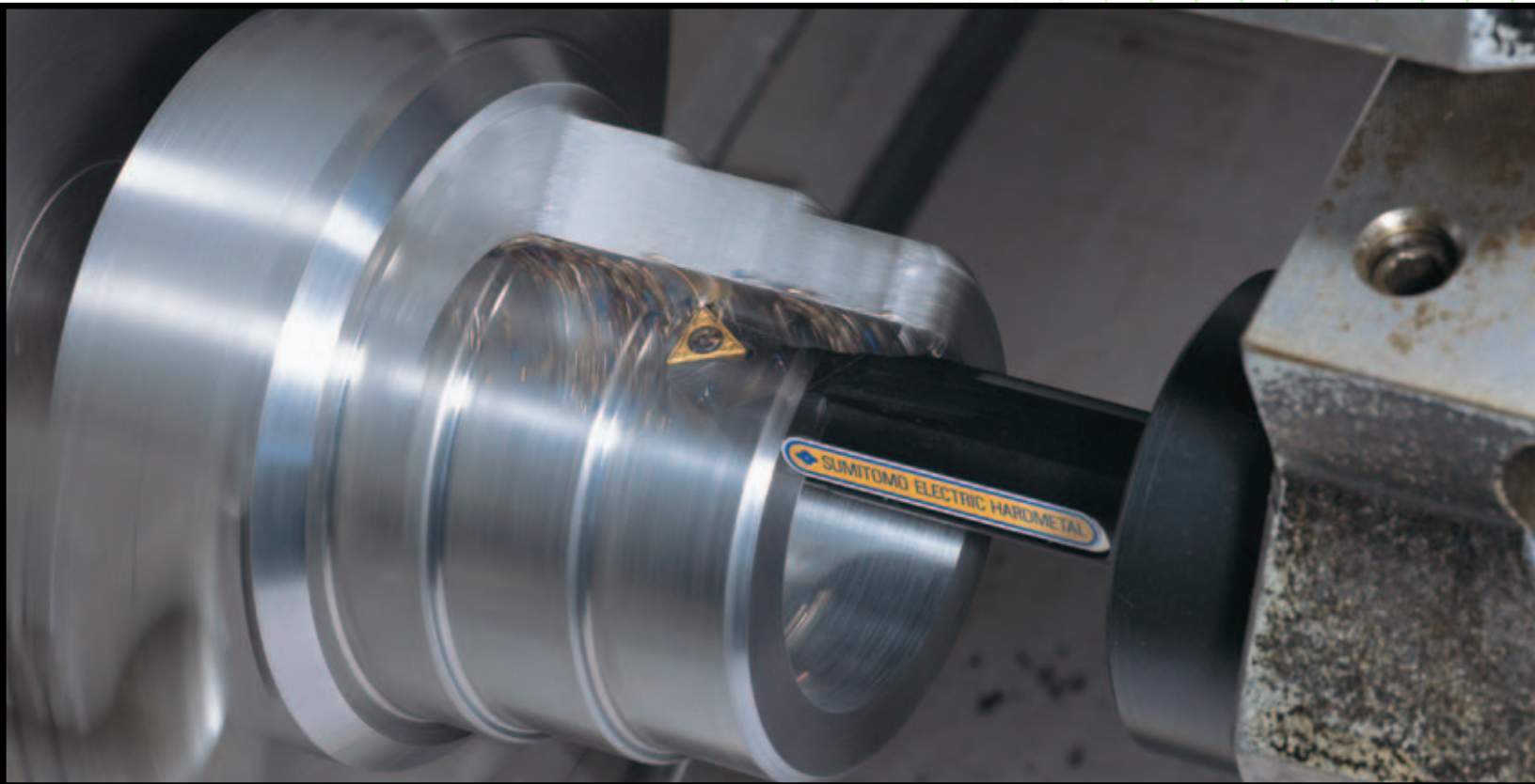


 SUMITOMO ELECTRIC

# *SumiTurn* *X-BAR*



*The Anti-Vibration boring  
bar that eliminates CHATTER!*



**SumiTurn**  **-Bar**

# SumiTurn X-BAR

## Features & Benefits

- Special dampener mechanism eliminates chatter
- Up to 6X L/D overhang (depth bar diameter)
- Cost effective solution to carbide bars when deep hole boring
- All X-Bars are coolant-through
- Effectively rough bores deep holes
- Bars available with CCMT, TCMT and TPMT style inserts



## X-BAR Technical Information

**Good Chip Evacuation**  
from new head design

Evacuates long chips

Evacuates short chips

Strong cross section to withstand high cutting forces

Ribbed surface for maximum rigidity

**Anti-Chatter System**  
- Eliminates Vibration

Unique structure of the X-Bar

The dampener resists vibration (Patent pending)

**Application Range**

Overhang length (L/D)

Shank size  $\phi$ D (inch)

New anti-vibration type SumiTurn X-Bar

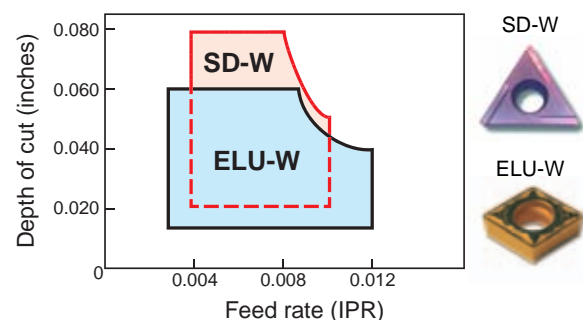
Steel shank

## Recommended Overhang Length / Shank Diameter (L/D)

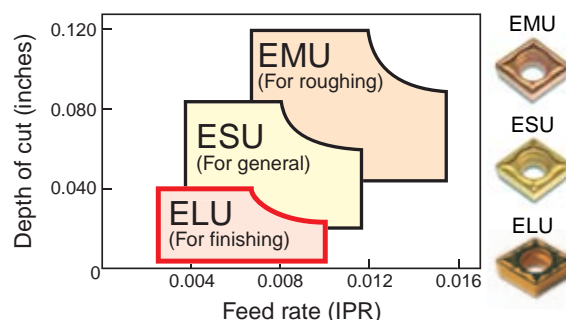
Chip Breakers	Type of Boring Bar	Over Hang Length (L/D)						
		1	2	3	4	5	6	7
<p><b>ELU, ESU, EMU</b> (M class inserts)</p>	<p><b>NEW</b></p> <p>Steel shank</p> <p>SumiTurn X-Bar</p>							
<p><b>ELU-W, SD-W</b> ("Wiper" style inserts)</p>	<p><b>NEW</b></p> <p>Steel shank</p> <p>SumiTurn X-Bar</p>							

## Recommended Chipbreakers

### “Wiper” Style Positive Inserts



### M Class Positive Inserts



# SumiTurn X-BAR



## SumiTurn X-Bar Availability

Sumitomo Cat. No.		Dimensions						Gage Insert	Hardware	
Right Hand	Left Hand	Min. Bore	D	L	S	H	$\theta^\circ$	Insert	Screw	Wrench
D08RSCLCR2	D08RSCLCL2	0.600"	0.500"	8"	0.300"	0.434"	-10°	CC-21.5	BFTX02506N	TRX08
D10SSCLCR3	D10SSCLCL3	0.770"	0.625"	10"	0.385"	0.590"	-8°	CC-32.5	BFTX0407N	TRX15
D12SSCLCR3	D12SSCLCL3	0.930"	0.750"	10"	0.465"	0.708"	-7°	CC-32.5	BFTX0409N	TRX15
D16TSCLCR3	D16TSCLCL3	1.200"	1.000"	12"	0.600"	0.906"	-6°	CC-32.5	BFTX0409N	TRX15

Sumitomo Cat. No.		Dimensions						Gage Insert	Hardware	
Right Hand	Left Hand	Min. Bore	D	L	S	H	$\theta^\circ$	Insert	Screw	Wrench
D08RSTUPR2	D08RSTUPL2	0.600"	0.500"	8"	0.300"	0.434"	-7°	TP-22	BFTX0306A	TRX10
D10SSTUPR2	D10SSTUPL2	0.770"	0.625"	10"	0.385"	0.590"	-4°	TP-22	BFTX0306A	TRX10
D12SSTUPR2	D12SSTUPL2	0.930"	0.750"	10"	0.465"	0.708"	-2°	TP-22	BFTX0307A	TRX10
D16TSTUPR3	D16TSTUPL3	1.200"	1.000"	12"	0.600"	0.906"	-2°	TP-33	BFTX0410A	TRX15

Sumitomo Cat. No.		Dimensions						Gage Insert	Hardware	
Right Hand	Left Hand	Min. Bore	D	L	S	H	$\theta^\circ$	Insert	Screw	Wrench
D08RSTUCR2	D08RSTUCL2	0.600"	0.500"	8"	0.300"	0.434"	-10°	TC-21.5	BFTX02506N	TRX08
D10SSTUCR2	D10SSTUCL2	0.770"	0.625"	10"	0.385"	0.590"	-8°	TC-21.5	BFTX02506N	TRX08
D12SSTUCR3	D12SSTUCL3	0.930"	0.750"	10"	0.465"	0.708"	-7°	TC-32.5	BFTX0409N	TRX15
D16TSTUCR3	D16TSTUCL3	1.200"	1.000"	12"	0.600"	0.906"	-6°	TC-32.5	BFTX0409N	TRX15





# SUMITOMO ELECTRIC

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