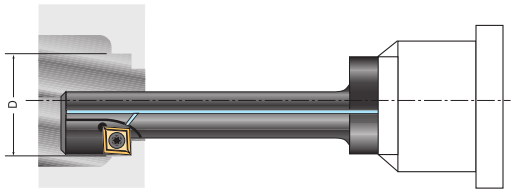
# 17570 Reverse milling counterbores, 180°/45°

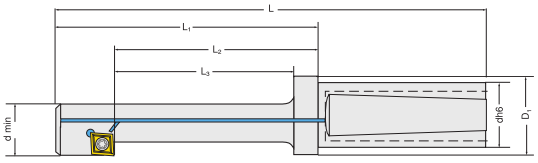
DIN 1835 E

ATORN®

**Design**
- Supplied **without** indexable inserts

**Applications**
For reverse countersinking of bores.



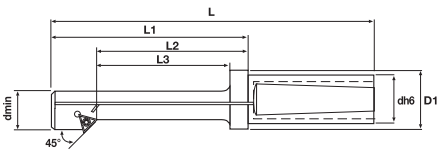

17570 101-114

## Reverse milling counterbores, 180°

| Ø D mm | d min. mm | L mm | $L_1$ mm | $L_2$ mm | $L_3$ mm | dh6 mm | $D_1$ mm | e mm | Indexable inserts | 17570 ... |
|---|---|---|---|---|---|---|---|---|---|---|
| 18 | 10.5 | 112 | 62 | 47 | 40 | 20 | 25 | 4.0 | CC.. 0602.. | 101 |
| 20 | 13.0 | 117 | 67 | 52 | 45 | 20 | 25 | 3.75 | CC.. 0602.. | 102 |
| 24 | 15.0 | 122 | 72 | 57 | 50 | 20 | 25 | 4.75 | CC.. 0602.. | 103 |
| 26 | 17.0 | 132 | 82 | 67 | 60 | 20 | 25 | 5.0 | CC.. 0602.. | 104 |
| 30 | 19.0 | 142 | 92 | 77 | 65 | 20 | 25 | 6.0 | CC.. 0602.. | 105 |
| 33 | 21.0 | 152 | 102 | 82 | 75 | 20 | 25 | 6.5 | CC.. 09T3.. | 106 |
| 36 | 23.0 | 173 | 113 | 93 | 85 | 32 | 40 | 7.0 | CC.. 09T3.. | 107 |
| 40 | 25.0 | 183 | 123 | 103 | 95 | 32 | 40 | 8.0 | CC.. 09T3.. | 108 |
| 43 | 30.0 | 183 | 123 | 103 | 95 | 32 | 40 | 7.0 | CC.. 09T3.. | 109 |
| 48 | 33.0 | 223 | 163 | 143 | 135 | 32 | 40 | 8.0 | CC.. 09T3.. | 110 |
| 53 | 36.0 | 210 | 140 | 40 | 110 | 40 | - | 9.0 | CC.. 1204.. | 111 |
| 57 | 39.0 | 220 | 150 | 40 | 120 | 40 | - | 9.5 | CC.. 1204.. | 112 |
| 66 | 45.0 | 245 | 165 | 50 | 135 | 50 | - | 11.0 | CC.. 1204.. | 113 |
| 76 | 52.0 | 265 | 185 | 50 | 155 | 50 | - | 12.5 | CC.. 1204.. | 114 |

**17570 101**
**Design**
- Without internal cooling

**Note:**
*For indexable inserts see art. no. 18550 ff.*



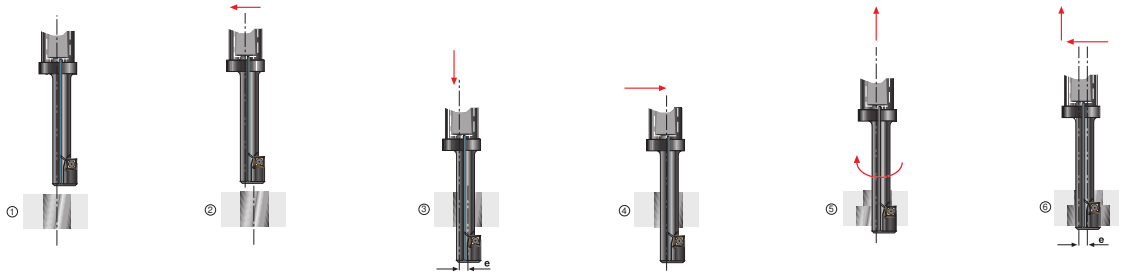

17570 201-209

## Reverse milling counterbores, 45°

| Ø D mm | d min. mm | L mm | L1 mm | L2 mm | L3 mm | dh6 mm | D1 mm | e mm | Indexable inserts | 17570 ... |
|---|---|---|---|---|---|---|---|---|---|---|
| 15 | 10 | 105 | 55 | 42 | 35 | 20 | 25 | 2.7 | TCMT 0802.. | 201 NEW |
| 20 | 14 | 110 | 60 | 47 | 40 | 20 | 25 | 3.2 | TCMT 0802.. | 203 NEW |
| 23 | 17 | 120 | 70 | 57 | 50 | 20 | 25 | 3.2 | TCMT 1102.. | 204 NEW |
| 27 | 21 | 140 | 90 | 77 | 70 | 20 | 25 | 3.2 | TCMT 1102.. | 207 NEW |
| 31 | 24 | 150 | 100 | 87 | 80 | 20 | 25 | 3.7 | TCMT 1102.. | 209 NEW |

**17570 201**
**Design**
- Without internal cooling

***Note:***
*For indexable inserts see art. no. 17570 301.*




**1)** Position the tool on the centre of the bore. Spindle orientation 0°.

**2)** Offset the tool by the programming dimension (e).

**3)** Plunge to the position below the lower edge of the workpiece with safety clearance.

**4)** Move back to the centre of the bore by the dimension (e), and then start the spindle.

**5)** Countersink to the desired depth.

**6)** Position at the safety distance below the lower edge of the workpiece. Spindle orientation at 0°.
Then offset the tool by the programming dimension (e) and extend the cutter.

| Applications | | | | | | | P M K | |
|---|---|---|---|---|---|---|---|---|
| Coating | | | | | | | TiN | |
| ISO Designation | l mm | d mm | s mm | $d_1$ mm | r mm | | 17570 | ... |
| TCMT 080204 | 8.2 | 4.76 | 2.38 | 2.3 | 0.4 | 10 pcs. | | 301 NEW |

| Spare parts | | Clamping screw 10 | | Wrench | |
|---|---|---|---|---|---|
| For indexable inserts size | TX size T | 17528 | ... | 52529 | ... |
| TCMT 080204 | 7 | | 100 NEW | | 402 NEW |
| CC.. 0602.. | 8 | | 101 | | 403 |
| CC.. 09T3.. | 15 | | 102 | | 406 |
| CC.. 1204.. | 20 | | 103 | | 407 |



= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

DIN 1835 B

ATORN®

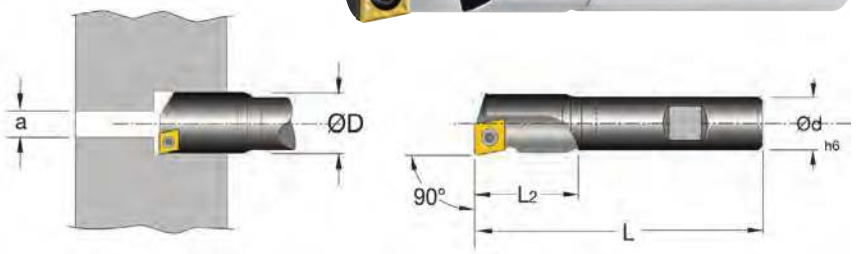
17576

**Design**
- Single-edged boring bar with internal cooling
- **Without** indexable inserts

**Bore tolerances:**
Indexable insert radius 0.2 mm = +0.05/-0.10 mm
Indexable insert radius 0.4 mm = +0.03/-0.18 mm

**Applications**
For countersinking and core drilling.

***Note:***
*For indexable inserts see art. no. 18550 ff.*




| Ø D mm | Ød h6 mm | a mm | L mm | $L_2$ mm | Indexable inserts | 17576 | ... |
|---|---|---|---|---|---|---|---|
| **9.8** | 8 | 4.5 | 90 | 23 | CC.. 0602.. | | 201 NEW |
| **10** | 12 | 4 | 85 | 15 | CC.. 0602.. | | 101 |
| **10.8** | 10 | 3.5 | 105 | 24 | CC.. 0602.. | | 202 NEW |
| **11** | 12 | 4 | 85 | 16 | CC.. 0602.. | | 102 |
| **11.8** | 10 | 3 | 105 | 25 | CC.. 0602.. | | 203 NEW |
| **12** | 10 | 4 | 85 | 20 | CC.. 0602.. | | 103 |
| **12.8** | 10 | 2.5 | 105 | 26 | CC.. 0602.. | | 204 NEW |
| **13** | 12 | 5 | 85 | 21 | CC.. 0602.. | | 104 |
| **13.8** | 12 | 3 | 110 | 27 | CC.. 0602.. | | 205 NEW |
| **14** | 12 | 5 | 85 | 21 | CC.. 0602.. | | 105 |
| **14.8** | 12 | 3.5 | 120 | 28 | CC.. 0602.. | | 206 NEW |
| **15** | 12 | 5 | 85 | 24 | CC.. 0602.. | | 106 |
| **15.8** | 12 | 4 | 125 | 29 | CC.. 0602.. | | 207 NEW |
| **16** | 12 | 5 | 85 | 28 | CC.. 0602.. | | 107 |
| **16.8** | 16 | 5 | 140 | 30 | CC.. 0602.. | | 208 NEW |
| **17** | 16 | 5 | 95 | 40 | CC.. 09T3.. | | 108 |
| **17.8** | 16 | 6 | 140 | 31 | CC.. 0602.. | | 209 NEW |
| **18** | 16 | 5 | 95 | 40 | CC.. 09T3.. | | 109 |
| **18.8** | 16 | 7 | 150 | 32 | CC.. 0602.. | | 210 NEW |
| **19** | 16 | 5 | 95 | 40 | CC.. 09T3.. | | 110 |
| **19.8** | 16 | 8 | 150 | 33 | CC.. 09T3.. | | 211 NEW |
| **20** | 16 | 5 | 95 | 40 | CC.. 09T3.. | | 111 |
| **20.8** | 16 | 9 | 160 | 34 | CC.. 09T3.. | | 212 NEW |
| **21** | 16 | 5 | 95 | 33 | CC.. 09T3.. | | 112 |

| Ø D mm | Ød h6 mm | a mm | L mm | $L_2$ mm | Indexable inserts | 17576 | ... |
|---|---|---|---|---|---|---|---|
| **21.8** | 20 | 10 | 160 | 35 | CC.. 09T3.. | | 213 NEW |
| **22** | 16 | 6 | 95 | 37 | CC.. 09T3.. | | 113 |
| **22.8** | 20 | 11 | 165 | 36 | CC.. 09T3.. | | 214 NEW |
| **23** | 16 | 6 | 95 | 40 | CC.. 09T3.. | | 114 |
| **23.8** | 20 | 12 | 170 | 37 | CC.. 09T3.. | | 215 NEW |
| **24** | 16 | 6 | 95 | 34 | CC.. 09T3.. | | 115 |
| **24.8** | 20 | 13 | 180 | 38 | CC.. 09T3.. | | 216 NEW |
| **25** | 16 | 8 | 95 | 33 | CC.. 09T3.. | | 116 |
| **25.8** | 20 | 14 | 185 | 39 | CC.. 09T3.. | | 217 NEW |
| **26** | 20 | 8 | 120 | 53 | CC.. 09T3.. | | 117 |
| **26.8** | 20 | 15 | 190 | 40 | CC.. 09T3.. | | 218 NEW |
| **27** | 20 | 9 | 120 | 56 | CC.. 09T3.. | | 118 |
| **27.8** | 20 | 16 | 190 | 41 | CC.. 09T3.. | | 219 NEW |
| **28** | 20 | 10 | 120 | 53 | CC.. 09T3.. | | 119 |
| **28.8** | 20 | 17 | 200 | 42 | CC.. 09T3.. | | 220 NEW |
| **29** | 20 | 11 | 120 | 55 | CC.. 09T3.. | | 120 |
| **29.8** | 25 | 18 | 200 | 43 | CC.. 09T3.. | | 221 NEW |
| **30** | 20 | 12 | 121 | 57 | CC.. 09T3.. | | 121 |
| **30.8** | 25 | 19 | 200 | 44 | CC.. 09T3.. | | 222 NEW |
| **31** | 20 | 14 | 120 | 55 | CC.. 09T3.. | | 122 |
| **31.8** | 25 | 20 | 200 | 45 | CC.. 09T3.. | | 223 NEW |
| **32** | 20 | 15 | 120 | 54 | CC.. 09T3.. | | 123 |
| **33** | 20 | 16 | 120 | 55 | CC.. 09T3.. | | 124 |

**Spare parts**

| For indexable inserts size | TX size T | Clamping screw 17528 | ... | Wrench 52529 | ... |
|---|---|---|---|---|---|
| **CC.. 0602..** | 8 | | 101 | | 403 |
| **CC.. 09T3..** | 15 | | 102 | | 406 |

## 17577 Core and countersunk drills (double-edged)

DIN 1835 B

ATORN®

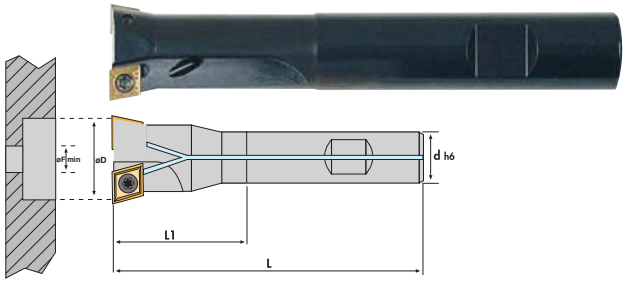
**Design**
- Double-edged boring bar with internal cooling
- **Without** indexable inserts

**Bore tolerances:**
Indexable insert radius 0.2 mm = +0.05/-0.10 mm
Indexable insert radius 0.4 mm = +0.03/-0.18 mm

**Applications**
For countersinking and core drilling.

***Note:***
*For indexable inserts see art. no. 18550 ff.*

17577




| Ø D mm | Ød h6 mm | Ø F min. mm | L mm | L1 mm | Indexable inserts | 17577 ... |
|---|---|---|---|---|---|---|
| 16 | 12 | 5 | 92 | 30 | CC.. 0602.. | 101 |
| 17 | 16 | 6 | 94 | 32 | CC.. 0602.. | 102 |
| 18 | 16 | 7 | 97 | 41 | CC.. 0602.. | 103 |
| 19 | 16 | 8 | 100 | 41 | CC.. 0602.. | 104 |
| 20 | 16 | 9 | 102 | 41 | CC.. 0602.. | 105 |
| 21 | 16 | 10 | 105 | 41 | CC.. 0602.. | 106 |
| 22 | 16 | 11 | 110 | 41 | CC.. 0602.. | 107 |
| 23 | 16 | 12 | 112 | 41 | CC.. 0602.. | 108 |
| 24 | 16 | 13 | 115 | 41 | CC.. 0602.. | 109 |
| 25 | 16 | 8 | 120 | 40 | CC.. 09T3.. | 110 |
| 26 | 20 | 9 | 125 | 55 | CC.. 09T3.. | 111 |
| 27 | 20 | 10 | 128 | 55 | CC.. 09T3.. | 112 |
| 28 | 20 | 11 | 130 | 55 | CC.. 09T3.. | 113 |
| 29 | 20 | 12 | 132 | 55 | CC.. 09T3.. | 114 |

| Ø D mm | Ød h6 mm | Ø F min. mm | L mm | L1 mm | Indexable inserts | 17577 ... |
|---|---|---|---|---|---|---|
| 30 | 20 | 13 | 134 | 55 | CC.. 09T3.. | 115 |
| 31 | 20 | 14 | 136 | 55 | CC.. 09T3.. | 116 |
| 32 | 20 | 15 | 138 | 55 | CC.. 09T3.. | 117 |
| 33 | 20 | 16 | 140 | 55 | CC.. 09T3.. | 118 |
| 34 | 25 | 16 | 140 | 60 | CC.. 09T3.. | 119 |
| 35 | 25 | 17 | 140 | 60 | CC.. 09T3.. | 120 |
| 36 | 25 | 18 | 140 | 60 | CC.. 09T3.. | 121 |
| 37 | 25 | 19 | 140 | 60 | CC.. 09T3.. | 122 |
| 38 | 25 | 20 | 140 | 60 | CC.. 09T3.. | 123 |
| 39 | 25 | 21 | 140 | 60 | CC.. 09T3.. | 124 |
| 40 | 25 | 22 | 140 | 60 | CC.. 09T3.. | 125 |
| 41 | 25 | 23 | 140 | 60 | CC.. 09T3.. | 126 |
| 42 | 25 | 24 | 140 | 60 | CC.. 09T3.. | 127 |

| Spare parts | | Clamping screw 10 | | Wrench | |
|---|---|---|---|---|---|
| For indexable inserts size | TX size T | 17528 | ... | 52529 | ... |
| CC.. 0602.. | 8 | | 101 | | 403 |
| CC.. 09T3.. | 15 | | 102 | | 406 |

## 17578 Adjustable fine boring bars

DIN 1835 B

ATORN®

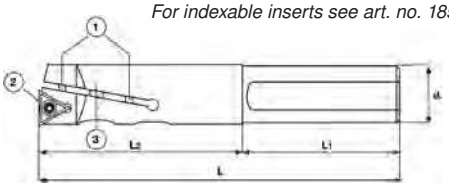
**Design**
- Special steel, nickel-plated
- Adjustment range 2–5 mm
- **Without** indexable inserts

**Advantage:**
- Cost-effective alternative to spindle tools

**Applications**
For ISO indexable inserts CCMT and CCGT.

***Note:***
*For indexable inserts see art. no. 18550 ff.*

17578




1 = Draw bolt
2 = Clamping screw
3 = Counter screw

| D min. mm | D max. mm | d mm | L mm | L2 mm | L1 mm | Indexable inserts | Holder 17578 ... | Draw bolt 17578 ... | Counter screw 17578 ... |
|---|---|---|---|---|---|---|---|---|---|
| 10 | 12 | 10 | 100 | 30 | 70 | CC.. 0602.. | 101 | 201 | 301 |
| 12 | 15 | 12 | 105 | 30 | 70 | CC.. 0602.. | 102 | 201 | 302 |
| 15 | 20 | 16 | 110 | 50 | 60 | CC.. 0602.. | 103 | 202 | 303 |
| 20 | 25 | 20 | 120 | 60 | 60 | CC.. 0602.. | 104 | 203 | 304 |
| 25 | 30 | 25 | 140 | 70 | 70 | CC.. 09T3.. | 105 | 204 | 305 |
| 30 | 35 | 25 | 160 | 90 | 70 | CC.. 09T3.. | 106 | 205 | 306 |
| 35 | 40 | 32 | 170 | 100 | 70 | CC.. 09T3.. | 107 | 206 | 307 |
| 40 | 45 | 32 | 190 | 120 | 70 | CC.. 09T3.. | 108 | 207 | 308 |
| 45 | 50 | 32 | 220 | 160 | 70 | CC.. 09T3.. | 109 | 208 | 309 |

| Spare parts | | Clamping screw 10 | | Wrench | |
|---|---|---|---|---|---|
| For indexable inserts size | TX size T | 17528 | ... | 52529 | ... |
| CC.. 0602.. | 8 | | 101 | | 403 |
| CC.. 09T3.. | 15 | | 102 | | 406 |





= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.