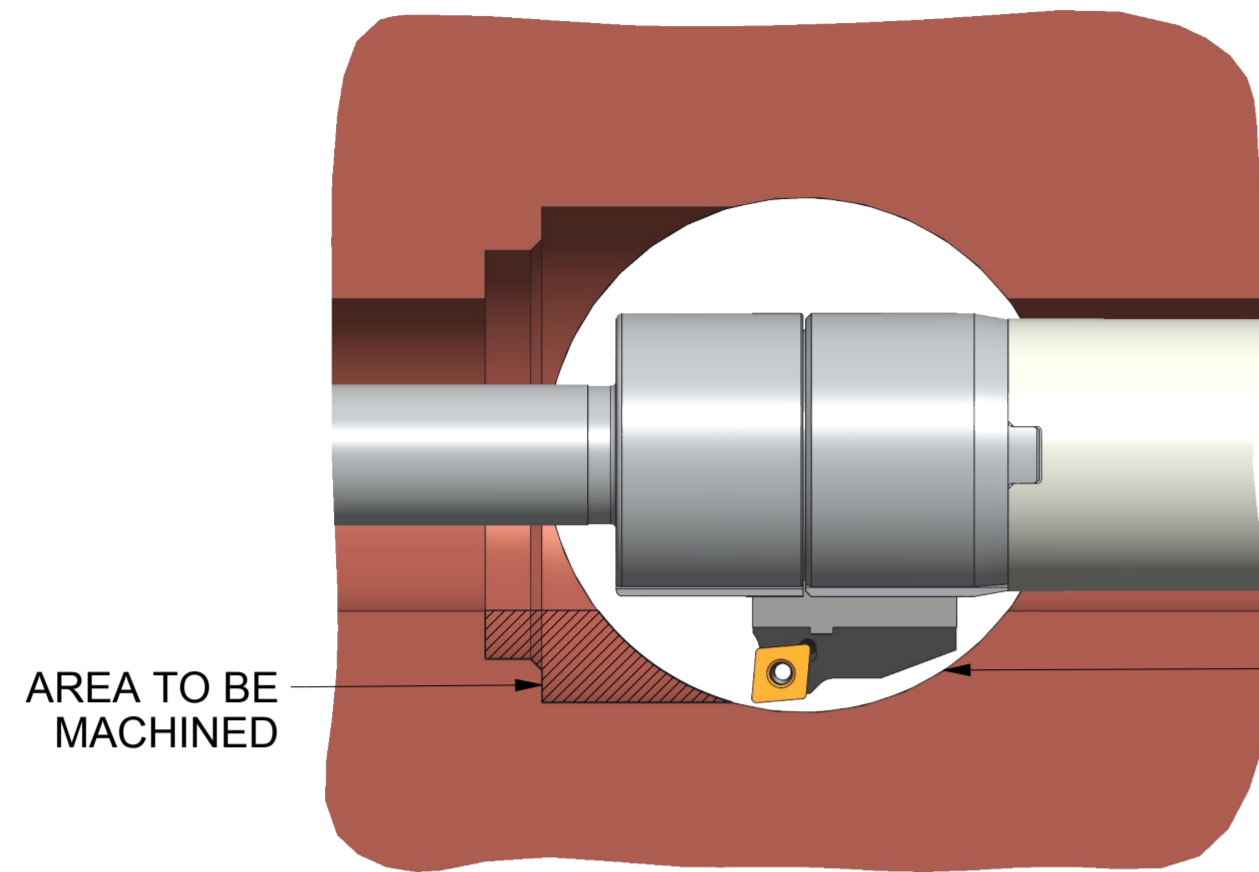
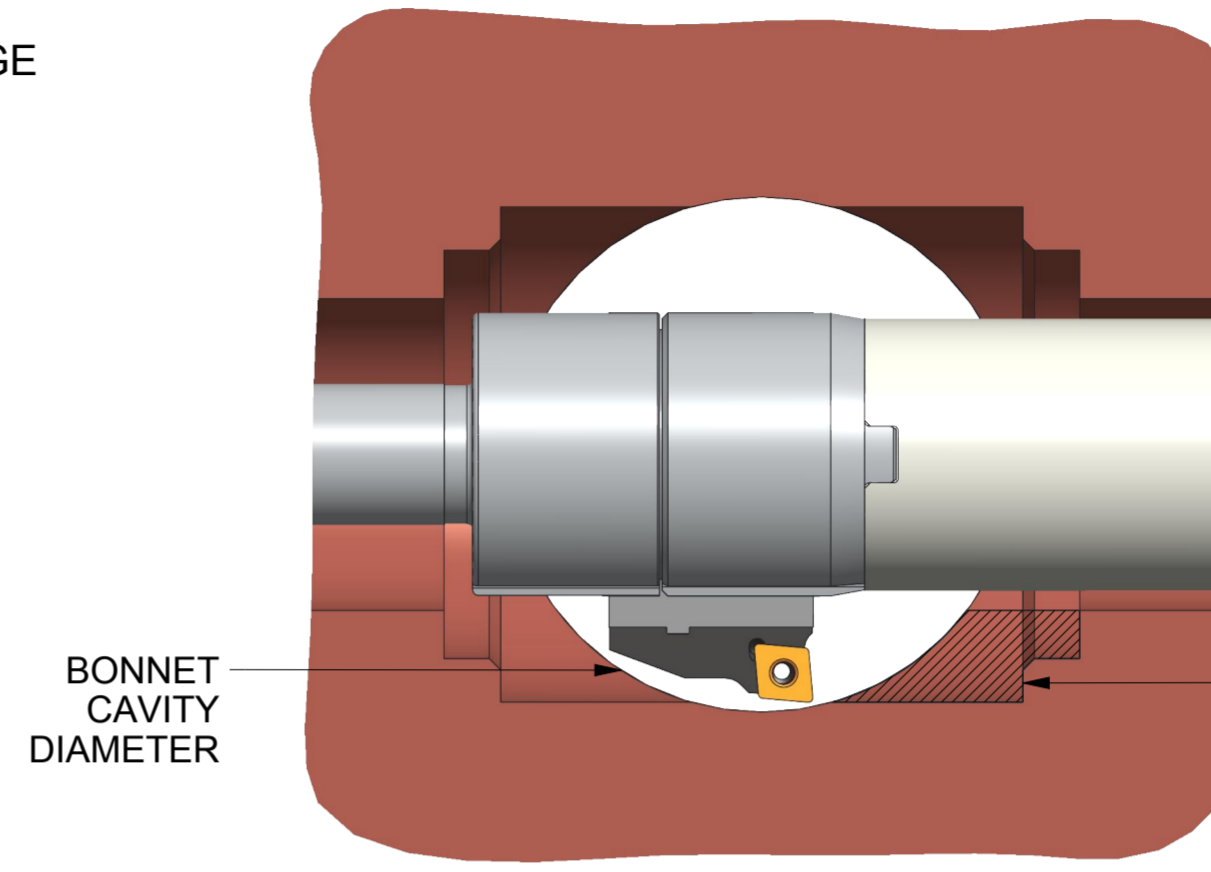


## UTILISING SINGLE INSERT CARTRIDGES FORWARD BORING AND BACKWARD BORING



FORWARD BORING CARTRIDGE

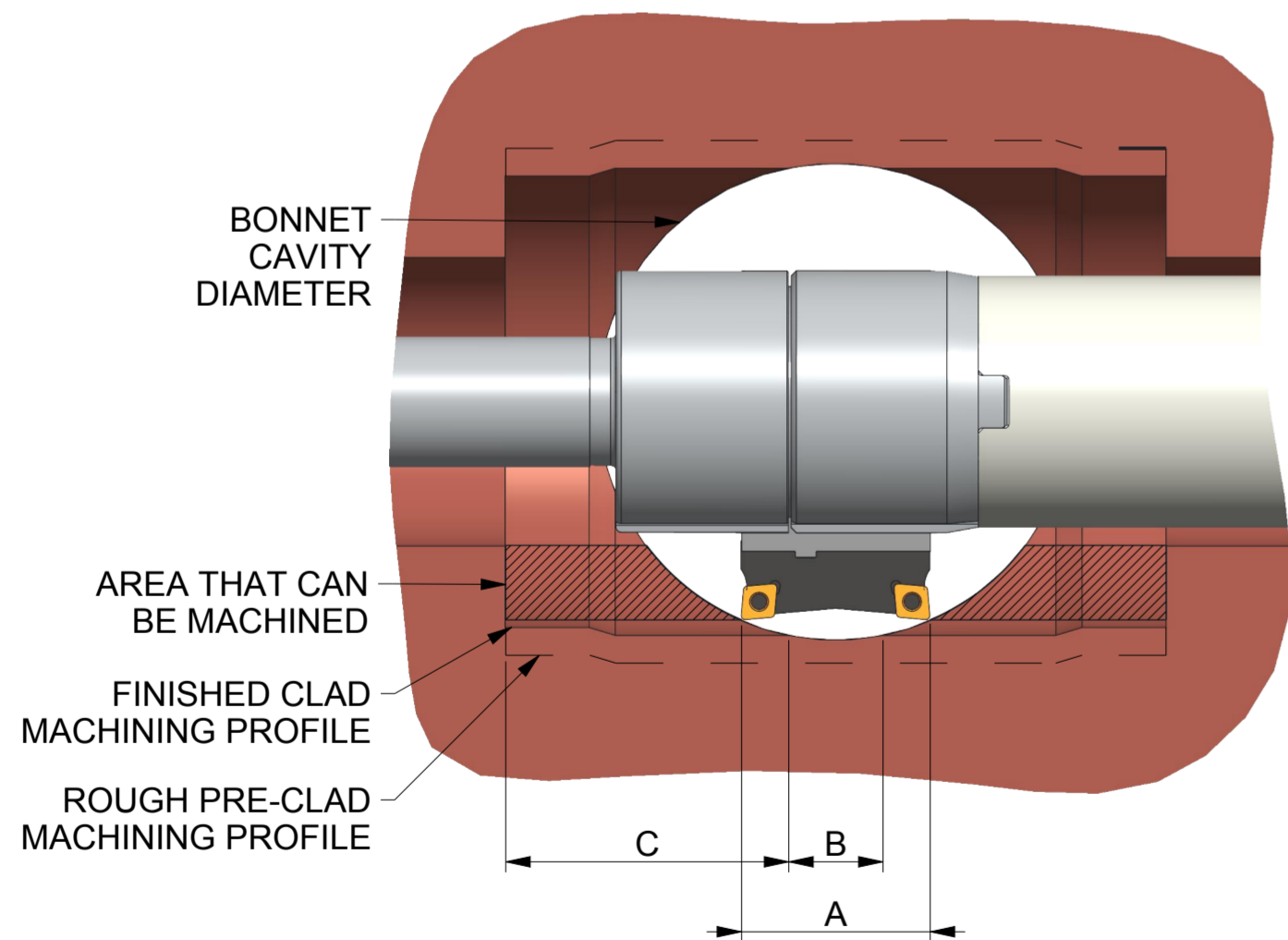
OP1 ROUGH MACHINE  
OP2 SEMI-FINISH MACHINE  
OP3 FINISH MACHINE



BACKWARD BORING CARTRIDGE

OP4 ROUGH MACHINE  
OP5 SEMI-FINISH MACHINE  
OP6 FINISH MACHINE

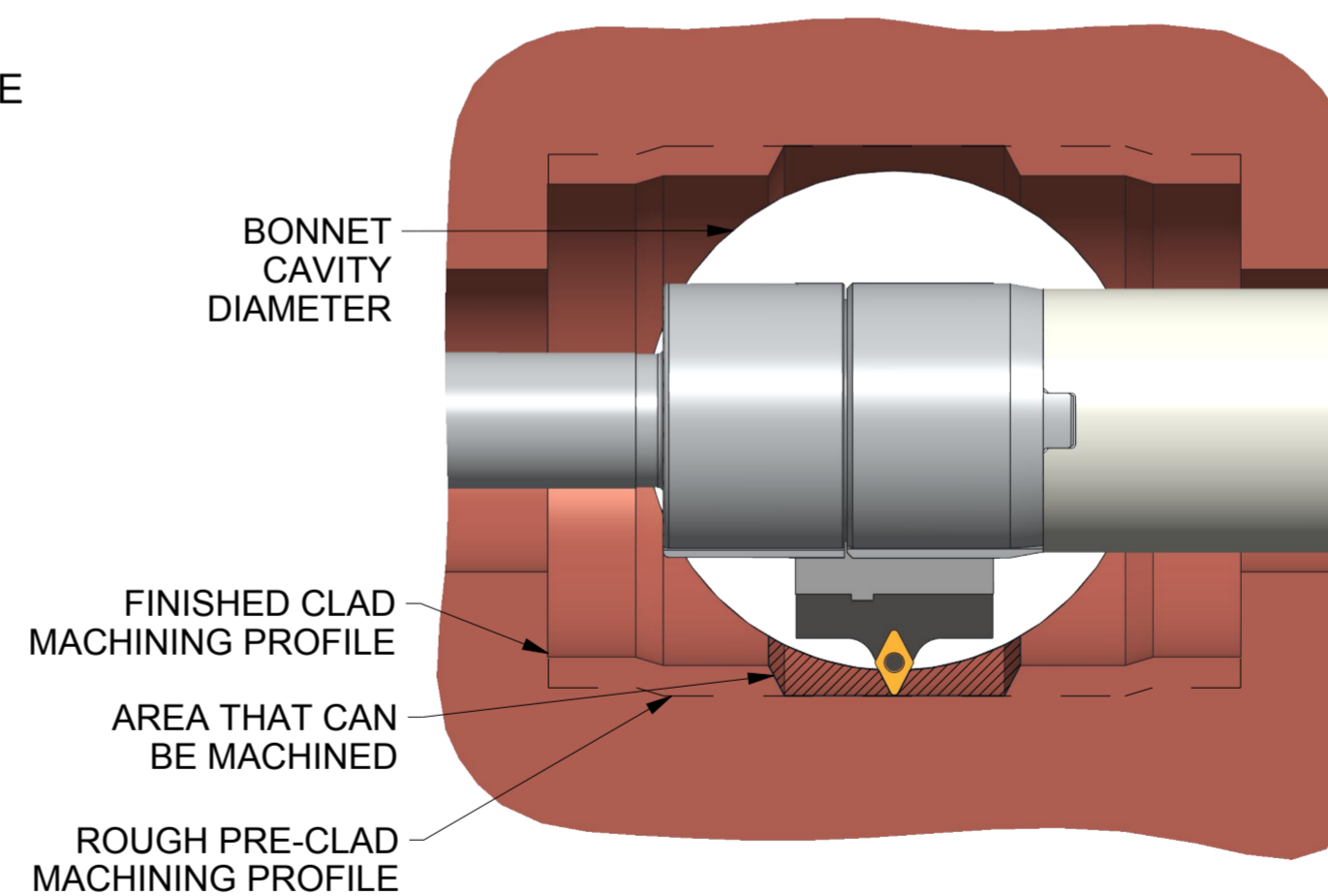
## DOUBLE AND NEUTRAL INSERT CARTRIDGE USE



DOUBLE INSERT CARTRIDGE

IN THIS INSTANCE THE CARTRIDGE CANNOT MACHINE THE PRE-CLAD & FINISHED BORE POSITIONS AS THERE IS NOT ENOUGH SPACE IN THE BONNET CAVITY DUE TO DIM (A) BEING GREATER THAN DIM (B)

TO EFFECTIVELY USE A DOUBLE INSERT CARTRIDGE DIM (A) MUST BE GREATER THAN DIM (C) TO PREVENT THE NON CUTTING TIP FROM TRAILING



NEUTRAL INSERT CARTRIDGE

UTILISED TO OPEN UP DIM (A) TO ALLOW ACCESS FOR MACHINING USING A SINGLE INSERT CARTRIDGE SET UP OR A DOUBLE INSERT CARTRIDGE SET UP

## SEAT POCKET MACHINING



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