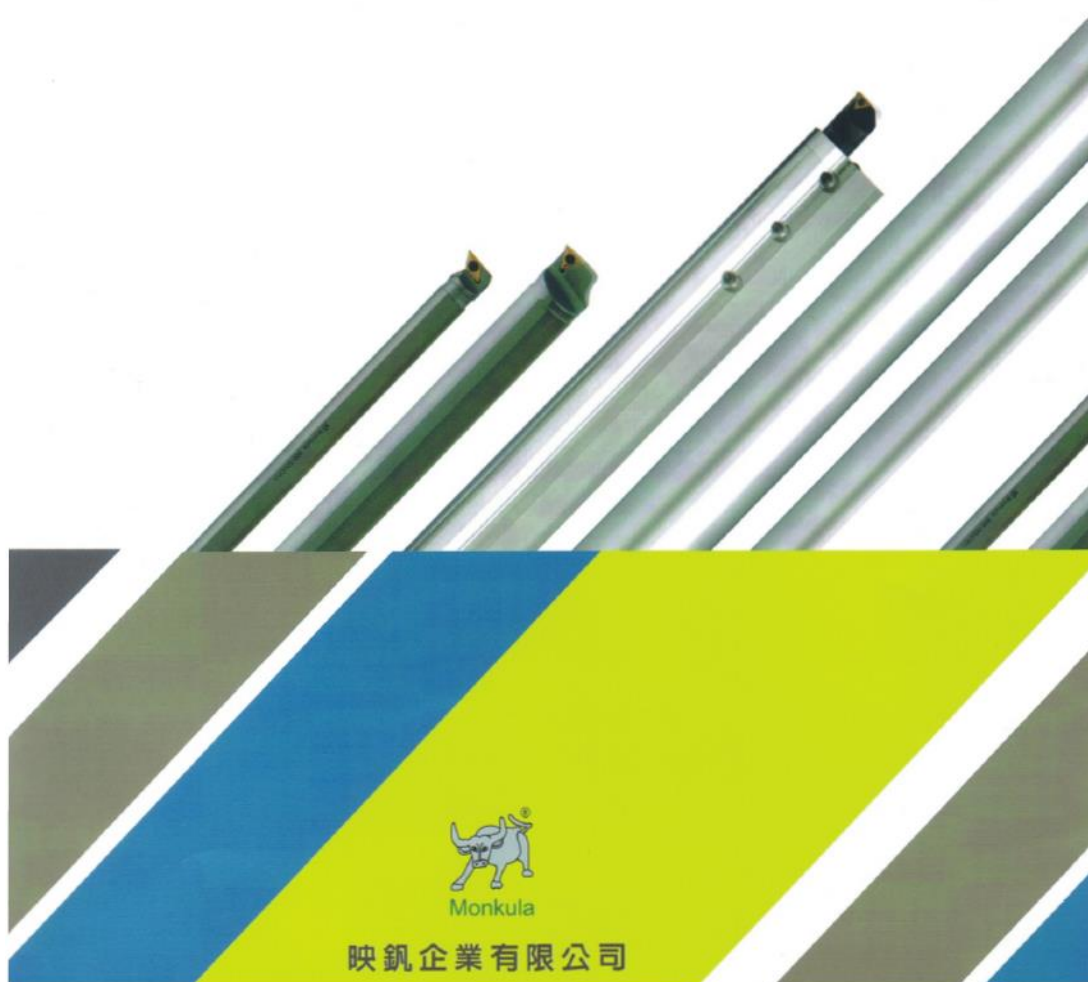




MONKULA ENTERPRISE

Anti Vibration Tooling & Tool Holders
For Turning & Milling



映鈺企業有限公司

Toolrunner Ltd.

SPECIALIST ENGINEER SUPPLIES & MACHINE TOOL MAINTENANCE

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MONKULA ENTERPRISE



Monkula Enterprise was established in 2001. We have extensive experience in the manufacture of large valves, Mould tooling, & complex fabrications.

This experience has led us to develop a range of boring & milling tool holders to eliminate the problems we experienced when machining deep bores & milling with long tool overhangs. This tool development has led us to successful collaborations with many OEM & ODM companies worldwide.

Further extensive research & development has led to our GIANT & COMBINATION boring cutters, Removable type Boring Cutters, & the Half Thread Tooling.

These cutters have patents pending in Taiwan, China, America, Japan, & Germany. We have also passed tests set by the prestigious Precision Machinery Research Development Center (PMC) in Taiwan.

The development of our cutters has overcome the shortcomings of traditional cutters in deep hole boring & applications that require long tool overhangs. We have reduced & in some case eliminated tool vibration, improve hole quality, reduced defects & the need for costly component reworking, increased tool life, & reduced tooling costs.

Our tools also give a reduced initial outlay cost for tooling when compared to brand leading products from major Japanese American & European manufactures.

We are continuing to develop further enhancements to our exciting range of products & would invite you to visit our website:

www.monkula.com.tw

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Removable Head Boring Bar System

The Monkula Removable Head boring bar system is one of the most flexible & user friendly boring bar system available in today's market.

By matching the unique properties of the Monkula patented anti-vibration boring bars, with Monkula removable cutting heads, customers have a truly flexible solution to their many internal machining applications.

Monkula Anti-vibration boring bars are available from 16mm diameter to 250mm diameter, & in anti-vibration ratios from 6 x D to 14 x D.

All bars are manufactured with Monkula's patented anti-vibration damping system & are produced in their own manufacturing plant.

Removable heads are manufactured from size CH-1 (16mm) to CH-5 (40mm), & fit directly onto the corresponding bars up to 40mm diameter.

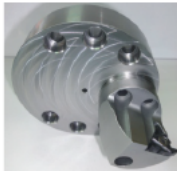
Bars of 50mm, 60mm, & 80mm are adapted to use the CH-5 (40mm) heads. Bars of 100mm & above can also use the CH-5 head with an additional adaptor or can be produced with heads directly matching the bars diameter, this depends on customer requirements & the application involved.

Larger diameter bars also have the option to use an adaptor that can accommodate square shank tool holders, again depending on customer requirements & application.



50mm bar with CH-5 head
using CNMG 1204 insert

80mm bar with CH-5 head
using TCMT 1604 insert



100mm bar adaptor with CH-5 head
using IC16 threading insert

100mm bar adaptor with CH-5 head
using DCMT 1604 insert



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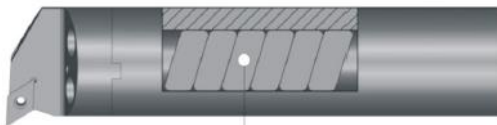
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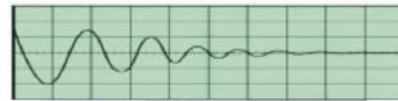
Removable Head Boring Bar System

Comparison of Vibration Amplitude

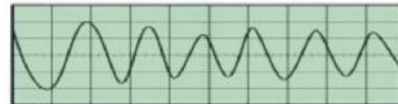
Structure of Dampening System



Patented Dampening Material



Monkula Patented Damped Bar (7 x D)



Non Damped Bar (7 x D)

Removable Head Assembly



Check head attachment area on bar



Remove screws & align cutting head to bar



Check head alignment is correct, insert screws & tighten

Machine Mounting & Use

Monkula recommend to obtain best results the following should be observed when mounting your bar on the machine.

- 1) Minimum bar mounting area to be 3 x D of bar, 4 x D is preferable
- 2) Bars should be mounted in split sleeves where possible, refer to P17
- 3) Apply correct cutting data for the insert selected & material being machined

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Removable Head Boring Bars

- Interchangeable Head System
- High efficiency Anti- Vibration ratio of 6 –14 times diameter
- Internal coolant supply direct to boring head
- Bars made from High Strength Alloy steel to Hardened 42 HRC with addition of internal dampening device
- Interchangeable heads can be made to take most ISO turning, threading, & grooving inserts.

Details of a small selection of replaceable heads on pages 6 & 7. Full range on request.

Removable Head Boring Bars				
Part No	Head Mount Size	Diameter mm	Length mm	Anti-Vibration Ratio
M6D-20-220	CH2	20	220	6 x D
M6D-25-250	CH3	25	250	
M6D-32-300	CH4	32	300	
M6D-40-350	CH5	40	350	
M6D-50-400-40	CH5	50	400	
M6D-60-450-40	CH5	60	450	
M8D-20-260	CH2	20	260	8 x D
M8D-25-300	CH3	25	300	
M8D-32-350	CH4	32	350	
M8D-40-420	CH5	40	420	
M8D-50-510-40	CH5	50	510	
M8D-60-620-40	CH5	60	620	
M10D-20-300	CH2	20	300	10 x D
M10D-25-350	CH3	25	350	
M10D-32-420	CH4	32	420	
M10D-40-530	CH5	40	530	
M10D-50-668-40	CH5	50	668	
M10D-60-808-40	CH5	60	808	

Taiwan patent: M385422

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TSC Anti-Vibration Boring Bars

- Anti-vibration ratio of 6 to 16 x Diameter
- Bars made from Dense alloy steel & Wolfram
- Bars have additional internal dampening device



TSC Anti-Vibration Boring Bars				
Part No	Bar Diameter mm	Bar Length mm	Anti-Vibration Ratio	Fixed Pocket Type
TSC-08-125	8	125	6 x D	For screw-on Indexable Inserts CCMT DCMT
TSC-10-150	10	150		
TSC-12-150	12	150		
TSC-14-150	14	150		
TSC-16-180	16	180		
TSC-18-180	18	180		
TSC-20-200	20	200		
TSC-25-250	25	250		
TSC-10-180	10	180	8 x D	TCMT VCMT
TSC-12-180	12	180		
TSC-14-200	14	200		
TSC-16-200	16	200		
TSC-18-200	18	200		
TSC-16-250	16	250	10	

TSC Anti-Vibration Boring Bars				
Part No	Bar Diameter mm	Bar Length mm	Anti-Vibration Ratio	Cutting Head
TSC-20-300	20	300	10 x D	CH2
TSC-25-350	25	350		CH3
TSC-32-420	32	420		CH4
TSC-40-520	40	520		CH5
TSC-20-360	20	360	12 x D	CH2
TSC-25-400	25	400		CH3
TSC-32-480	32	480		CH4
TSC-25-470	25	470	14 x D	CH3
TSC-32-570	32	570		CH4
TSC-32-640	32	640	16 x D	CH4

- A small selection of heads can be found on pages 6 & 7.
Heads are available for most common ISO indexable turning, threading, & grooving inserts. Please ask for details.

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Giant Combination Head Boring Bars

M10D-100-1500

(shown with external cutting head)



Square Shank Head
For internal & external machining



Replaceable Head CH-5 (40mm)
For internal machining

- Anti-vibration ratio of up to 10 x Diameter
- Bars made from Dense alloy steel & have internal dampening device.
- Bars can be used for both External & Internal machining using different head types.
- Heads use standard CH-5 (40mm) replaceable heads, or standard square shank holders.
- Special bars can be made to suit customer requirements.

Giant Combination Removable Head Boring Bars						
Part No	Diameter mm	Length mm	Anti-Vibration Ratio	Replaceable Head Mount Size	General Cutting Head Mount Size	Removable Cutting Head
M10D-100-1500-40	100	1500	10 x D	100-CH5-40	100-GCH	CH5
M10D-120-1900-40	120	1900		120-CH5-40	120-GCH	
M10D-150-24000-40	150	2400		150-CH5-40	150-GCH	
M10D-180-2800-40	180	2800		180-CH5-40	180-GCH	
M10D-200-3200-40	200	3200		200-CH5-40	200-GCH	
M10D-250-4000-40	250	4000		250-CH5-40	250-GCH	

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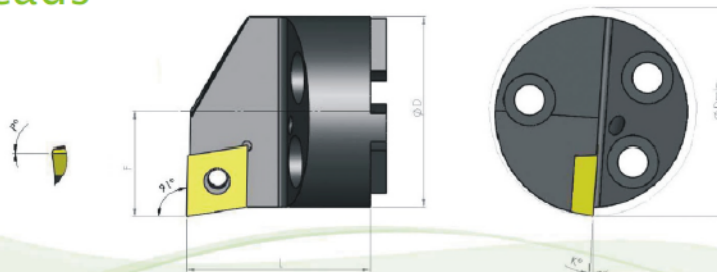
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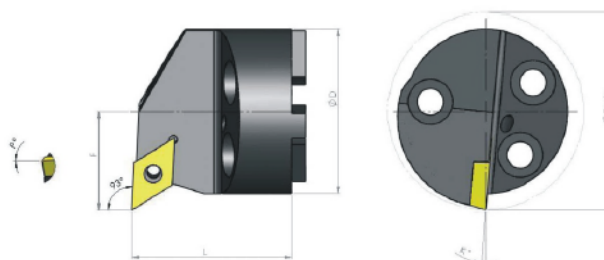
Anti-Vibration Boring Bar Replaceable Heads

● S-SCFCR-91°



Removable Head for Boring Bars								
Part No	Head Mount Size	D	F	L	K	P	D (min)	Insert
CH2-S20R-SCFCR/L 09	CH2	20	12	25	4	0	24	CCMT 09T3
CH4-S32R-SCFCR/L 09	CH4	32	18	33			36	
CH5-S40R-SCFCR/L 09	CH5	40	22	34			44	
CH5-S40R-SCFCR/L 09	CH5	40	27	36			54	
CH4-S32R-SCFCR/L 12	CH4	32	22	35	6	0	44	CCMT 1204
CH5-S40R-SCFCR/L 12	CH5	40	22	37	6		44	
CH5-S40R-SCFCR/L 12	CH5	40	27	39	4		54	

● S-SDUCR-93°



Removable Head for Boring Bars								
Part No	Head Mount Size	D	F	L	K	P	D (min)	Insert
CH2-S20R-SDUCR/L07	CH2	20	13	25	5	0	26	DCMT 0702
CH3-S25S-SDUCR/L07	CH3	25	17	26	5		34	
CH3-S25R-SDUCR/L11	CH3	25	17	30	5	0	34	DCMT 11T3
CH4-S32R-SDUCR/L11	CH4	32	22	34	4		44	
CH5-S40R-SDUCR/L11	CH5	40	24	37.5	2		48	

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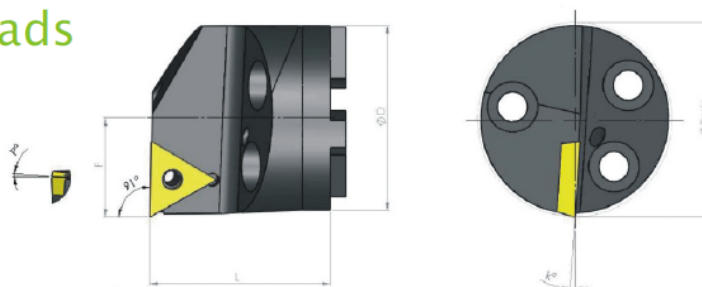
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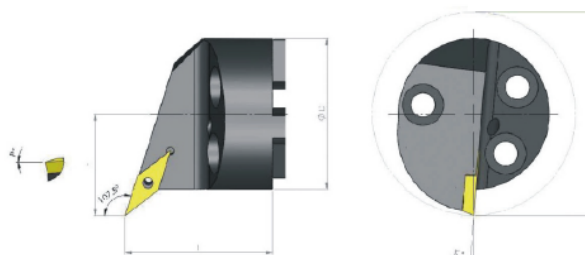
Anti-Vibration Boring Bar Replaceable Heads

● S-STFCR-91°



Removable Head for Boring Bars									
Part No	Head Mount Size	D	F	L	K	P	D (min)	Insert	
CH2-S20R-STFCR/L 11	CH2	20	15	32	6	5	26	TCMT 1102	
CH3-S25R-STFCR/L 11	CH3	25	17.5	36			34		
CH3-S25S-STFCR/L16	CH3	25	15	31	6	0	30	TCMT 16T3	
CH3-S25S-STFCR/L16	CH3	25	17	33			34		
CH4-S32S-STFCR/L16	CH4	32	17	35	4		34		
CH4-S32S-STFCR/L16	CH4	32	17.5	36			35		
CH5-S40S-STFCR/L16	CH5	40	27	38	3		54		

● S-SVQCR-107.5°



Removable Head for Boring Bars								
Part No	Head Mount Size	D	F	L	K	P	D (min)	Insert
CH2-S20R-SVQCR/L11	CH2	20	15	28	6	0	30	VCMT1103
CH2-S20R-SVQCR/L 16	CH2	20	19	35	8	0	38	VCMT1604
CH3-S25R-SVQCR/L 16	CH3	25	20.5	35	4		41	
CH4-S32R-SVQCR/L 16	CH4	32	22.5	40	8		45	
CH5-S40R-SVQCR/L 16	CH5	40	27	43	4		54	

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Combination Boring Bar Holder up to 4xD



- Anti-vibration ratio of up to 4 times diameter
- Holder can be used with standard boring bars, threading bars, grooving tools etc, reducing inventory & tooling costs.
- Reduces need for specialist anti-vibration tooling
- Coolant flow is available directly to the cutting edge, increasing tool life & surface finish properties.
- Bars made from Dense Alloy Steel hardened to 40 Rc

Combination Anti-Vibration Holders x 4D				
Part No	Holder Diameter mm	Tool Diameter mm	Length mm	Anti-Vibration Ratio
MT32-S12H	32	12	160	4 x Dia
MT32-S16H	32	16	160	
MT40-S12H	40	12	180	
MT40-S16H	40	16	180	
MT40-S20H	40	20	180	
MT50-S16H	50	16	200	
MT50-S20H	50	20	200	
MT50-S25H	50	25	200	
MT60-S20H	60	20	200	
MT60-S25H	60	25	200	
MT60-S32H	60	32	200	

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Combination Boring Bar Holder x7D

● MT80-S32L Φ 80/680mm



● MT40-S16L Φ 40/320mm

- Anti-vibration ratio of up to 7 times diameter
- Holder can be used with standard boring bars, threading bars, grooving tools etc, reducing inventory & tooling costs.
- Reduces need for specialist anti-vibration tooling
- Coolant flow is available directly to the cutting edge, increasing tool life & surface finish properties.
- Bars made from Dense Alloy Steel hardened to 40 Rc

Combination Anti-Vibration Holders x 7D				
Part No	Holder Diameter mm	Tool Diameter mm	Length mm	Anti-Vibration Ratio
MT20-S08L	20	8	200	7 x Dia
MT25-S10L	25	10	200	
MT32-S12L	32	12	280	
MT40-S16L	40	16	320	
MT50-S20L	50	20	400	
MT60-S25L	60	25	520	
MT63-S25L	63	25	520	
MT80-S32L	80	32	680	

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Giant Combination Boring Bar Holder

● MT120-S40L

Φ120/1900mm

● MT50-S20L

Φ50/400mm

● MT100-S32L

Φ100/1500mm

● MT180-S50L

Φ180/2000mm

- Anti-vibration ratio of 10 times diameter & above
- Holder can be used with standard boring bars, threading bars, grooving tools etc, reducing inventory & tooling costs.
- Reduces need for specialist anti-vibration tooling
- Coolant flow is available directly to the cutting edge, increasing tool life & surface finish properties.
- Bars made from Dense Alloy Steel hardened to 40 Rc

Giant Combination Anti-Vibration Holders x 10D				
Part No	Holder Diameter mm	Tool Diameter mm	Length mm	Anti-Vibration Ratio
MT100-S32L	100	32	1500	10 x Dia
MT120-S40L	120	40	1900	
MT180-S50L	180	50	2000	

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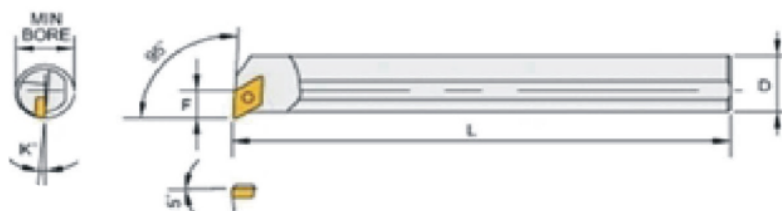
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Boring Bars with Damped Anti-Vibration

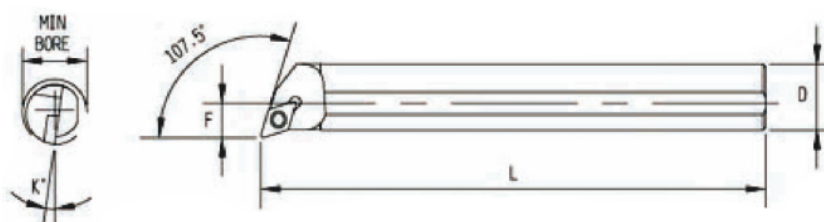
● SDUCR 93



- Anti-vibration ratio: 6 x D & above
- Bars have though coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars								
Part No	Insert	D	F	L	K	D (min)	Screw	Torx Key
B10M-SDUCR 07	DCMT 0702	10	7	150	10	13	CS25060	FT-7
B12Q-SDUCR 07		12	9	180	8	16		
B16R-SDUCR 07		16	11	200	6	20		

● SDQCR 107.5



- Anti-vibration ratio: 6 x D & above
- Bars have though coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars								
Part No	Insert	D	F	L	K	D (min)	Screw	Torx Key
B10M-SDQCR 07	DCMT 0702	10	7	150	10	13	CS25060	FT-7
B12Q-SDQCR 07		12	9	180	8	16		
B16R-SDQCR 07		16	11	200	6	20		

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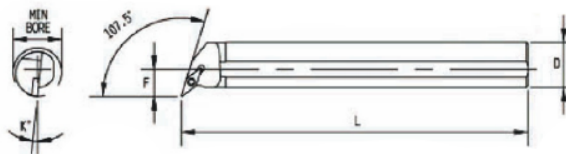
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Boring Bars with Damped Anti-Vibration

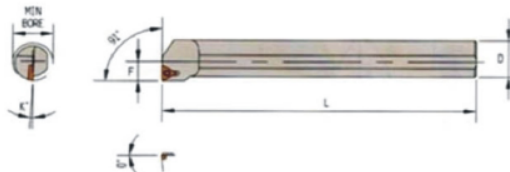
● SVQCR 107.5



- Anti-vibration ratio: 6 x D & above
- Bars have though coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars								
Part No	Insert	D	F	L	K	D (min)	Screw	Torx Key
B16R-SVQCR 11	VCMT 1103	16	13	200	7	22	CS25060	FT-7
B20R-SVQCR 11		20	15	200	6	27		
B20R-SVQCR 16	VCMT 1604	20	19	200	8	27	CS35090	FT-15
B25S-SVQCR 16		25	20.5	250	4	33		
B32T-SVQCR 16		32	22.5	300	8	41	CS35115	FT-15
B40U-SVQCR 16		40	27	350	6	50		

● STFCR 91



- Anti-vibration ratio: 6 x D & above
- Bars have though coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars								
Part No	Insert	D	F	L	K	D (Min)	Screw	Torx Key
B08M-STFCR-09	TCMT 0902	8	6	150	12	12	CS22050	FT-7
B10M-STFCR-09		10	7	150	15	14		
B12M-STFCR-09		12	9	150	10	16		
B10M-STFCR-11	TCMT 1102	10	7	150	15	14	CS25060	FT-7
B12M-STFCR-11		12	9	150	10	16		
B12M-STFCR-11-14		12	7	150	10	14		
B16R-STFCR-11		16	11	200	6	20		
B16R-STFCR-11-18		16	9	200	8	18		
B20R-STFCR-11	TCMT 16T3	20	13	200	3	25	CS35090	FT-15
B20R-STFCR-16		20	11.5	200	8	25		
B25S-STFCR-16		25	17	250	6	32		
B32T-STFCR-16		32	17.5	300	4	39		

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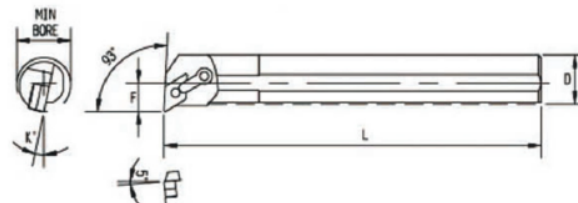
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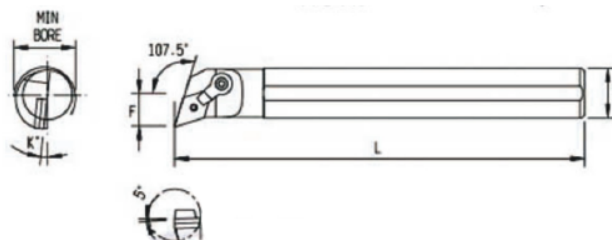
Boring Bars with Damped Anti-Vibration

● MDUNR 93



- Anti-vibration ratio: 5 x D & above
- Bars have though coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars												
Part No	Insert	D	F	L	K	D (min)	Shim	Screw	Clamp	Clamp Screw	Wrench	
B25Q-MDUNR-1504	DNMG 1504	25	17	180	12	32	SMD-433	LCS-617	CP50-24	CS7-6024	LW030	
B32R-MDUNR-1504		32	22	200	10	40				CS7-6024		
B40S-MDUNR-1504		40	27	250	10	50				CS7-6030		
B50T-MDUNR-1504		50	35	300	10	63				CS7-6030		
B32R-MDUNR-1506	DNMG 1506	32	22	200	17	40		LCS-619		CS7-6024		
B40S-MDUNR-1506		40	27	250	15	50				CS7-6030		
B50T-MDUNR-1506		50	35	300	15	63				CS7-6030		
B50T-MDUNR-1506		50	35	300	15	63				CS7-6030		



● MDQNR 107.5

- Anti-vibration ratio: 5 x D & above
- Bars have though coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars												
Part No	Insert	D	F	L	K	D (min)	Shim	Screw	Clamp	Clamp Screw	Wrench	
B25Q-MDQNR-1504	DNMG 1504	25	17	200	12	32	SMD-443	LCS-617	CP50-24	CS7-6024	LW030	
B32Q-MDQNR-1504		32	22	250	17	40				CS7-6024		
B40R-MDQNR-1504		40	27	300	15	50				CS7-6030		
B50S-MDQNR-1504		50	35	350	12	63				CS7-6030		
B32S-MDQNR-1506	DNMG 1506	32	22	250	17	40		LCS-619		CS7-6024		
B40T-MDQNR-1506		40	27	300	15	50				CS7-6030		
B50U-MDQNR-1506		50	35	350	12	63				CS7-6030		

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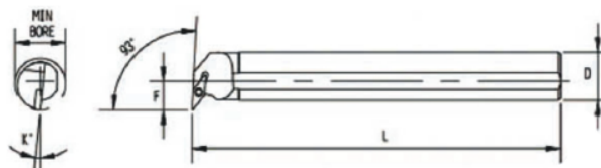
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Boring Bars with Damped Anti-Vibration

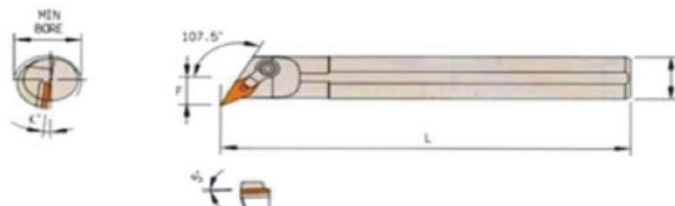
● SVUCR 93



- Anti-vibration ratio: 6 x D & above
- Bars have through coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars								
Part No	Insert	D	F	L	K	D (Min)	Screw	Torx Key
B16R-SVUCR-11	VCMT 1103	16	13	200	7	22	CS25060	FT-7
B20R-SVUCR-11		20	15	200	6	27		
B20R-SVUCR-16	VCMT 1603	20	19	200	8	31	CS35090	FT-15
B25S-SVUCR-16		25	20.5	250	4	33		
B32T-SVUCR-16		32	22.5	300	8	42		
B40U-SVUCR-16		40	27	350	6	51		

● MVQNR 107.5



- Anti-vibration ratio: 5 x D & above
- Bars have through coolant
- Bars made from High Strength Alloy steel with addition of internal dampening device

Anti-Vibration Boring Bars											
Part No	Insert	D	F	L	K	D (min)	Shim	Screw	Clamp	Clamp Screw	Wrench
B25Q-MVQNR-16	VNMG 1604	25	20	200	12	32	SMV-322	LCS-513	CP50-22	CS7-5024	LW030
B32R-MVQNR-16		32	33	250	17	42				CS7-5024	
B40S-MVQNR-16		40	27	300	15	50				CS7-6030	
B50T-MVQNR-16		50	33	350	15	63				CS7-6030	

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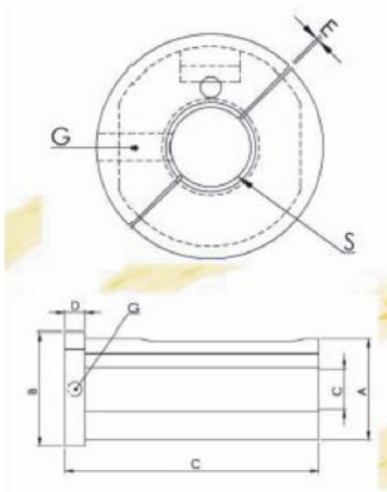
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Split Sleeve Boring Bar Holders



Split Sleeve boring bar holders for use with anti-vibration & solid carbide boring bars

Split Sleeve Boring Bar Holders		
Description	Part No	Size
Boring Bar Split Sleeve for Anti-Vibration Bar	ME32-S06-86	32 x 6 x 86
	ME32-S08-86	32 x 8 x 86
	ME32-S10-86	32 x 10 x 86
	ME32-S12-86	32 x 12 x 86
	ME32-S16-86	32 x 16 x 86
	ME32-S20-86	32 x 20 x 86
	ME32-S25-86	32 x 25 x 86
Boring Bar Split Sleeve for Anti-Vibration Bar	ME40-S08-97	40 x 8 x 97
	ME40-S10-97	40 x 10 x 97
	ME40-S12-97	40 x 12 x 97
	ME40-S16-97	40 x 16 x 97
	ME40-S20-97	40 x 20 x 97
	ME40-S25-97	40 x 25 x 97
Boring Bar Split Sleeve for Anti-Vibration Bar	ME40-S32-97	40 x 32 x 97
	ME50-S10-112	50 x 10 x 112
	ME50-S12-112	50 x 12 x 112
	ME50-S16-112	50 x 16 x 112
	ME50-S20-112	50 x 20 x 112
	ME50-S25-112	50 x 25 x 112
	ME50-S32-112	50 x 32 x 112
	ME50-S40-112	50 x 40 x 112

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Anti-Vibration Shell Mill Holders



- Anti-Vibration Shell Mill Adaptor System
- Anti-Vibration ratio of 5 times diameter & above
- Bars made from High Strength Alloy steel with addition of internal dampening device
- Can be used with all types of conventional face mills

Anti-Vibration Shell mill Holders								
Part No	Dimensions in mm						Spare Parts	
	d _i Spigot Dia	A	D _i Shank Dia	L Gauge Length	L _i Effective Length	Kg	Tenon	Tenon Screw
BT40-16-160	16	160	38	242	133	2.6	16C2080810A	951D0312
BT40-22-210	22	210	48	294	183	3.83	16C2101111	951D0416
BT40-22-260	22	260	48	344	233	5.5	16C2101111	951D0416
BT40-27-260	27	260	60	346	233	6.95	16C2121214A	951D0516
BT50-22-210	22	210	48	330	172	6.17	16C2101111	951D0416
BT50-22-260	22	260	48	380	222	8.08	16C2101111	951D0416
BT50-27-260	27	260	60	382	222	9.24	16C2121214A	951D0516
BT50-27-320	27	320	60	442	282	12.89	16C2121214A	951D0516
BT50-32-330	32	330	78	455	292	15.2	16C2121214A	951D0516

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MFB

Three-Section Anti-Vibration Finishing Boring Bars



- Anti-vibration ratio of 6 & 10 x Diameter
- Bars made from Dense alloy steel & Carbide
- Bars have additional internal dampening device
- For applications on Vertical & Horizontal boring machines, & line borers.

MFB 3 Section Anti-Vibration Finish Boring Bars				
Part No	Tool Conection	Boring Range mm	Length mm	Anti-Vibration Ratio
MFB 20	SCK 1	20 - 26	200	6
MFB 25	SCK 2	25 - 32	230	
MFB 32	SCK 3	32 - 42	270	
MFB 40	SCK 4	40 - 55	320	
MFB 50	SCK 5	52 - 70	380	
MFB 20L	SCK 1	20 - 26	280	10
MFB 25L	SCK 2	25 - 32	330	
MFB 32L	SCK 3	32 - 42	400	
MFB 40L	SCK 4	40 - 55	480	
MFB 50L	SCK 5	52 - 70	580	

NOTE: Bar is not supplied with Boring Heads or Inserts.

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Fine-Tune Anti-Vibration Boring Tool Holders



- Anti Vibration ratio of 5D & above
- Improves tool life, Increases output, Reduces Tooling costs
- Improves component surface finish.
- Can be used on Machining Centres, Turning Centres, & Large Manual Borers

Fine Tuning Anti-Vibration Boring Tool Holder				
Part No	Dimensions in mm			
	Holder Dia	Holder Shank Size	Heads mm	L Length
BT40-S2508	25	8 x 8	90.4	125
BT40-S3210	32	10 x 10	90.4	160
BT40-S4016	40	16 x 16	90.4	200
BT40-S5019	50	19 x 19	90.4	250
BT50-S2508	25	8 x 8	139.8	125
BT50-S3210	32	10 x 10	139.8	160
BT50-S4016	40	16 x 16	139.8	200
BT50-S5019	50	19 x 19	139.8	250
BT50-S6025	60	25 x 25	139.8	300

NOTE: Bar is not supplied with tool holder or inserts.

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