



Screw Lock 7° & 11° Positive Insert Boring Bars

**S-SVQC
R/L Boring Bar**
Style Q - Negative 17.5°
End Cutting Edge Angle
for 7° positive 35° diamond
VC_T inserts

RAKE 0°

Right Hand Shown, Left Hand Opposite

Part No. 733101-		Min. Bore						VC_T	Insert	Torx	
Inch Description	R.H.	L.H.	B	C	D	E	F	Gage Insert	Torx Screw	Key	
S10R-SVQCR/L-2	55814	55815	0.85	8.0	0.625	1.000	0.500	8°	221	TS-25.45-6M2	T-8
S12S-SVQCR/L-2	55816	55817	0.98	10.0	0.750	1.250	0.562	7°			
S16T-SVQCR/L-3	55818	55819	1.30	12.0	1.000	1.500	0.750	6°	332	TS-4.7-10M1	T-15

For inserts see PAGES 16-33. For spare parts see PAGES 108-109.

**S-SVUC
R/L Boring Bar**
Style U - Negative 3°
End Cutting Edge Angle
for 7° positive 35° diamond
VC_T inserts

RAKE 0°

Right Hand Shown, Left Hand Opposite

Part No. 733101-		Min. Bore						VC_T	Insert	Torx	
Inch Description	R.H.	L.H.	B	C	D	E	F	Gage Insert	Torx Screw	Key	
S12S-SVUCR/L-2	55800	55801	1.125	10.0	0.75	1.250	0.625	6°	221	TS-25.45-6M2	T-8
S16T-SVUCR/L-2	55804	55805	1.300	12.0	1.00	1.500	0.750	6°			
S16T-SVUCR/L-3	55808	55809	1.625	12.0	1.00	1.500	0.750	6°			
S20U-SVUCR/L-3	55812	55813	1.625	14.0	1.25	2.000	1.000	6°	332	TS-4.7-10M1	T-15

For inserts see PAGES 16-33. For spare parts see PAGES 108-109.

**S-SVXC
R/L Boring Bar**
Style X - Negative 5° Back
Boring Cutting Edge Angle
for 7° positive 35° diamond
VC_T inserts

RAKE 0°

Right Hand Shown, Left Hand Opposite

Part No. 733101-		Min. Bore						VC_T	Insert	Torx	
Inch Description	R.H.	L.H.	B	C	D	E	F	Gage Insert	Torx Screw	Key	
S12S-SVXCR/L-2	55822	55823	1.125	10.0	0.75	1.250	0.625	6°	221	TS-25.45-6M2	T-8
S16T-SVXCR/L-2	55826	55827	1.500	12.0	1.00	1.500	0.750	6°			
S16T-SVXCR/L-3	55830	55831	2.000	12.0	1.00	1.500	0.750	6°			
S20U-SVXCR/L-3	55834	55835	2.250	14.0	1.25	1.500	1.000	6°	332	TS-4.7-10M1	T-15

For inserts see PAGES 16-33. For spare parts see PAGES 108-109.

**S-SWUC
R/L Boring Bar**
Style U - Negative 3°
End Cutting Edge Angle
for 7° positive 80° trigon
WC_T inserts

RAKE 0°

Right Hand Shown, Left Hand Opposite

Part No. 733101-		Min. Bore						WC_T	Insert	Torx	
Inch Description	R.H.	L.H.	B	C	D	E	F	Gage Insert	Torx Screw	Key	
S06M-SWUCR/L-2	55912	55913	0.500	6.00	0.375	0.625	.250	11°			
S08M-SWUCR/L-2	55916	55917	0.625	6.00	0.500	0.750	.312	9°	21.51	TS-25.45-6M2	T-8
S10R-SWUCR/L-2	55920	55921	0.812	8.00	0.625	1.250	.406	7°			
S08M-SWUCR/L-3	55924	55925	0.625	6.00	0.500	1.250	.312	11°			
S10R-SWUCR/L-3	55928	55929	0.812	8.00	0.625	1.250	.406	7°	32.52	TS-4.7-8M1	T-15
S12S-SWUCR/L-3	55932	55933	1.000	10.0	0.750	1.875	.500	10°	32.52	TS-4.7-10M1	T-15
S16T-SWUCR/L-3	55936	55937	1.250	12.0	1.000	2.500	.625	5°			
S16T-SWUCR/L-4	55940	55941	1.280	12.0	1.000	2.500	.640	5°			
S20U-SWUCR/L-4	55944	55945	1.530	14.0	1.250	2.500	.765	5°	432	TS-5.8-10M1	T-20
S24U-SWUCR/L-4	55948	55949	1.780	14.0	1.500	2.500	.890	5°			

For inserts see PAGES 16-33. For spare parts see PAGES 108-109.