

KAISER[®]

NEW!

SERIES 639-1

Chamfering & Back Boring
Insert Holders for Series
319 SW Boring Heads



A PRODUCT OF:

BIG KAISER[®]

PRECISION TOOLING INC.

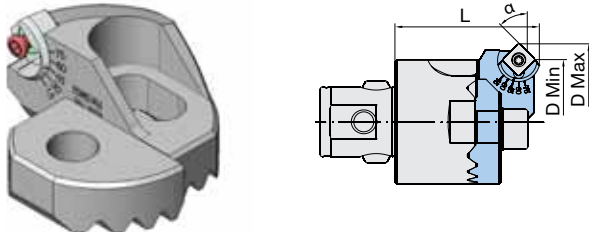
Higher Performance. Guaranteed.

SERIES 639-1 CHAMFERING INSERT HOLDERS FOR SERIES 319 SW

Insert Holders for Chamfering

These insert holders are made for front and back chamfering on the twin cutter roughing heads Series 319 SW41-SW148 and cover the diameter range $\varnothing 1.299''-8.268''$. The desired chamfering angle is adjustable from $15^\circ-75^\circ$.

The set contains one insert holder and one blank piece.

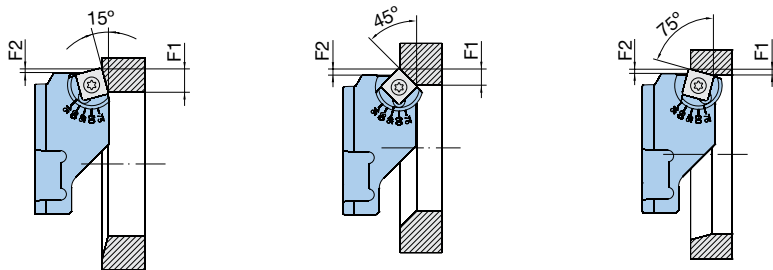


Boring Head	Catalog Number	15°		30°		45°		60°		75°		L 45° (RSS)	Insert
		D Min	D Max	D Min	D Max	D Min	D Max	D Min	D Max	D Min	D Max		
SW41	10.639.104	1.299	2.362	1.417	2.441	1.535	2.480	1.693	2.480	1.772	2.441	2.008	SC..09
SW53	10.639.105	1.772	2.992	1.890	3.071	2.008	3.110	2.165	3.110	2.244	3.071	2.283	
SW68	10.639.106	2.402	3.819	2.520	3.898	2.638	3.937	2.795	3.937	2.874	3.898	2.677	
SW98 (KAB6/CKN6)	10.639.107	3.031	4.961	3.189	5.039	3.386	5.079	3.543	5.039	3.701	5.000	2.874	SC..12
	10.639.108	4.094	6.024	4.252	6.102	4.449	6.142	4.606	6.102	4.764	6.063		
SW148 (KAB6/CKN6)	10.639.109	5.157	7.087	5.315	7.165	5.512	7.205	4.488	7.165	5.827	7.126		
	10.639.110	6.220	8.150	6.378	8.228	6.575	8.268	6.732	8.228	6.890	8.189		
SW98 (KAB7/CKN7)	10.639.107	3.031	4.961	3.189	5.039	3.386	5.079	3.543	5.039	3.701	5.000	3.504/4.685*	
	10.639.108	4.094	6.024	4.252	6.102	4.449	6.142	4.606	6.102	4.764	6.063		
SW148 (KAB7/CKN7)	10.639.109	5.157	7.087	5.315	7.165	5.512	7.205	5.669	7.165	5.827	7.126		
	10.639.110	6.220	8.150	6.378	8.228	6.575	8.268	6.732	8.228	6.890	8.189		

*With SW98L x KAB7/CKN7

Radial Chamfer Length for Front (F1) and Back (F2) Chamfering

Applicable for inserts with .016" nose radius.

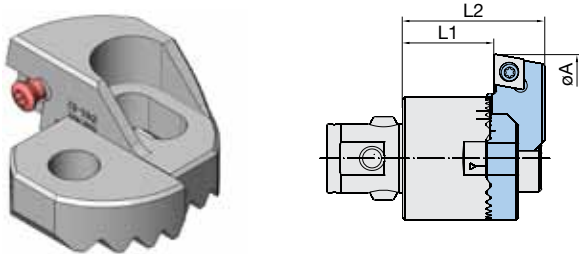


Boring Head	Insert	Chamfer Angle									
		15°		30°		45°		60°		75°	
		F1 Max	F2 Max	F1 Max	F2 Max	F1 Max	F2 Max	F1 Max	F2 Max	F1 Max	F2 Max
SW41	SC..09	.303	.028	.272	.055	.224	.071	.157	.067	.083	.047
SW53											
SW68											
SW98	SC..12	.417	.047	.374	.087	.307	.102	.217	.098	.110	.071
SW148											

Insert Holders for Back Boring

These insert holders are made for back boring with the twin cutter rough boring heads Series 319 SW32-SW148 and cover the diameter range from $\phi 1.732''$ - $8.307''$.

The set contains one insert holder and one blank piece.

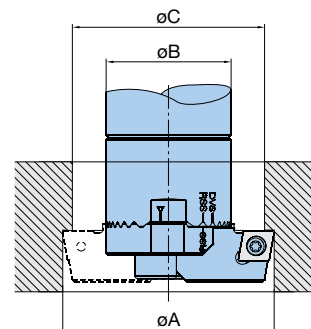


Boring Head	Catalog Number	ϕA		B	L1 (RSS)	L2 (RSS)	Insert
		Min	Max				
SW32	10.639.403	1.732	2.126	1.220	.945	1.496	CC..09
SW41	10.639.404	2.087	2.598	1.535	1.142	1.732	
SW53	10.639.405	2.559	3.228	1.969	1.339	2.165	
SW68	10.639.406	3.189	4.055	2.500	1.614	2.598	CC..12
SW98 (KAB6/CKN6)	10.639.407	4.016	5.118	3.543	1.496	2.717	
	10.639.408	5.079	6.181				
SW148 (KAB6/CKN6)	10.639.409	6.142	7.244	5.512	1.850/3.031*	3.071/4.252*	
	10.639.410	7.205	8.307				
SW98 (KAB7/CKN7)	10.639.407	4.016	5.118	3.543	1.850/3.031*	3.071/4.252*	
	10.639.408	5.079	6.181				
SW148 (KAB7/CKN7)	10.639.409	6.142	7.244	5.512	3.031	4.252	
	10.639.410	7.205	8.307				

*With SW98L x KAB7/CKN7

Back Bore & Entry Bore Diameters

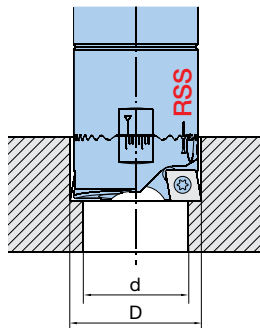
Maximum Back Bore Diameter 'A'	$A \max = (2 \times C) - B$
Maximum Body Diameter 'B'	$B \max = (2 \times C) - A$
Minimum Entry Bore Diameter 'C'	$C \min = (A+B)/2$



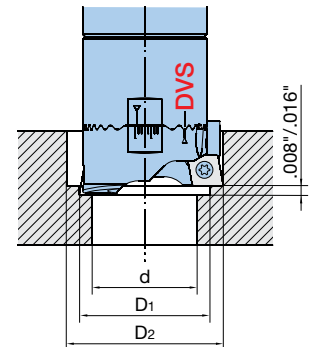
SERIES 639-1 APPLICATION EXAMPLES

Roughing

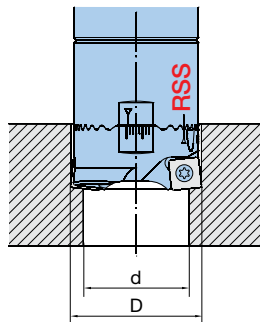
Insert Holders: Type CC
RSS*, ϕ .787"-8.000"
High feed rates



Insert Holders: Type CC
DVS*, ϕ .787"-8.000"
Double stock removal, half the feed rate



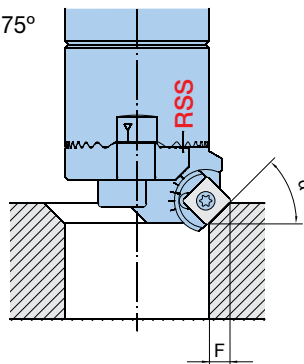
Insert Holders: Type SP/SC
RSS*, ϕ .787"-8.000"
4 cutting edges, lead angle 6°



***RSS: Balanced Cutting**
***DVS: Stepped Cutting**

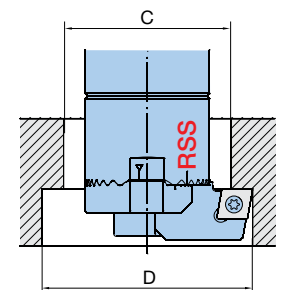
Chamfering

ϕ 1.535"-8.268" (45°)
Adjustable chamfer angle 15°-75°



Back Boring

ϕ 1.732"-8.307"
Lead angle 90°



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