 SCLCL4	570-SCLCR-40-12
SH16 SCLCL3	570-SCLCL-25-09
SH20 SCLCL3	570-SCLCL-32-10
SH24 SCLCR4	570-SCLCL-40-12
SH20 STFGR3	570-STFCR-32-16
SH24 STFGR3	570-STFCR-40-16
SH20 STFCL3	570-STFCL-32-16
SH24 STFCL3	570-STFCL-40-16
SH16 SDUCR3	570-SDUCR-25-11
SH20 SDUCR3	570-SDUCR-32-11
SH24 SDUCR3	570-SDUCR-40-11
SH16 SDUCL3	570-SDUCL-25-11
SH20 SDUCL3	570-SDUCL-32-11
SH24 SDUCL3	570-SDUCL-40-11
SH16 SDNCR2	570-SDXCR-25-07-D
SH20 SDNCR3	570-SDXCR-32-11
SH24 SDNCR3	570-SDXCR-40-11
SH16 SDNCL2	570-SDXCL-25-07-D
SH20 SDNCL3	570-SDXCL-32-11

Ultra-Dex	Sandvik®
SH24 SDNCL3	570-SDXCL-40-11
SH16 SDXCR2	570-SDUCR-25-07-DX
SH20 SDXCR3	570-SDUCR-32-11X
SH24 SDXCR3	570-SDUCR-40-11X
SH16 SDXCL2	570-SDUCL-25-07-DX
SH20 SDXCL3	570-SDUCL-32-11X
SH24 SDXCL3	570-SDUCL-40-11X
SH20 DCLNR4	570-DCLNR-32-12-L
SH24 DCLNR4	570-DCLNR-40-12-L
SH20 DCLNL4	570-DCLNL-32-12-L
SH24 DCLNL4	570-DCLNL-40-12-L
SH20 DDUNR3	570-DDUNR-32-11
SH20 DDUNL3	570-DDUNL-32-11
SH20 DTFNR3	570-DTFNR-32-16-L
SH24 DTFNR3	570-DTFNR-40-16-L
SH20 DTFNL3	570-DTFNL-32-16-L
SH24 DTFNL3	570-DTFNL-40-16-L
SH20 DWLNR4	570-DWLNR-32-08-LE
SH24 DWLNR4	570-DWLNR-40-08-L
SH20 DWLNL4	570-DWLNL-32-08-LE
SH24 DWLNL4	570-DWLNL-40-08-L



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