

# NPA

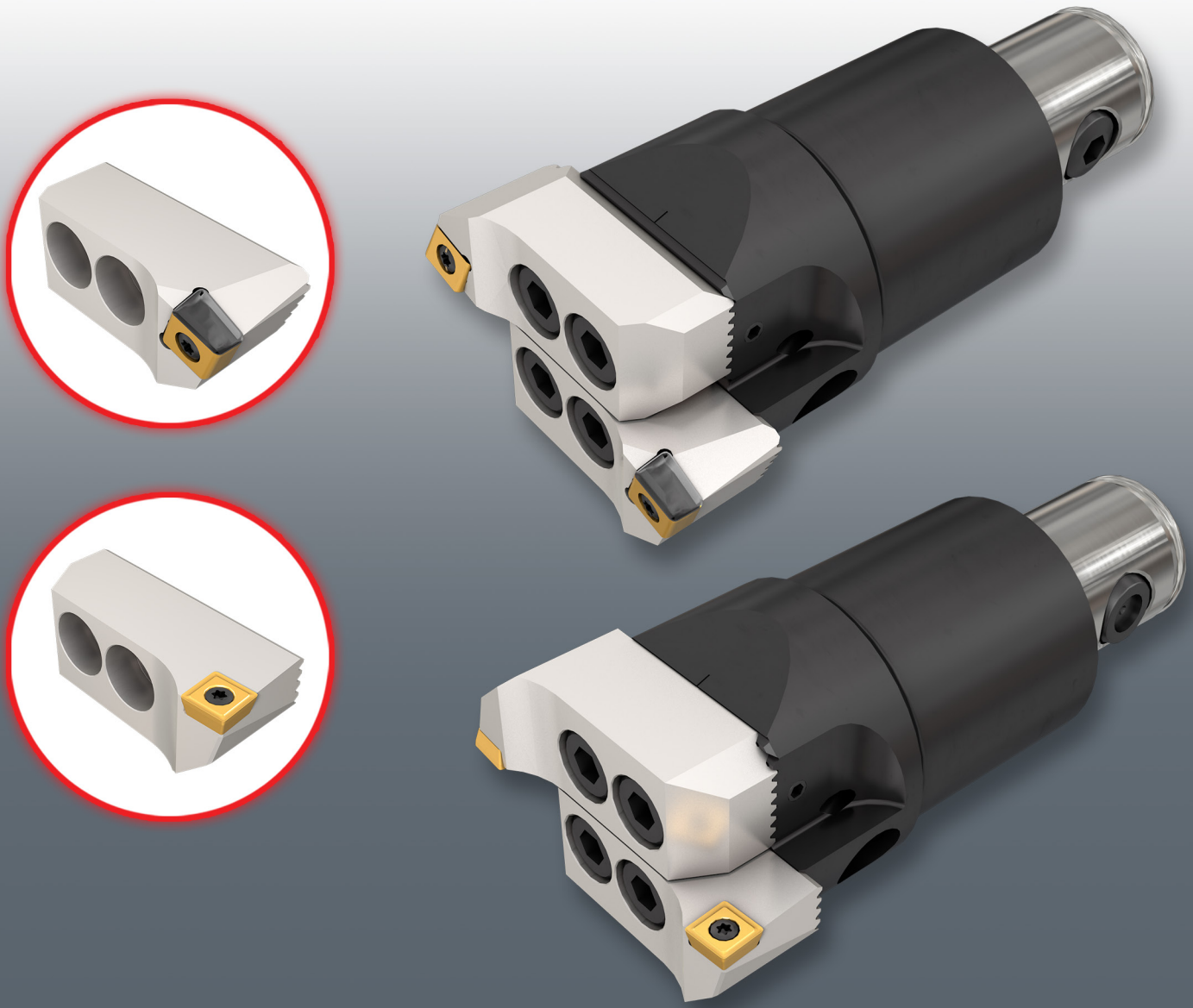
New Product Announcement

HOLE MAKING

48-2020

OCTOBER 2020 • METRIC

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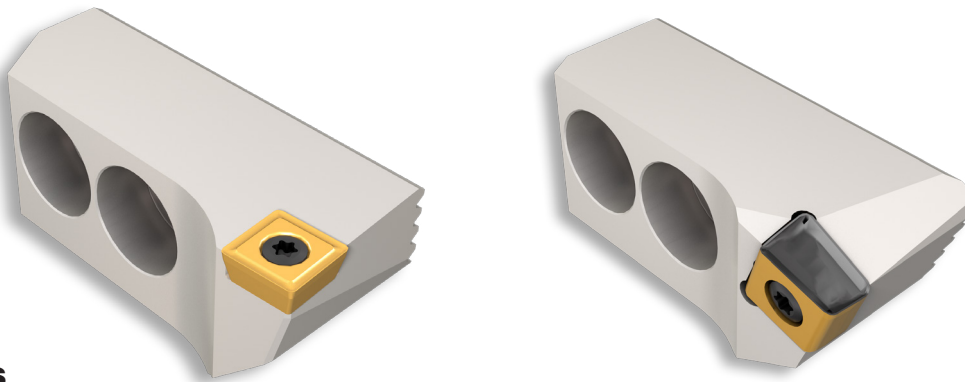
## **ITSBORE**

**New Standard Cartridges for  
BHR Boring Heads with Pocket Seats  
Intended for ISCAR's Unique Inserts**

**ITSBORE**

## Highlights

**ISCAR introduces new cartridges which mount ISCAR's unique inserts. This development promotes the return business of ITS BORE customers and provides the superior engineering performance of ISCAR's insert designs.**



### Features

#### CR SOMT09 68-90-CP

- A new cartridge for square drilling inserts.
- Four cutting corners.
- Several geometry types.
- A selection of grades.
- Able to machine up to  $a_p=8$  mm.

#### CR LNHT10 68-90-CP

- A new cartridge for tangential plunging inserts.
- Four cutting corners.
- Robust structure enables the cartridge to withstand heavy duty machining.
- Unmatched performance in cast iron boring with a depth of cut ( $a_p$ ) of up to 9 mm per side.

**Click Link to  
See Short Video**



<https://youtu.be/7cCUn5m9Drg>

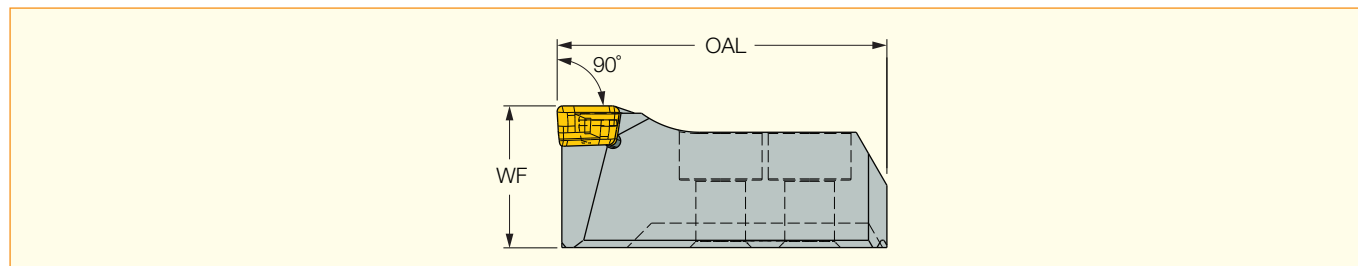
### Availability

In stock.

# ITSBORE

## CR LNHT

Boring Cartridge with Tangential Insert for BHR MB50-50X100 Boring Head



Designation	DCN <sup>(1)</sup>	DCX <sup>(2)</sup>	WF	OAL	MIID <sup>(3)</sup>
CR LNHT10 68-90-CP	68.00	90.00	23.10	53.76	HTP LN.. 1006

<sup>(1)</sup> Cutting diameter minimum <sup>(2)</sup> Cutting diameter maximum <sup>(3)</sup> Master insert identification

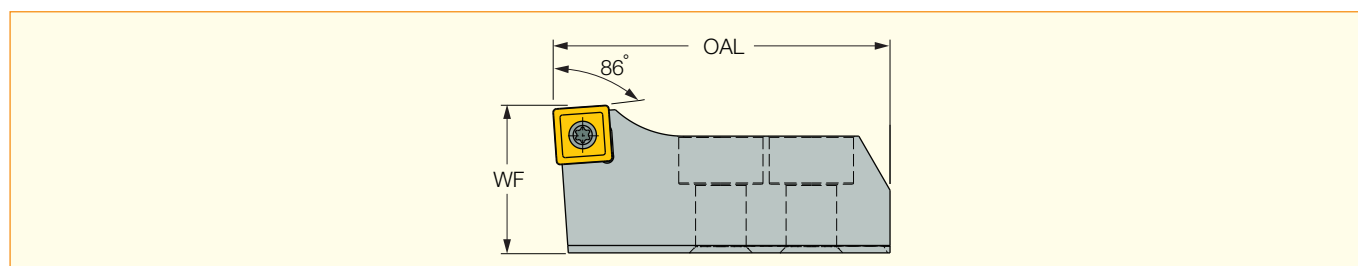
### Spare Parts



Designation	Handle	Screw	Torx Blade
CR LNHT	SW6-SD	SR 34-550	BLD T10/S7

## CR SOMT

Boring Cartridge with Square Insert for BHR MB50-50X100 Boring Head



Designation	DCN <sup>(1)</sup>	DCX <sup>(2)</sup>	WF	OAL	MIID <sup>(3)</sup>
CR SOMT09 68-90-CP	68.00	90.00	23.60	54.00	SO.T 09...

<sup>(1)</sup> Cutting diameter minimum <sup>(2)</sup> Cutting diameter maximum <sup>(3)</sup> Master insert identification

### Spare Parts



Designation	Handle	Screw	Torx Blade
CR SOMT	SW4-SD	SR 34-506	BLD T09/M7-SW4



Material	Hardness	CR SO...-CP Ø68-90 mm			CR LN...-CP Ø68-90 mm		
			ap [mm] 0.5-3	ap [mm] 3-7		ap [mm] 0.5-3	ap [mm] 3-9
		Vc [m/min]	Fz [mm/rev]	Fz [mm/rev]	Vc [m/min]	Fz [mm/rev]	Fz [mm/rev]
Low Carbon Steel (<0.3% C)	<200HB	50-140-220	0.14-0.22	0.1-0.2	50-140-220	0.15-0.3	0.12-0.2
Carbon Steel (>0.3% C)	>200HB	60-120-180	0.14-0.22	0.1-0.2	60-120-180	0.15-0.3	0.12-0.2
Alloy Steel	<300HB	100-150-220	0.14-0.22	0.1-0.2	100-150-220	0.15-0.3	0.12-0.2
Alloy Steel	>300HB	70-140-180	0.14-0.22	0.1-0.2	70-140-180	0.15-0.3	0.12-0.2
Stainless Steel (Ferritic)	200HB	50-100-200	0.14-0.22	0.1-0.2	50-100-200	0.15-0.3	0.12-0.2
Stainless Steel (Martensitic)	240HB	50-110-180	0.14-0.22	0.1-0.2	50-110-180	0.15-0.3	0.12-0.2
Stainless Steel (Austenitic)	180HB	50-100-180	0.1-0.2	0.08-0.15	50-100-180	0.1-0.2	0.1-0.2
Grey Cast Iron	180-280HB	60-230-300	0.18-0.3	0.1-0.25	60-230-300	0.1-0.3	0.1-0.25
Ductile Cast Iron	160-250HB	60-160-280	0.18-0.3	0.1-0.25	60-160-280	0.1-0.3	0.1-0.25
Malleable Cast Iron	130-230HB	60-160-280	0.18-0.3	0.1-0.25	60-160-280	0.1-0.3	0.1-0.25
Aluminum	60-130HB	100-200-300	0.1-0.25	0.1-0.25	100-200-700	0.05-0.25	0.05-0.15
Copper Alloys	90-110HB	100-200-300	0.1-0.25	0.1-0.25	100-200-300	0.05-0.25	0.05-0.15
High Temp Alloys and Ti Alloys	110-310HB	20-50	0.08-0.12	0.08-0.12	25-60	0.1-0.2	0.1-0.2
Hardened Steel	50-60 HRC	20-50	0.08-0.12	0.08-0.12	45-70	0.1-0.2	0.1-0.2

\*Reference table. Choose grades according materials.  
 \*Internal coolant is recommended.  
 \*Chip formers should be selected according each insert type.  
 \*Low speed advised when L/D ratio exceeds x4.