

**New**

## Modular Line

**Turning adaptors and boring bars  
for internal applications of threading and grooving.**



### Advantages

- High accurate turning ML adaptors provide full flexibility and easy adjustment.
- Full repeatability.
- A single boring bar fits to multi ML adaptors.
- Reduces tool inventories - investing in a single boring bar, right and left hand ML adaptors from the same size.
- ML adaptors support all Carmex standard thread turning inserts sizes 16, 22 and 27 mm. Grooving inserts size 16 mm fit the MLR/L 16 - 32 and MLR / L 16 - 40 adaptors.
- ML adaptors are coated with a high abrasive resistant nickel layer to prolong the ML adaptors tool life.

### Applications

- Internal machining
- Deep threads require high overhang with maximum rigidity
- Grooving
- Can be used on a large range of turning or multi-task machines

## High pressure coolant

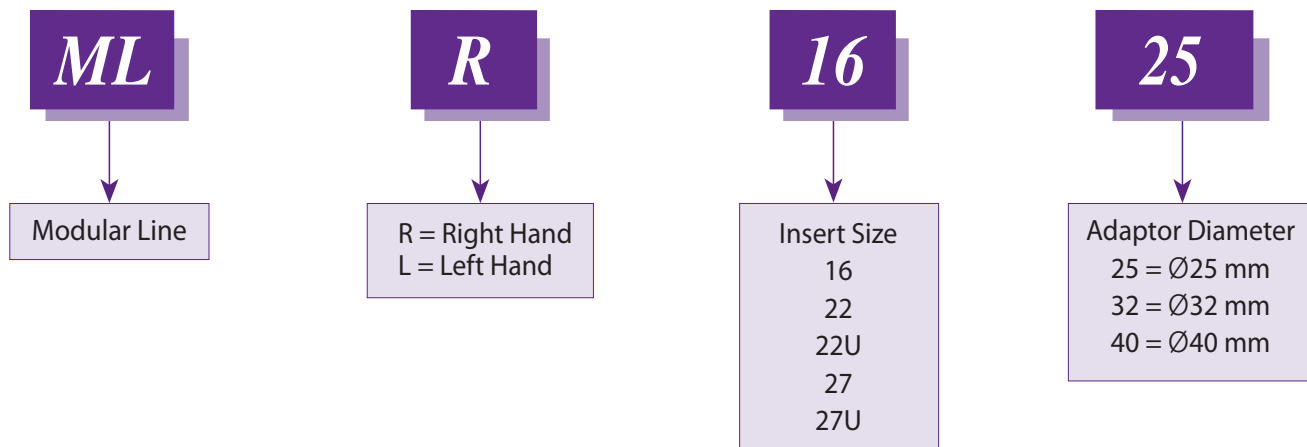
ML boring bars and adaptors are designed with internal coolant allowing high pressure up to 120 Bar.

High pressure coolant reduces the cutting edge temperature, provides a better chip evacuation and improves tool life.

The tools can also be used with normal coolant pressure.

## Product Identification

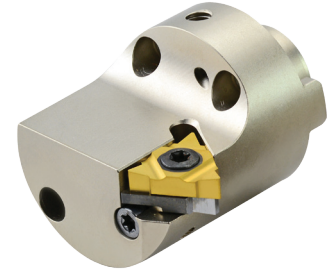
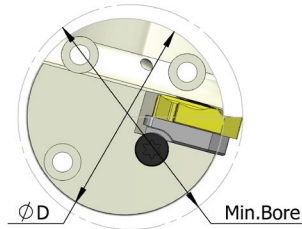
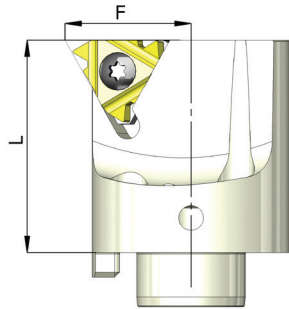
### Ordering Codes: ML Turning adaptors



### Ordering Codes: Boring Bars



## ML Turning Adaptors

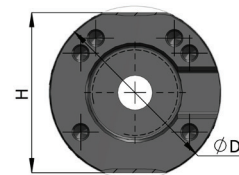
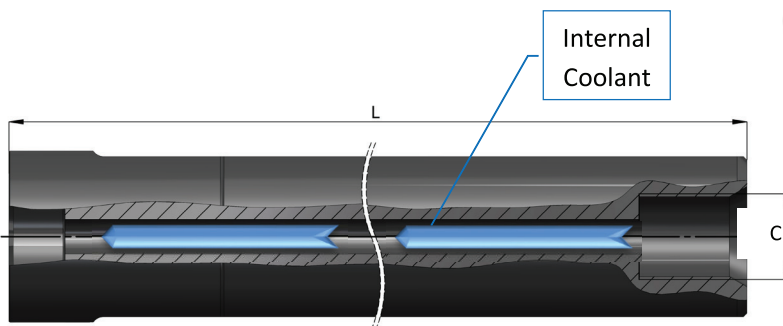


| D  | Ordering Code       |  L | I.C.<br>in | Min<br>Bore<br>Diam. | L  | F    | Insert<br>Screw | Anvil<br>Screw | Torx<br>Key | RH<br>Anvil | LH<br>Anvil |
|----|---------------------|-------------------------------------------------------------------------------------|------------|----------------------|----|------|-----------------|----------------|-------------|-------------|-------------|
| 25 | <b>*MLR 16 - 25</b> | 16                                                                                  | 3/8        | 29                   | 30 | 16.2 | S16P            | -              | K16P        | -           | -           |
| 25 | <b>*MLR 22 - 25</b> | 22                                                                                  | 1/2        | 29                   | 30 | 18.1 | S22P            | -              | K22P        | -           | -           |
| 32 | <b>MLR 16 - 32</b>  | 16                                                                                  | 3/8        | 36                   | 43 | 19.7 | S16P            | A16P           | K16P        | AI16        | AE16        |
| 32 | <b>MLR 22 - 32</b>  | 22                                                                                  | 1/2        | 38                   | 43 | 21.6 | S22P            | A22P           | K22P        | AI22        | AE22        |
| 32 | <b>MLR 22U - 32</b> | 22U                                                                                 | 1/2U       | 38                   | 43 | 24.4 | S22P            | A22P           | K22P        | AI22U       | AE22U       |
| 40 | <b>MLR 16 - 40</b>  | 16                                                                                  | 3/8        | 44                   | 43 | 23.7 | S16P            | A16P           | K16P        | AI16        | AE16        |
| 40 | <b>MLR 22 - 40</b>  | 22                                                                                  | 1/2        | 46                   | 43 | 25.6 | S22P            | A22P           | K22P        | AI22        | AE22        |
| 40 | <b>MLR 22U - 40</b> | 22U                                                                                 | 1/2U       | 46                   | 43 | 28.1 | S22P            | A22P           | K22P        | AI22        | AE22        |
| 40 | <b>MLR 27 - 40</b>  | 27                                                                                  | 5/8        | 48                   | 43 | 26.6 | S27P            | A27P           | K27P        | AI27        | AE27        |
| 40 | <b>MLR 27U - 40</b> | 27U                                                                                 | 5/8U       | 48                   | 43 | 29.4 | S27P            | A27P           | K27P        | AI27U       | AE27U       |

\*Toolholders with no anvil

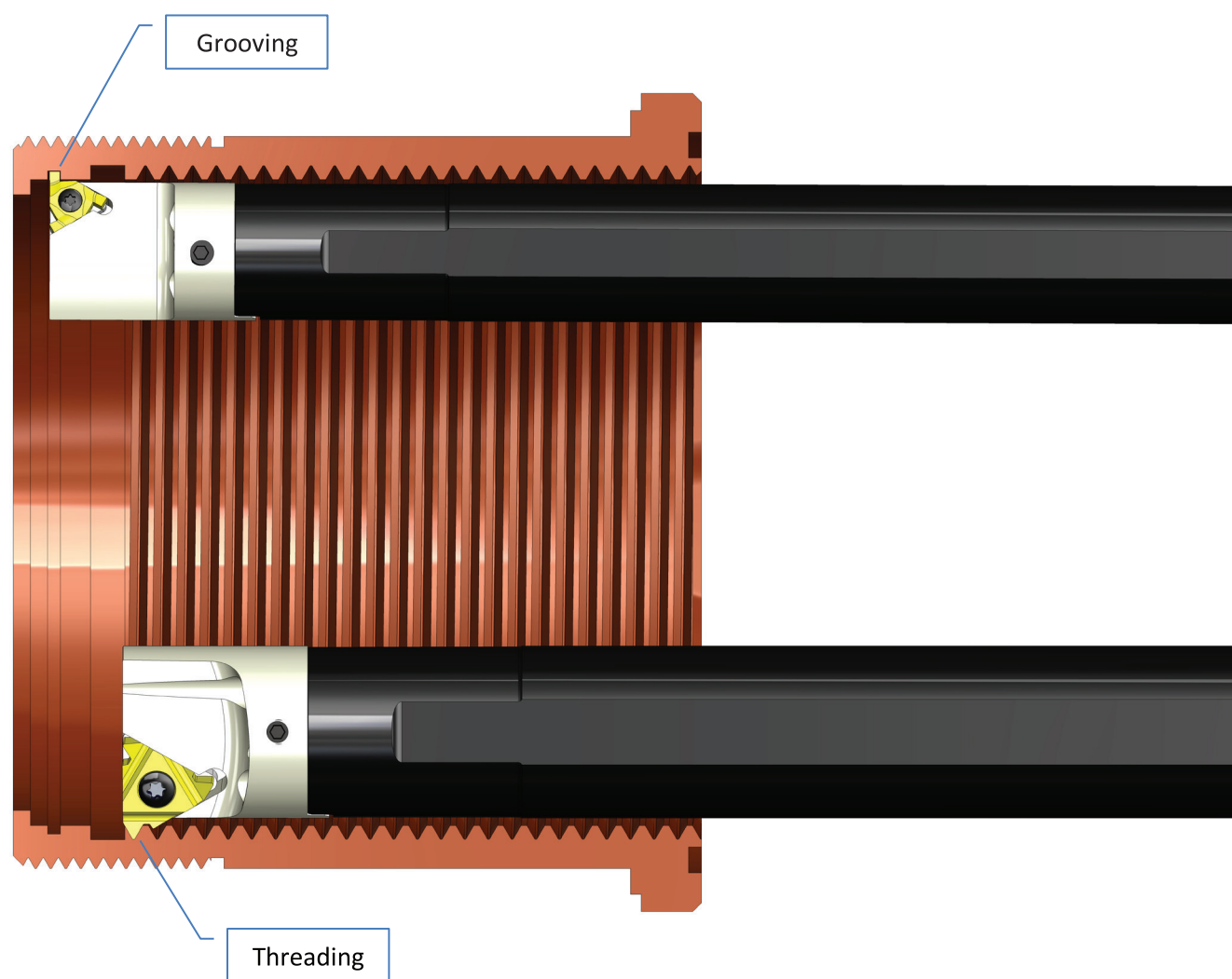
For **LEFT HAND** toolholders specify **MLL** instead of **MLR**

## Boring Bars



| D  | Ordering Code     | L   | H  | C     | Screw      | Key |
|----|-------------------|-----|----|-------|------------|-----|
| 25 | <b>MLS 0025 R</b> | 200 | 23 | G1/4" | S420, S435 | K3  |
| 32 | <b>MLS 0032 S</b> | 250 | 30 | G3/8" | S520, S550 | K4  |
| 40 | <b>MLS 0040 T</b> | 300 | 36 | G1/2" | S520, S550 | K4  |

External ML adaptors (for external threads) are available upon request and can be used on the same MLS boring bars.



- Maximum overhang:  $4 \times D$