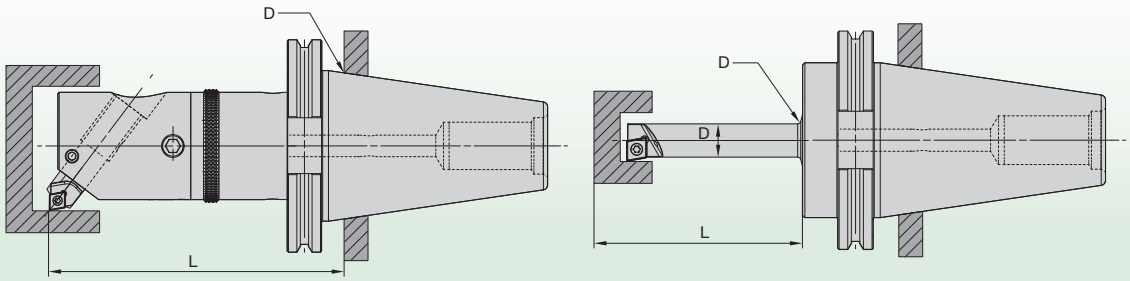
General Application Hints

- Identify your critical diameter (D).
- Identify the maximum distance cutting edge (L) to critical diameter.

Here are some examples:



Refer to this table for first investigation of application:

Type of Tooling	Stable	Unstable	Tests Necessary
Twin Cutter Solid Tools	<3,5 x D	3,5–6,5 x D	>6,5 x D
Twin Cutter Bridge Tools	<3,5 x D	3,5–6,5 x D	>6,5 x D
Fine-Boring Heads with Boring Bar (FBHBB)	<3,5 x D	3,5–5,0 x D	>5,0 x D
Fine-Boring Heads (FBH)	<3,5 x D	3,5–5,0 x D	>5,0 x D
Fine-Boring Bridge Tools	<3,5 x D	3,5–5,0 x D	>5,0 x D
	Function of the tool is expected without issues within recommended cutting data.	**Application may require reduced feeds and/or speeds compared to stable conditions.**	**Machining test may be required to identify cutting data.**

Causes of and remedies for rough and fine boring problems

It is generally assumed that the tools have been properly mounted as per the technical recommendations in this catalogue.

Problem	Cause	Possible Remedy
Vibration tendency	1. Overhang 2. Choice of insert 3. Cutting data	• Adjust L/D ratio • Select 90° lead angle on rough boring tools • Select inserts with positive geometry • Select inserts with smaller corner radius • Reduce depth of cut • Increase feed
Slight chatter marks on surface	1. Choice of insert 2. Cutting data 3. Machining environment	• Select 90° lead angle • Select ground inserts with small edge preparation • Select inserts with smaller corner radius • Increase feed • Increase coolant
Conical bores	1. Choice of insert 2. Cutting data 3. Machining environment	• Select a more wear-resistant insert grade • Increase cutting speed • Check whether all screws have been tightened to recommended torque