

Indexable Inserts

Rigibore® The Most Accurately Adjustable Boring Tools in the World



Inserts by Rigibore®

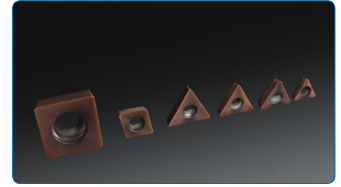
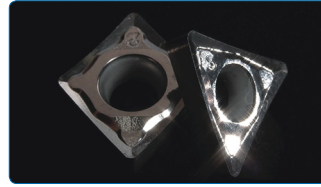
All areas of production catered for, including low speed roughing, interrupted cuts and optimised machining of specialised materials

Ground to ISO H tolerance, long lasting, fast metal removal

Finishing

Choice of geometries - Uncoated and coated grades

Inserts for cast iron, aluminum, steel, brass, bronze and titanium alloys



Rigibore Insert Grades

Grade	I.S.O	ANSI	Description	Coating	Materials
RC217	M10 - M25 K05 - K25	C2-C3	High-speed finishing. Exceptional resistance to wear, oxidation & thermal shock	PVD composite coated	Cast iron heat-resisting titanium alloy
R71	P05-P25 M10-M20	P6-P7	Light roughing & finishing. High cutting speeds with moderate feeds. High resistance to wear & thermal shock	Uncoated	Steel, cast steel
R22	K10-K25 M10-M30	C2-C3	Wide range of applications. High resistance to wear & good edge sharpness. Moderate cutting	Micro-grain uncoated	Cast Iron, ferrous materials, heat resisting titanium alloy & aircraft aluminum

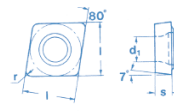
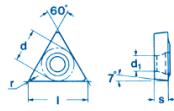
Chipbreaker Geometries

A choice of 4 geometries is available to suit most applications
Ultra-precision ground to I.S.O. "H" tolerance for indexing within .0005"/0.013mm

0° T.R.	Brass, S.G. Cast Iron, hardened steel, short-chipping Bronze
8° T.R.	Alloy steels, tool steels, some bronzes, some grey cast irons & tougher materials
14° T.R.	Mild steels, stainless steels, some tool steels, heat-resisting steel alloys, hard plastics
22° T.R.	Aluminum, aluminum alloys, soft plastics, rubber, magnesium alloys, copper

Inserts for Aluminum

Size	Order Code	Available Grades	d (I.C)		l*		d1		s		r	
			mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
06-16	TCHT 06 11 04 FN-AL	R22	3.97	.156	6.87	.27	2.2	.087	1.98	.078	0.4	.016
	TCHT 09 02 04 FN-AL		5.56	.22	9.63	.38	2.5	.098	2.38	.094		
	TCHT 11 02 04 FN-AL		6.35	.25	11.0	.43	2.8	.11	2.38	.094		
	TCHT 16 T3 08 FN-AL		9.525	.375	16.5	.65	4.4	.17	3.97	.156	0.8	.031
06-12	CCHT 06 02 04 FN-AL	R22	6.35	.25	6.35	.25	2.8	.11	2.38	.094	0.4	.016
	CCHT 09 T3 08 FN-AL		9.525	.375	9.525	.375	4.4	.17	3.97	.156	0.8	.031
	CCHT 12 02 08 FN-AL		12.7	.5	12.7	.5	5.5	.217	4.74	.187		



Inserts for all uses

L = Left hand (boring), R = Right hand (turning)

Size	Order Code	Available Grades	Top Rake (deg)	d (I.C)		l*		d1		s		r		
				mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	
06	TCHW 06 T1 02	RC217, R22	0	3.97	0.156	6.87	0.27	2.2	0.087	1.98	0.078	0.2	0.008	
	TCHW 06 T1 04											0.4	0.016	
	TCHW 06 T1 08	RC217										0.8	0.031	
	TCHX 06 T1 01 - L22	R22										22	0.1	0.004
	TCHX 06 T1 02 - L08	R71										8	0.2	0.008
	TCHX 06 T1 02 - L14											14		
	TCHX 06 T1 02 - L22	R22										22	0.4	0.016
	TCHX 06 T1 04 - L08	R71										8		
09	TCHW 09 02 02	RC217, R22	0	5.56	0.219	9.63	0.379	2.5	0.098	2.38	0.094	0.2	0.008	
	TCHW 09 02 04											0.4	0.016	
	TCHW 09 02 08											0.8	0.031	
	TCHX 09 02 01 - L22	R22										22	0.2	0.008
	TCHX 09 02 02 - L14	R71										14	0.2	0.008
	TCHX 09 02 02 - L22	R22										22		
	TCHX 09 02 04 - L08	R71										8	0.4	0.016
	TCHX 09 02 04 - L14											14		
11	TCHW 11 02 02	RC217, R22	0	6.35	0.25	11	0.433	2.8	0.11	2.38	0.094	0.2	0.008	
	TCHW 11 02 04											0.4	0.016	
	TCHW 11 02 08											0.8	0.031	
	TCHX 11 02 01 - L22	R22										22	0.1	0.004
	TCHX 11 02 02 - L08	R71										8	0.2	0.008
	TCHX 11 02 04 - L08											14		
	TCHX 11 02 04 - L14											14		
16	TCHW 16 T3 02	R22	0	9.525	0.375	16.5	0.65	4.4	0.173	3.97	0.156	0.2	0.008	
	TCHW 16 T3 04	RC217, R22										0.4	0.016	
	TCHW 16 T3 08											0.8	0.031	
	TCHW 16 T3 12											1.2	0.047	
	TCHX 16 T3 04 - L14	R71										14	0.4	0.016
	TCHX 16 T3 08 - L22	R22										22	0.8	0.031
06	CCHW 06 02 04	RC217, R22	0	6.35	0.25	6.35	0.25	2.8	0.11	2.38	0.094	0.4	0.016	
	CCHW 06 02 08											RC217	0.8	0.031
	CCHX 06 02 04 - L14	14											0.2	0.008
	CCHX 06 02 02 - L22	R22												
	CCHX 06 02 04 - L08	RC217, R22, R71										8	0.4	0.016
	CCHX 06 02 04 - R08											R22		
	CCHX 06 02 04 - L14	R71										14		
09	CCHW 09 T3 04	RC217, R22	0	9.525	0.375	9.525	0.375	4.4	0.173	3.97	0.156	0.4	0.016	
	CCHW 09 T3 08											RC217	0.8	0.031
	CCHX 09 T3 02 - L08	8											0.2	0.008
	CCHX 09 T3 04 - L08	RC217, R71											8	0.4
	CCHX 09 T3 08 - L08											RC217	8	0.8
12	CCHW 12 04 08	RC217	0	12.7	0.5	12.7	0.5	5.5	0.216	4.74	0.187	0.8	0.031	
04	CPHW 04 T1 04	RC217, R22	0	4.76	0.187	4.8	0.189	2.15	0.085	1.98	0.078	0.4	0.016	