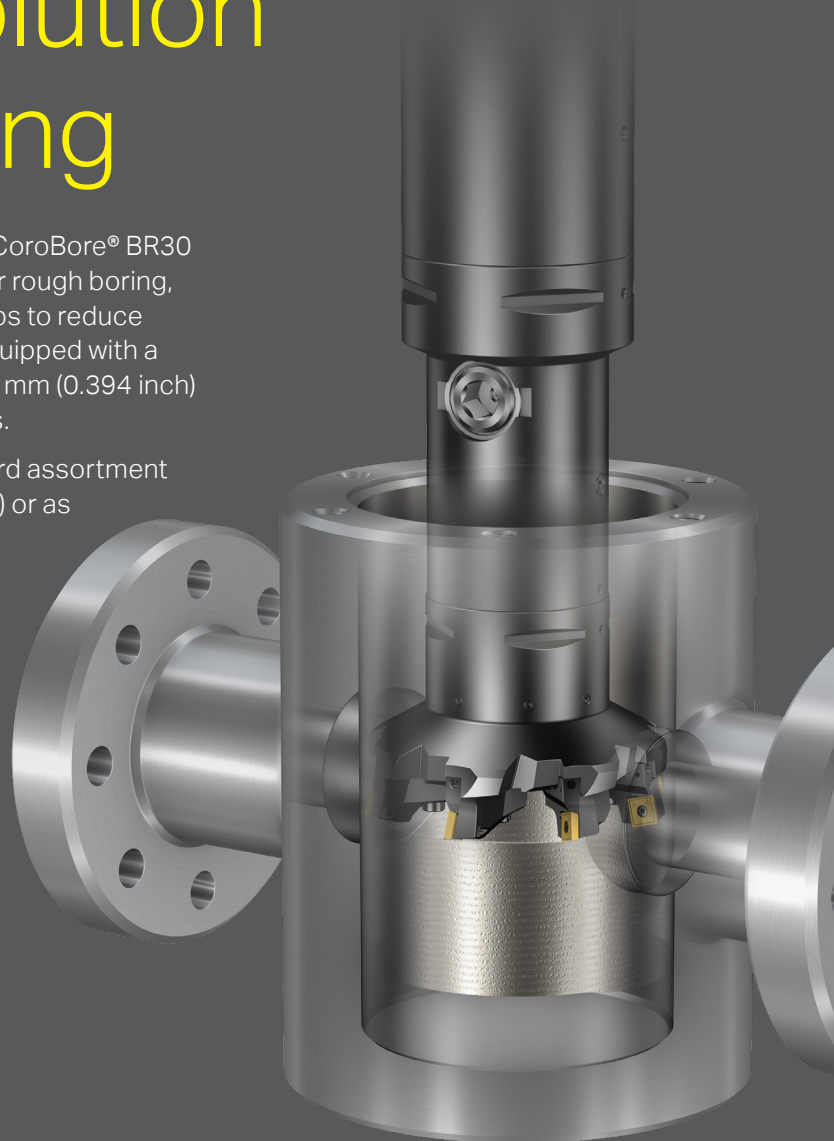


# Multi-edge solution for cavity boring

When machining deep cavities with long overhangs, CoroBore® BR30 is an excellent choice. This is a multi-edge solution for rough boring, with an optimized number of cutting edges which helps to reduce cutting forces in deep cavities. CoroBore® BR30 is equipped with a cartridge solution with diameter adjustability up to 10 mm (0.394 inch) that further helps to optimize your machining process.

This solution is available in Sandvik Coromant standard assortment and can be ordered as a complete tool assembly (kits) or as separate components (adaptors and slides).

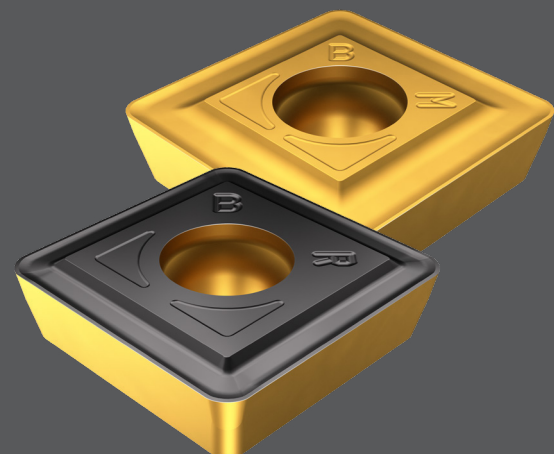


## Features and benefits

- Designed with a differential pitch to reduce vibrations
- Multi-edge solution promotes a higher metal removal rate
- Entering angles reduce chip thickness, improving cutting edge action
- Reduced machining time
- Increased process security

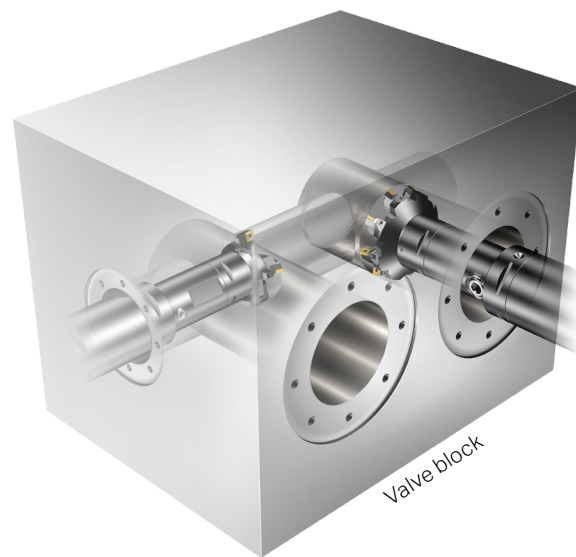
## CoroBore® 111

Inserts designed for rough boring with material-optimized geometries and grades, offering excellent chip-breaking capabilities, improved wear resistance and increased tool life.



## Application

- A multi-edge rough boring solution for all industry segments, but optimized for cavities and flow bores within the oil and gas industry
- Typical components: Valve blocks and valve bodies
- Semi-roughing operations



## Customer case

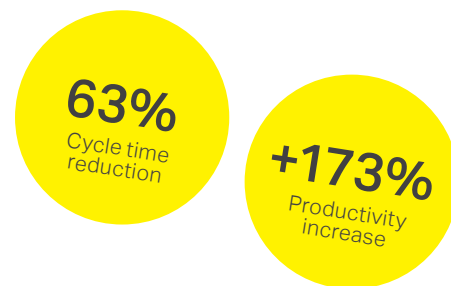
**Component:** 4" gate valve

**Material:** Full clad Inconel 625

**Operation:** Rough boring

**Machine:** Doosan NHM 8000

**Coolant:** Emulsion, through and external coolant supply



	Twin-edge rough boring tool	CoroBore® BR30 – cavity boring solution
Insert	Competitor insert	SPMT 1210-BM 1145
$z_n$	2	8
$n$ rpm (rev/min)	60	32
$v_c$ m/min (ft/min)	27.5 (90)	14.7–15 (48–49)
$v_f$ mm/min (in/min)	4.5 (0.177)	26 (1.024) to depth of 250 mm (9.842 inch) 26 (0.787) to depth of 360 mm (14.173 inch)
$f_z$ mm/z (in/z)	0.05 (0.002)	0.1 (0.004)
$a_e$ mm (inch)	Uneven surface, depends on the weld, minimum 3 mm (0.118 inch) per side to bore	
Number of passes	2	2
<b>Tool life</b>	<b>18 insert edges/cavity</b>	<b>16 insert edges/cavity</b>
<b>Machining time</b>	<b>78 minutes</b>	<b>16 minutes</b>

Head office:  
 AB Sandvik Coromant  
 SE-811 81 Sandviken, Sweden  
 E-mail: [info.coromant@sandvik.com](mailto:info.coromant@sandvik.com)  
[www.sandvik.coromant.com](http://www.sandvik.coromant.com)

