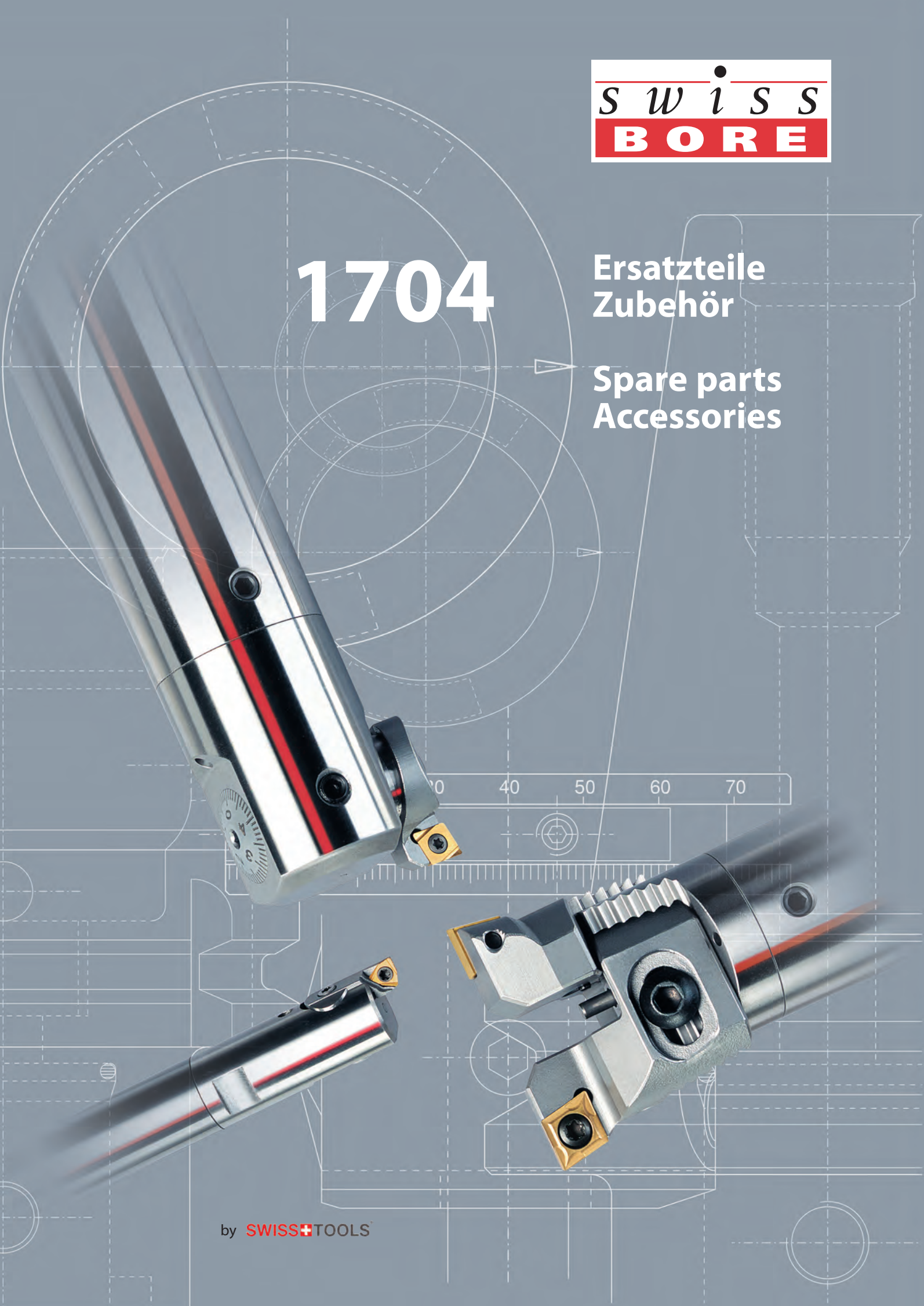


**S W I S S**  
**BORE**

**1704**

**Ersatzteile  
Zubehör**

**Spare parts  
Accessories**



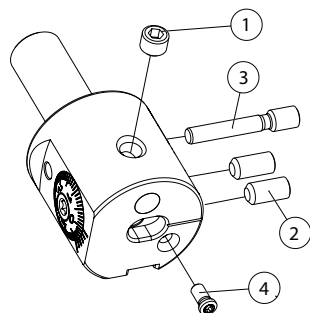
## Inhaltsverzeichnis / Table of contents

	Typ / Type	Ersatzteilliste / Spare part list Seite / Page	Bedienungsanleitung / Instruction manual Seite / Page
Ausdrehkopf / Fine boring head	204 /206 MICRO HEAD	3	15
	204 /206/208/211	3	15
	205 VARIO HEAD	3	16
	210 MULTI HAED	3	16
Auswuchtring / Balancing ring	216	4	21
Ausdrehstahlverlängerung / Boring bar extension	234	4	
Ausdrehstahl / Boring Bar	254	4	
	256	4	
	274	4	
	294	5	18
Feinbohrkopf / Fine boring head	300/301	5	18
	304/305	6	18
Anzeigeeinheit / Display unit	309	6	19
Wendeplattenhalter / Insert holder	302/314/315	7	
Umkehradapter / Reversal adapter	324	7	
Zweischneiderkopf / Twin Cutter Ø86-402mm	344/354	8	19
Feinbohrkopf / Fine boring head Ø86-402mm	444/454	8	19
Zweischneiderkopf / Twincutter boring head	404	9	22
Wendeplattenhalter / Insert holder	414/424/437	10	22
	434	11	22
Brückenwerkzeuge / Bridge tool adapter	504/514/534/544/554	12	22
Verlängerungskonsolen / Extension bridge	560/562/564	12	22
Wendeplattenhalter / Insertholder	570/580	13	22
Feinbohrkopf / Fine boring head Ø150-2205mm	590/591/594	13	22
Feinbohrkopf / Fine Boring head	598 ECO HEAD	13	21
Bedienschlüssel / Service keys		14	
Modulare Schnittstelle / Modulare Interface	ST1 - ST7+	15	

## Ersatzteile / Zubehör

## Spare parts / Accessories

204/206

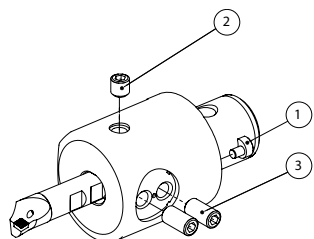


Type	max. Nm	S	Torque key	Bit	Service key
204/206.010.025.025					
① 900.204.005.004	1.4	2.5	900.895.000.012	900.895.001.025	900.892.000.025
② 900.204.004.008	2.4	2	900.895.000.022	900.895.001.020	900.892.000.020
③ A25-BG4.003.022					
④ 900.254.025.006					
<b>Type</b>					
204/206.016.032.032					
① 900.204.006.005	2.4	3	900.895.000.022	900.895.001.030	900.892.000.030
② 900.204.006.010	3.4	3	900.895.000.030	900.895.001.030	900.892.000.030
③ A32-BG4.003.028					
④ 900.254.025.006					

## Ersatzteile / Zubehör

## Spare parts / Accessories

204/206/208/211

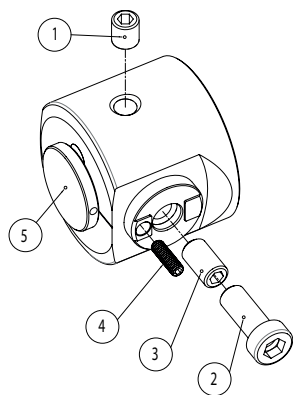


Type	max. Nm	S	Torque key	Bit	Service key
204 / 206 / 208 / 211					
① 900.102.050.000 (204.050.025.045)					
① 900.102.064.000 (210.064.025.065)					
② 900.204.010.008	8.0	5	900.895.000.057	900.895.001.050	900.892.000.050
③ 900.204.010.016	10.0	5			900.892.000.050

## Ersatzteile / Zubehör

## Spare parts / Accessories

205

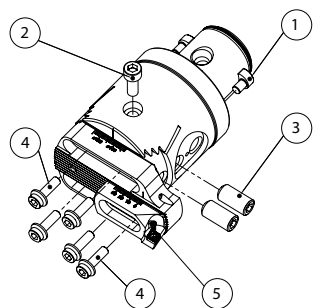


Type	max. Nm	S	Torque key	Bit	Service key
205.040.003.152					
① 900.205.010.012	8.0	5	900.895.000.057	900.895.001.050	900.892.000.050
② 900.205.010.025	10.0	8			900.892.000.080
③ 900.205.010.018	10.0	5			900.892.000.050
④ 900.205.003.014	3.0	2.5	900.895.000.030	900.895.001.025	900.892.000.025
⑤ 900.805.000.032					

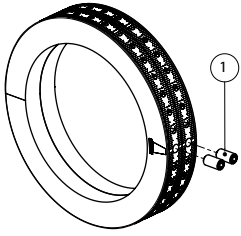
## Ersatzteile / Zubehör

## Spare parts / Accessories

210



Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
210.xxx.xxx.xxx						
① 900.102.064.000 (210.064.025.065)						
② 900.210.006.016	8.0	5	900.895.000.057	900.895.001.050		900.892.000.050
③ 900.210.010.020	10.0	5				900.892.000.050
④ 900.256.005.016	5.0	4	900.895.000.050	900.895.001.040		900.892.000.040
⑤ 900.254.025.006 (256.xxx.006.xxx)	0.9	T7	900.895.000.009	900.895.002.007	900.254.007.000	
⑤ 900.254.040.009 (256.xxx.009.xxx)	3.0	T15	900.895.000.030	900.895.002.015	900.254.009.000	

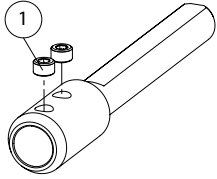


**Ersatzteile / Zubehör**

**Spare parts / Accessories**

**216**

Type	max. Nm	S	Torque key	Bit	Service key
216.xxxx.xxx.016					
① 900.216.004.008	1.4	2	900.895.000.012	900.895.001.020	900.892.000.020

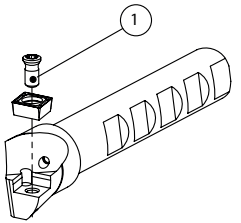


**Ersatzteile / Zubehör**

**Spare parts / Accessories**

**234**

Type	max. Nm	S	Torque key	Bit	Service key
234.016.010.128					
① 900.234.006.003	3.4	3	900.895.000.030	900.895.001.030	900.892.000.030
Type 234.016.016.148					
① 900.234.008.005	5.0	4	900.895.000.050	900.895.001.040	900.892.000.040

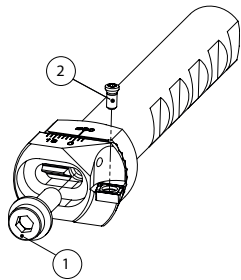


**Ersatzteile / Zubehör**

**Spare parts / Accessories**

**254**

Type	max. Nm	Torx	Torque key	Bit	Service key
254.010.006.075					
① 900.254.025.005	0.9	T7	900.895.000.009	900.895.002.007	900.254.007.000
Type 254.xxx.006.xxx					
① 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007	900.254.007.000
Type 254.xxx.009.xxx					
① 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015	900.254.009.000

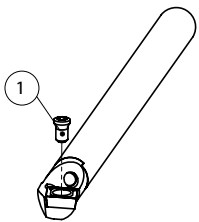


**Ersatzteile / Zubehör**

**Spare parts / Accessories**

**256**

Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
256.xxx.xxx.115						
① 900.256.005.016	5.0	4	900.895.000.050	900.895.001.040	900.892.000.040	
Type 256.xxx.006.xxx						
② 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007		900.254.007.000
Type 256.xxx.009.xxx						
② 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000

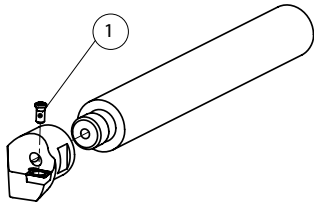


**Ersatzteile / Zubehör**

**Spare parts / Accessories**

**274**







Type	max. Nm	Torx	Torque key	Bit	Service key
274.xxx.002.xxx					
① 900.254.020.004	0.6	T6	900.895.000.006	900.895.002.006	900.254.006.000
Type 274.010.006.120					
① 900.254.025.005	0.9	T7	900.895.000.009	900.895.002.007	900.254.007.000
Type 274.xxx.006.xxx					
① 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007	900.254.007.000
Type 274.xxx.009.xxx					
① 900.254.040.009	3.0	15	900.895.000.030	900.895.002.015	900.254.009.000

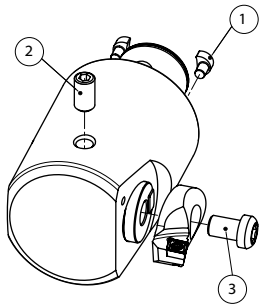


Ersatzteile / Zubehör

Spare parts / Accessories

294
































Type	max. Nm	Torx	Torque key	Bit	Service key
<b>Type 294.009-012.006.0xx</b>					
① 900.254.025.005	0.9	7			
900.254.025.005			900.895.000.009	900.895.002.007	900.254.007.000
<b>Type 294.013-035.006.xxx</b>					
① 900.254.025.006	0.9	7			
900.254.025.006			900.895.000.009	900.895.002.007	900.254.007.000



Ersatzteile / Zubehör

Spare parts / Accessories




300/301

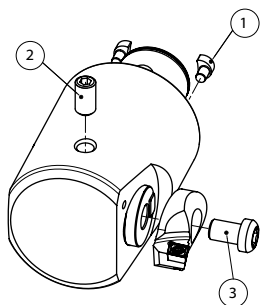
Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
<b>Type 300.014.015.040</b>						
② 900.881.280.140	0.9	1.5				
900.881.280.140			900.895.000.009	900.895.001.015	900.892.000.015	
③ 900.882.280.140	0.9	T6				900.254.006.000
900.882.280.140			900.895.000.009	900.895.002.006		900.254.006.000
<b>Type 300.016.017.040</b>						
② 900.881.280.160	0.9	1.5				
900.881.280.160			900.895.000.009	900.895.001.015	900.892.000.015	
③ 900.882.280.160	0.9	T6				900.254.006.000
900.882.280.160			900.895.000.009	900.895.002.006		900.254.006.000
<b>Type 300.019.020.040</b>						
② 900.881.280.180	0.9	1.5				
900.881.280.180			900.895.000.009	900.895.001.015	900.892.000.015	
③ 900.882.280.180	0.9	T6				900.254.006.000
900.882.280.180			900.895.000.009	900.895.002.006		900.254.006.000
<b>Type 300/301.020.024.041</b>						
② 900.304.004.003	1.2	2				
900.304.004.003			900.895.000.010	900.895.001.020	900.892.000.020	
③ 900.314.004.006	2.4	2.5				
900.314.004.006			900.895.000.022	900.895.001.025	900.892.000.025	
<b>Type 300/301.025.031.045</b>						
② 900.304.005.004	1.4	2.5				
900.304.005.004			900.895.000.012	900.895.001.025	900.892.000.025	
③ 900.314.005.008	5.0	3				
900.314.005.008			900.895.000.050	900.895.001.030	900.892.000.030	
<b>Type 300/301.032.040.051</b>						
② 900.304.006.005	2.4	3				
900.304.006.005			900.895.000.022	900.895.001.030	900.892.000.030	
③ 900.314.006.010	9.0	4				
900.314.006.010					900.892.000.040	

## Ersatzteile / Zubehör

## Spare parts / Accessories

304/305


Type	max. Nm	S	Torque key	Bit	Service key
<b>Type 304/305.020.024.035</b>					
① 900.102.020.000					
② 900.304.004.003	1.2	2	900.895.000.010	900.895.001.020	900.892.000.020
③ 900.314.004.006	2.4	2.5	900.895.000.022	900.895.001.025	900.892.000.025
<b>Type 304/305.025.031.040</b>					
① 900.102.025.000					
② 900.304.005.004	1.4	2.5	900.895.000.012	900.895.001.025	900.892.000.025
③ 900.314.005.008	5.0	3	900.895.000.050	900.895.001.030	900.892.000.030
<b>Type 304/305.032.040.047</b>					
① 900.102.032.000					
② 900.304.006.005	2.4	3	900.895.000.022	900.895.001.030	900.892.000.030
③ 900.314.006.010	9.0	4			900.892.000.040
<b>Type 304/305.039.051.057</b>					
① 900.102.039.000					
② 900.304.008.006	4.0	4	900.895.000.038	900.895.001.040	900.892.000.040
③ 900.314.008.012	10.0	5			900.892.000.050
<b>Type 304/305.050.067.080</b>					
① 900.102.050.000					
② 900.304.010.010	8.0	5	900.895.000.057	900.895.001.050	900.892.000.050
③ 900.314.010.016	20.0	8			900.892.000.080
<b>Type 304/305.064.087.100</b>					
① 900.102.064.000					
② 900.304.010.018	8.0	5	900.895.000.057	900.895.001.050	900.892.000.050
③ 900.314.010.016	20.0	8			900.892.000.080
<b>Type 304/305.090.116.130</b>					
① 900.102.090.000					
② 900.304.010.030	8.0	5	900.895.000.057	900.895.001.050	900.892.000.050
③ 900.314.010.016	20.0	8			900.892.000.080

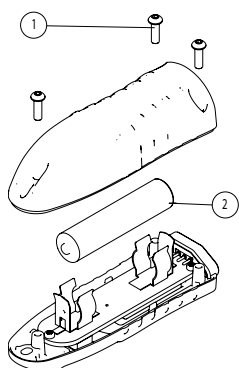


## Ersatzteile / Zubehör

## Spare parts / Accessories

309

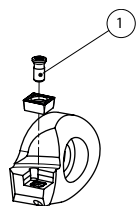
Type	Size	Torx	Service key
<b>Type 309.028.024.077</b>			
① 900.309.022.008		T6	 900.254.006.000
② 900.308.011.045	AAA		





## Ersatzteile / Zubehör

## Spare parts / Accessories

302/314/315

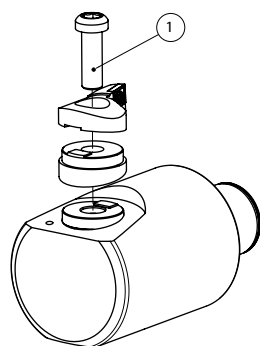






Type	max. Nm	Torx	Torque key	Bit	Service key
302.005.017.002					
900.254.020.004	0.6	T6	900.895.000.006	900.895.002.006	900.254.006.000
Type					
314/315.xxx.xxx.006					
900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007	900.254.007.000
Type					
314/315.xxx.xxx.009					
900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015	900.254.009.000

## Ersatzteile / Zubehör

## Spare parts / Accessories

324







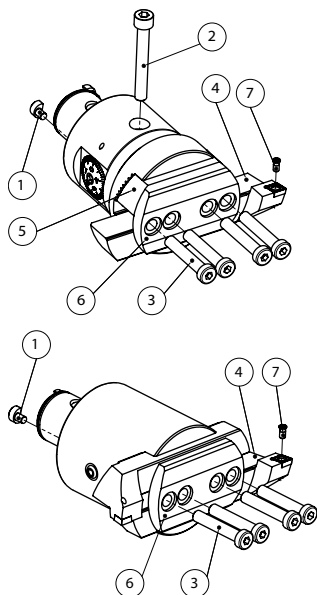
For reversal adapter	Order number	max. Nm	S	Torque key	Bit	Service key
Type						
324.011.065.008	900.324.004.012	2.4	2.5	900.895.000.022	900.895.001.025	900.892.000.025
324.011.080.008	900.324.004.013	2.4	2.5	900.895.000.022	900.895.001.025	900.892.000.025
324.013.065.007	900.324.005.014	3.4	3	900.895.000.050	900.895.001.030	900.892.000.030
324.013.100.007	900.324.005.016	3.4	3	900.895.000.050	900.895.001.030	900.892.000.030
324.017.065.013	900.324.006.015	5.0	4			900.892.000.040
324.017.100.013	900.324.006.020	5.0	4			900.892.000.040
324.022.065.016	900.324.008.020	10.0	5			900.892.000.050
324.022.120.016	900.324.008.025	10.0	5			900.892.000.050
324.030.100.027	900.324.010.030	20.0	8			900.892.000.050

## Ersatzteile / Zubehör

## Spare parts / Accessories

344/354/444/454

Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
344/444.064.086.112						
① 900.102.064.000						
② 900.344.008.065	8.0	6	900.895.000.057	900.895.001.060	900.892.000.060	
③ 900.344.008.044	25.0	6			900.892.000.060	
<b>Type</b>						
<b>354/454.086.138.009</b>						
④ 900.354.086.009						
⑤ 900.345.020.086						
⑥ 900.345.010.086						
⑦ 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type</b>						
<b>354/454.086.138.012</b>						
④ 900.354.086.012						
⑤ 900.345.020.086						
⑥ 900.345.010.086						
⑦ 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000
<b>Type</b>						
<b>354/454.136.220.009</b>						
④ 900.354.136.009						
⑤ 900.345.020.136						
⑥ 900.345.010.136						
⑦ 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type</b>						
<b>354/454.136.220.012</b>						
④ 900.354.136.012						
⑤ 900.345.020.136						
⑥ 900.345.010.136						
⑦ 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000
<b>Type</b>						
<b>354/454.188.302.009</b>						
④ 900.354.188.009						
⑤ 900.345.020.136						
⑥ 900.345.010.136						
⑦ 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type</b>						
<b>354/454.242.402.009</b>						
④ 900.354.242.009						
⑤ 900.345.020.136						
⑥ 900.345.010.136						
⑦ 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000





Type	max. Nm	S	Torque key	Bit	Service key
404.020.024.035		5			

①	900.102.020.000					
②	900.404.004.008	2.4	2.5	900.895.000.022	900.895.001.025	900.892.000.025
③	900.405.004.000					
④	900.406.025.008					

**Type**  
**404.025.031.040**

①	900.102.025.000					
②	900.404.005.012	5.0	3	900.895.000.050	900.895.001.030	900.892.000.030
③	900.405.005.000					
④	900.406.025.008					

**Type**  
**404.032.040.047**

①	900.102.032.000					
②	900.404.006.016	9.0	4			900.892.000.040
③	900.405.006.000					
④	900.406.030.012					

**Type**  
**404.039.051.057**

①	900.102.039.000					
②	900.404.008.020	20.0	5			900.892.000.050
③	900.405.008.000					
④	900.406.030.014					

**Type**  
**404.050.067.080**

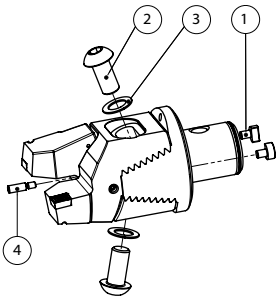
①	900.102.050.000					
②	900.404.010.025	35.0	6			900.892.000.060
③	900.405.010.000					
④	900.406.040.020					

**Type**  
**404.064.087.100**

①	900.102.064.000					
②	900.404.012.025	35.0	8			900.892.000.080
③	900.405.012.000					
④	900.406.060.020					

**Type**  
**404.090.116.130**





①	900.102.090.000					
②	900.404.016.035	35.0	10			900.892.000.100
③	900.405.016.000					
④	900.406.060.020					

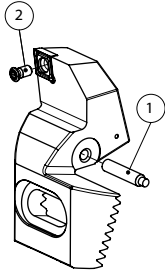


## Ersatzteile / Zubehör

## Spare parts / Accessories

414/424/437





Type 414/424/437	max. Nm	S / Torx	Torque key 	Bit 	Service key 	Service key 
<b>Type 414/424/437</b> <b>020.024.006</b>						
① 900.414.004.007		2			900.892.000.020	
② 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007		900.254.007.000
<b>Type 414/424/437</b> <b>025.031.006</b>						
① 900.414.004.010		2			900.892.000.020	
② 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007		900.254.007.000
<b>Type 414/424/437</b> <b>032.040.009</b>						
① 900.414.004.013		2			900.892.000.020	
② 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type 414/424/437</b> <b>039.051.009</b>						
① 900.414.006.014		3			900.892.000.030	
② 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type 414/424/437</b> <b>050.067.xxx</b>						
① 900.415.006.020		3			900.892.000.030	
② 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000
<b>Type 414/424/437</b> <b>064.087.xxx</b>						
① 900.415.006.020		3			900.892.000.030	
② 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000
<b>Type 414/424/437</b> <b>090.115.xxx</b>						
① 900.415.006.020		3			900.892.000.030	
② 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000

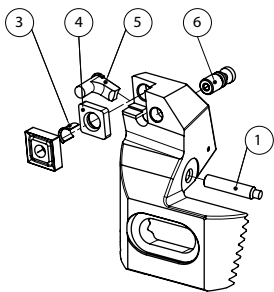


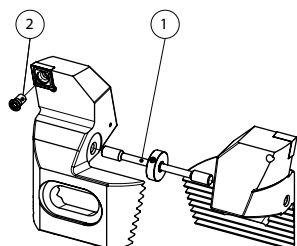
## Ersatzteile / Zubehör





## Spare parts / Accessories

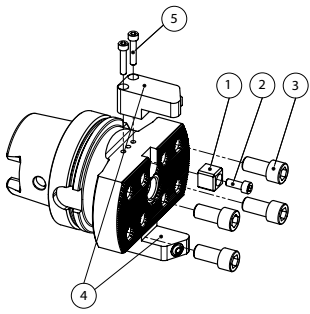
414/424

Type 414/424.050.067.112	max. Nm	S	Torque key 	Bit 	Service key 	Service key 
③ 900.416.012.000						
④ 900.417.012.000						
⑤ 900.418.012.000						
⑥ 900.419.012.000		3			900.892.000.030	
<b>Type</b> <b>414/424.064.087.116</b>						
③ 900.416.016.000						
④ 900.417.016.000						
⑤ 900.418.016.000						
⑥ 900.419.016.000		3			900.892.000.030	
<b>Type</b> <b>414/424.064.087.116</b>						
③ 900.416.016.000						
④ 900.417.016.000						
⑤ 900.418.016.000						
⑥ 900.419.016.000		4			900.892.000.040	








Type	max. Nm	S / Torx	Torque key 	Bit 	Service key 	Service key 
<b>Type 434.020.024.006</b>						
① 900.434.004.018		2			900.892.000.020	
② 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007		900.254.007.000
<b>Type 434.025.031.006</b>						
① 900.434.004.023		2			900.892.000.020	
② 900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007		900.254.007.000
<b>Type 434.032.040.009</b>						
① 900.434.004.030		2			900.892.000.020	
② 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type 434.039.051.009</b>						
① 900.434.006.040		3			900.892.000.030	
② 900.254.040.009	3.0	T15	900.895.000.030	900.895.002.015		900.254.009.000
<b>Type 434.050.067.012</b>						
① 900.434.006.052		3			900.892.000.030	
② 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000
<b>Type 434.064.087.012</b>						
① 900.434.006.068		3			900.892.000.030	
② 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000
<b>Type 434.090.115.012</b>						
① 900.434.006.090		3			900.892.000.030	
② 900.254.050.010	5.0	T20	900.895.000.050	900.895.002.020		900.254.012.000

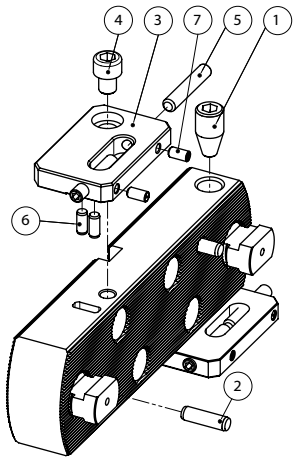


Ersatzteile / Zubehör

Spare parts / Accessories

504/514/534/544/554




Type 504/514/534/544/554	max. Nm	S	Torque key 	Bit 	Service key 
① 900.514.016.016					
② 900.515.006.015	8	5			900.892.000.050
③ 900.516.012.025	60	10			900.892.000.100
④ 900.500.028.015					
⑤ 900.500.005.025	5	4			900.892.000.040



Ersatzteile / Zubehör

Spare parts / Accessories

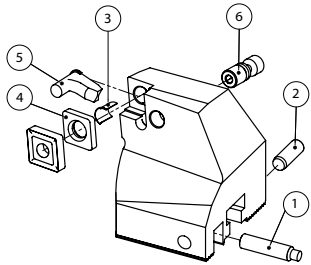
560/562/564

Type 560/564	max. Nm	S / Torx	Torque key 	Bit 	Service key 
① 900.560.016.030	50.0	8			900.892.000.080
② 900.560.008.028					
⑦ 900.560.006.012					
<b>Type 560.130.130/230.030</b>					
③ 900.560.080.012					
④ 900.560.110.012	35.0	8			900.892.000.080
⑤ 900.560.008.045		4			900.892.000.040
⑥ 900.560.006.014					
<b>Type 564.000.xxx.048 560.130.180/280-580. xxx</b>					
③ 900.560.080.012					
④ 900.560.110.018	35.0	8			900.892.000.080
⑤ 900.560.008.045		4			900.892.000.040
⑥ 900.560.006.014					

## Ersatzteile / Zubehör

## Spare parts / Accessories

570/580

Type  
570/580max.  
NmS /  
Torx

Torque key



Bit



Service key



①	900.570.008.035		4			900.892.000.040
②	900.570.008.024					

Type  
570.070.012.075

③	900.416.012.000					
④	900.417.012.000					
⑤	900.418.012.000					
⑥	900.419.012.000		3			900.892.000.030

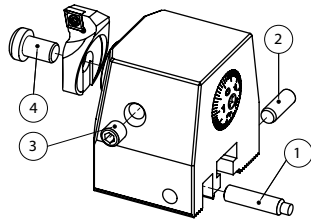
Type  
570/580.070.012.075

③	900.416.019.000					
④	900.417.019.000					
⑤	900.418.019.000					
⑥	900.419.019.000		3			900.892.000.030

## Ersatzteile / Zubehör

## Spare parts / Accessories

590/591/594

Type  
590/591.070.030.075max.  
NmS /  
Torx

Torque key



Bit



Service key



①	900.570.008.035		4			900.892.000.040
②	900.570.008.024					
③	900.590.010.020	8	5	900.895.000.057	900.895.001.050	900.892.000.050
④	900.314.010.016	35.0	8			900.892.000.080

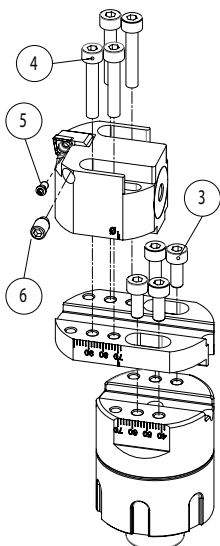
Type  
594.070.065.072

①	900.570.008.035		4			900.892.000.040
②	900.570.008.024					

## Ersatzteile / Zubehör

## Spare parts / Accessories

598

Type  
598.040.070.009max.  
NmS /  
Torx

Torque key



Bit



Service key



Service key



③	900.726.004.010	4.5	3	900.895.000.042	900.895.001.030	900.892.000.030	
④	900.726.004.025	4.5	3	900.895.000.042	900.895.001.030	900.892.000.030	
⑤	900.254.025.006	0.9	T7	900.895.000.009	900.895.002.007		900.254.007.000
⑥	900.598.005.008	1.2	2.5	900.895.000.010	900.895.001.025	900.892.000.025	



Torque key	Nm
900.895.000.006	0.6
900.895.000.009	0.9
900.895.000.010	1.0
900.895.000.012	1.2
900.895.000.018	1.8
900.895.000.022	2.2
900.895.000.030	3.0
900.895.000.038	3.8
900.895.000.042	4.2
900.895.000.050	5.0
900.895.000.057	5.7



Service key set	S
900.892.015.080	1.5 - 8
900.892.015.100	1.5-10



Service key	S
900.892.000.015	1.5
900.892.000.020	2
900.892.000.025	2.5
900.892.000.030	3
900.892.000.040	4
900.892.000.050	5
900.892.000.060	6
900.892.000.080	8
900.892.000.100	10
900.892.000.120	12
900.892.000.140	14



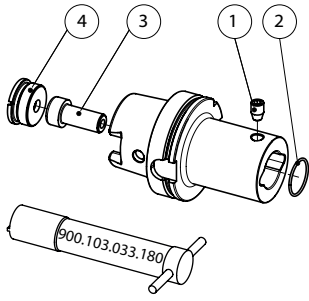
Torx bit	Tx
900.895.002.005	5
900.895.002.006	6
900.895.002.007	7
900.895.002.008	8
900.895.002.009	9
900.895.002.010	10
900.895.002.015	15
900.895.002.020	20



Hexagon bit	S
900.895.001.015	1.5
900.895.001.020	2
900.895.001.025	2.5
900.895.001.030	3
900.895.001.040	4
900.895.001.050	5
900.895.001.060	6
900.895.001.080	8



Torx key	Tx
900.254.006.000	6
900.254.007.000	7
900.254.009.000	15
900.254.012.000	20

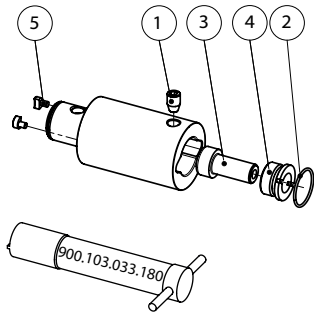


### Ersatzteile / Zubehör

### Spare parts / Accessories

144

Für ST For ST	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number
Für HSK A For HSK A	Klemmschraube / Clamping screw ①	O-Ring / O-ring ②	Zugschraube / Tension screw ③	Gewinding / Threaded ring ④
ST1	900.100.004.005	900.101.008.002		
ST2	900.100.005.006	900.101.011.002		
ST3	900.100.006.008	900.101.015.002		
ST4	900.100.008.011	900.101.019.002		
ST5	900.100.010.012	900.101.025.002		
ST6	900.100.012.018	900.101.032.002		
ST6+	900.100.012.018	900.101.032.002	900.102.018.040	
ST7+	900.100.020.029	900.101.043.002	900.102.024.045	
HSK A 63				900.104.030.014
HSK A 100				900.104.040.020

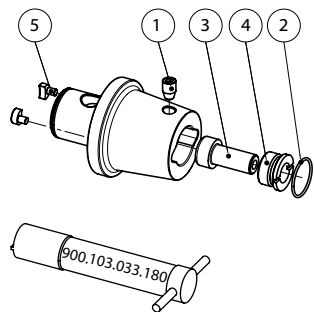


### Ersatzteile / Zubehör

### Spare parts / Accessories

164

Für ST For ST	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number
	Klemmschraube / Clamping screw ①	O-Ring / O-ring ②	Zugschraube / Tension screw ③	Gewinding / Threaded ring ④	Mitnehmer / Drive lug ⑤
ST1	900.100.004.005	900.101.008.002			900.102.020.000
ST2	900.100.005.006	900.101.011.002			900.102.025.000
ST3	900.100.006.008	900.101.015.002			900.102.032.000
ST4	900.100.008.011	900.101.019.002			900.102.039.000
ST5	900.100.010.012	900.101.025.002			900.102.050.000
ST6	900.100.012.018	900.101.032.002			900.102.064.000
ST6+	900.100.012.018	900.101.032.002	900.102.018.040	900.103.030.020	900.102.064.000
ST7+	900.100.020.029	900.101.043.002	900.102.024.045	900.103.040.020	900.102.090.000



### Ersatzteile / Zubehör

### Spare parts / Accessories

184

Für ST For ST	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number	Bestell-Nr. / Order number
	Klemmschraube / Clamping screw ①	O-Ring / O-ring ②	Zugschraube / Tension screw ③	Gewinding / Threaded ring ④	Mitnehmer / Drive lug ⑤
ST1	900.100.004.005	900.101.008.002			900.102.020.000
ST2	900.100.005.006	900.101.011.002			900.102.025.000
ST3	900.100.006.008	900.101.015.002			900.102.032.000
ST4	900.100.008.011	900.101.019.002			900.102.039.000
ST5	900.100.010.012	900.101.025.002			900.102.050.000
ST6+	900.100.012.018	900.101.032.002	900.102.018.040	900.103.030.020	900.102.064.000
ST7+					900.102.090.000

### Dimensionen

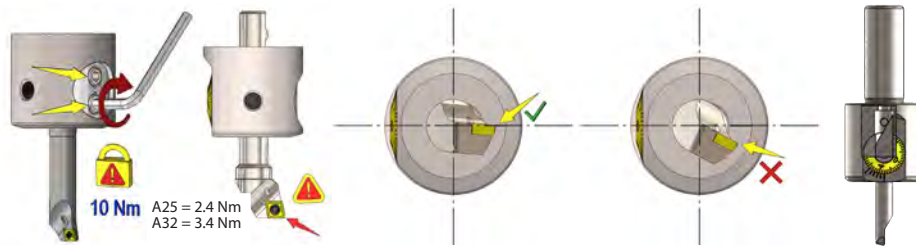
### Dimensions

ST	D	d1	L	M	Anzugsdrehmoment / Torque	Hex size	M1
ST1	20	11	13	M4x0.5	2.5Nm	2	
ST2	25	14	16	M5x0.5	3Nm	2.5	
ST3	32	18	20	M6x0.75	5Nm	3	
ST4	39	22	24	M8x0.75	10Nm	4	
ST5	50	28	30	M10x1	20Nm	5	
ST6/ST6+	64	36	40	M12x1	40Nm	6	M18x2
ST7+	90	46	50	M20x1.5	60Nm	10	M24x2

**INSTRUCTION MANUAL**  
**Ø 0.3 - 19.1 mm**



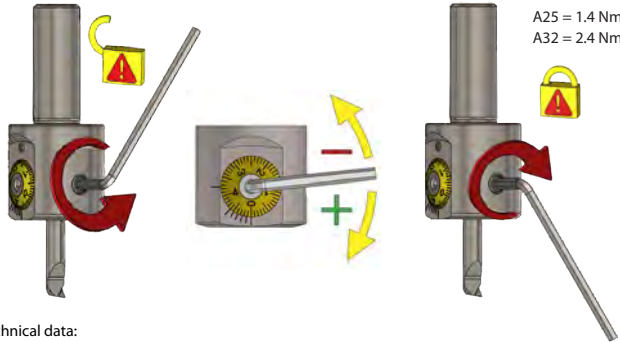
**assembling boring bar**



**10 Nm**

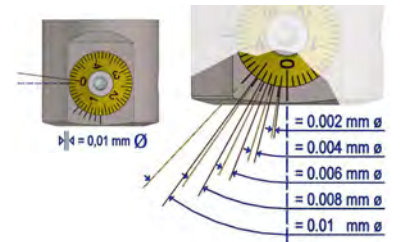
A25 = 2.4 Nm  
 A32 = 3.4 Nm

**diameter adjustment**



A25 = 1.4 Nm  
 A32 = 2.4 Nm

**scale / vernier**



**Technical data:**

**Boring range:** A25 Ø 0.3 - 7.1 mm  
 A32 Ø 0.3 - 19.1 mm

**Tool holder bore:** A25 Ø 4.0 mm  
 A32 Ø 7.0 mm

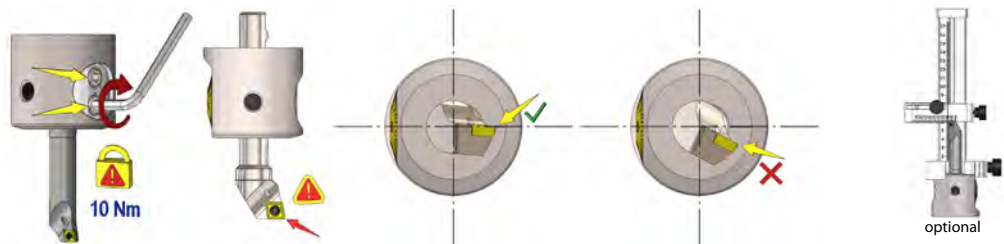
**Max. Spindle speed:** 30.000 rpm

**Adjustment range:** A25 -0.1 / + 3.0 mm Ø  
 A32 -0.1 / + 5.0 mm Ø

**INSTRUCTION MANUAL**  
**Ø 3.0 - 88.1 mm**

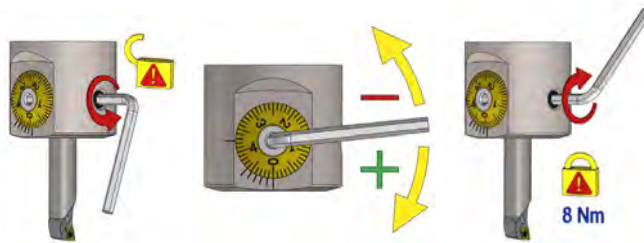


**assembling boring bar**



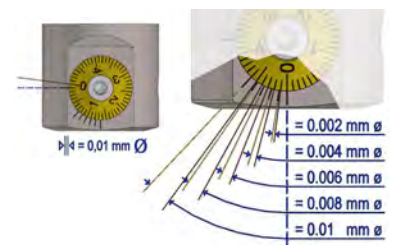
**10 Nm**

**diameter adjustment**



**8 Nm**

**scale / vernier**



**Max. revolution**

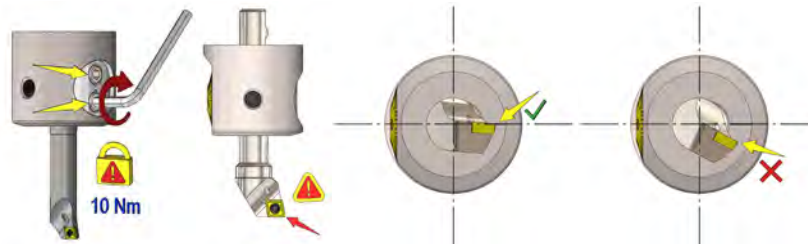




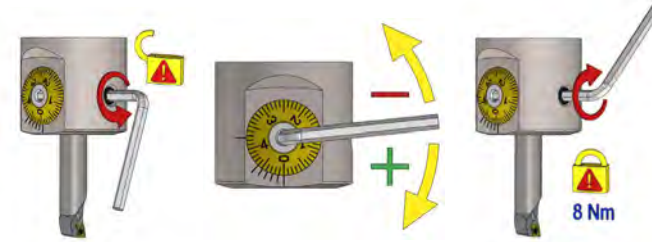
**INSTRUCTION MANUAL**  
Multi-Head Ø 3-320 mm



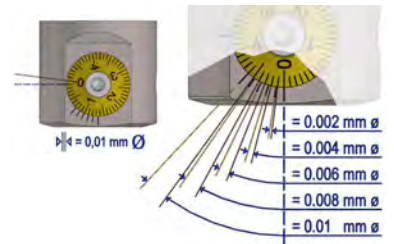
assembling boring bar



diameter adjustment



scale / vernier



Max. revolution

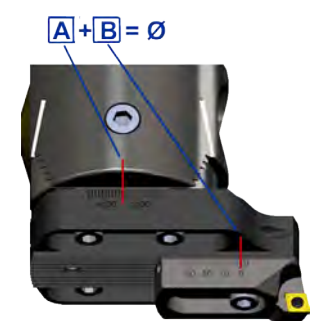
max. 1/min	Ø	max. 1/min
8.000	48 - 68 mm	2.500
12.000	20 - 48 mm	4.000
16.000	3 - 20 mm	6.000

Vmax 450 m/min (Ø88.0 - 164.0)  
Vmax 250 m/min (Ø164.0 - 320.0)

assembling Ø86-320mm



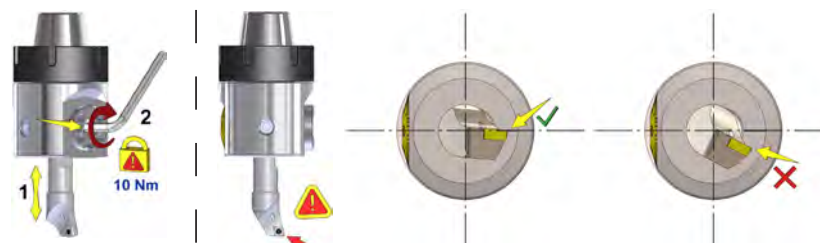
presetting scale



**INSTRUCTION MANUAL**  
VARIO HEAD Ø 3 - 152 mm



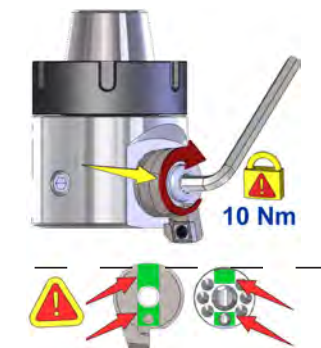
assembling boring bar



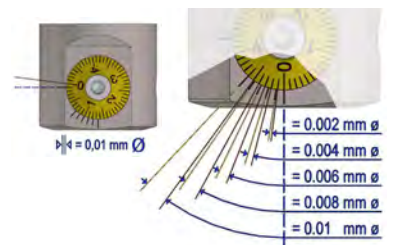
assembling coolant plug



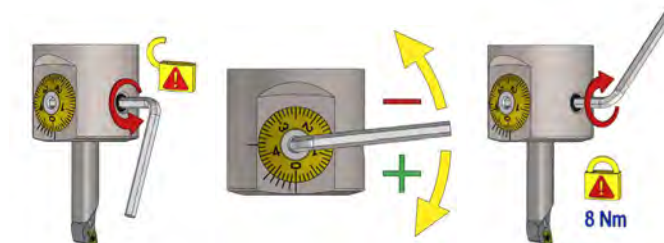
assembling insertholder



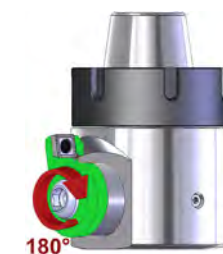
scale / vernier



diameter adjustment



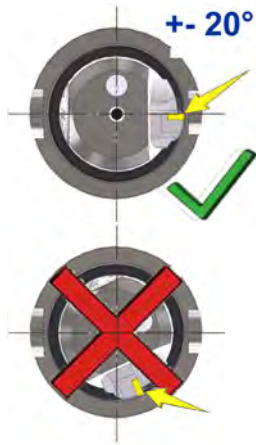
back boring



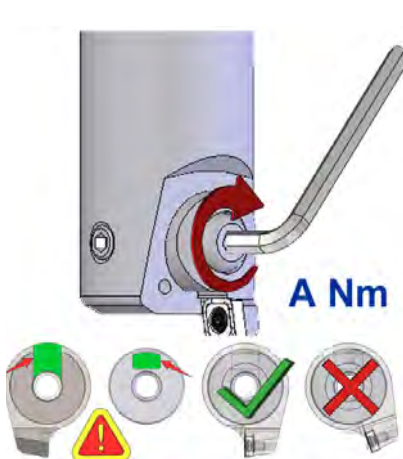
**FINE BORING HEAD**  
Ø 24 - 171 mm



**assembling boring head**



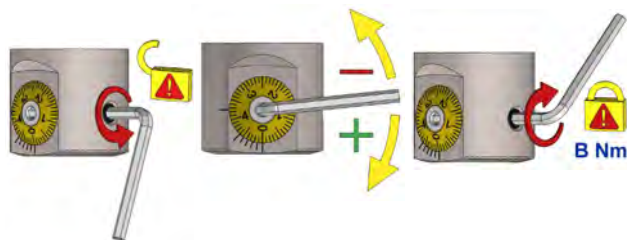
**assembling insertholder**



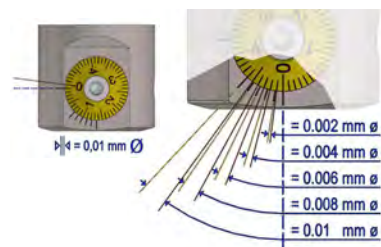
**back boring (requires a reversal adapter)**



**diameter adjustment**

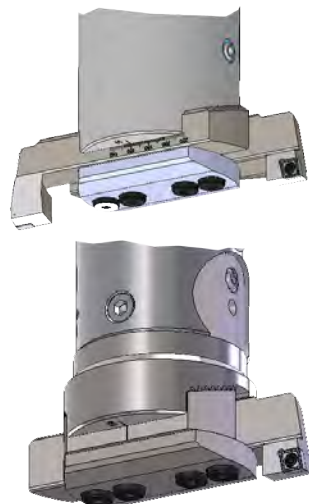


**scale / vernier**



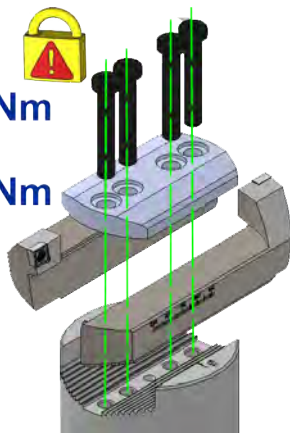
Fine boring head	Nm A	Nm B	max. rpm balanced	max. rpm unbalanced
D20 / Ø 24-31	2,4	1,2	12.000	9.000
D25 / Ø 31-40	3,4	1,4	10.000	7.500
D32 / Ø 40-51	5,0	2,4	8.000	5.250
D42 / Ø 51-67	10	4,0	6.500	4.000
D55 / Ø 67-87	20	8	5.000	3.000
D72 / Ø 87-116	20	8	4.000	2.500
D94 / Ø 116 - 171	20	8	3.000	1.750

**INSTRUCTION MANUAL**  
Fine + Rough boring head  
Ø 86 - 402 mm

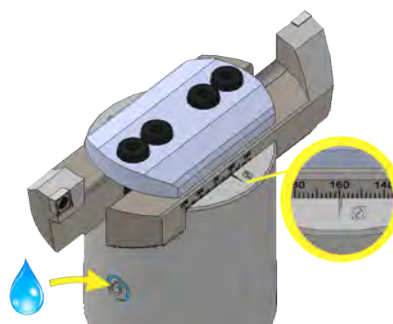


**assembling**

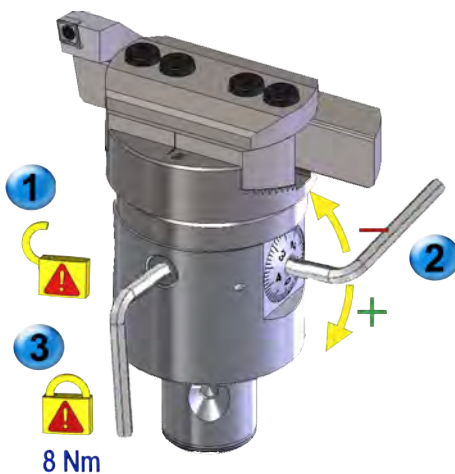
Ø86 - 138  
**2x 25Nm**  
< Ø136  
**4x 25Nm**



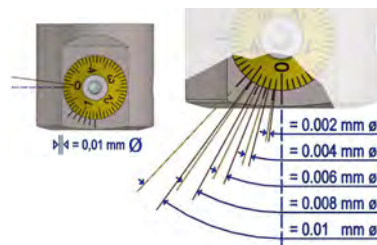
**pre adjustment / coolant**



**adjustment fine boring**

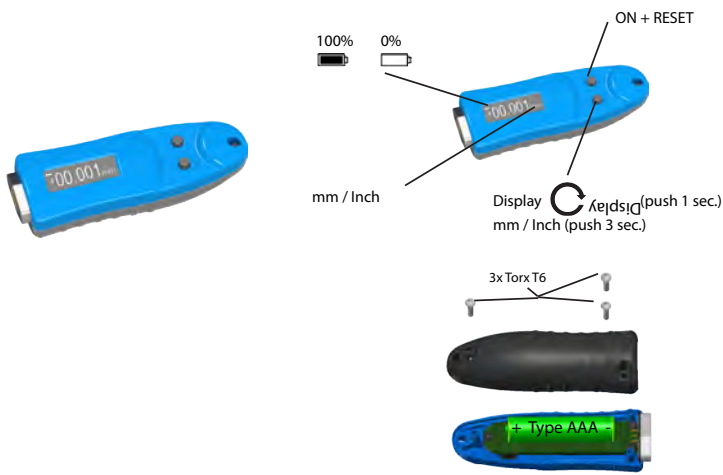


**scale / vernier**

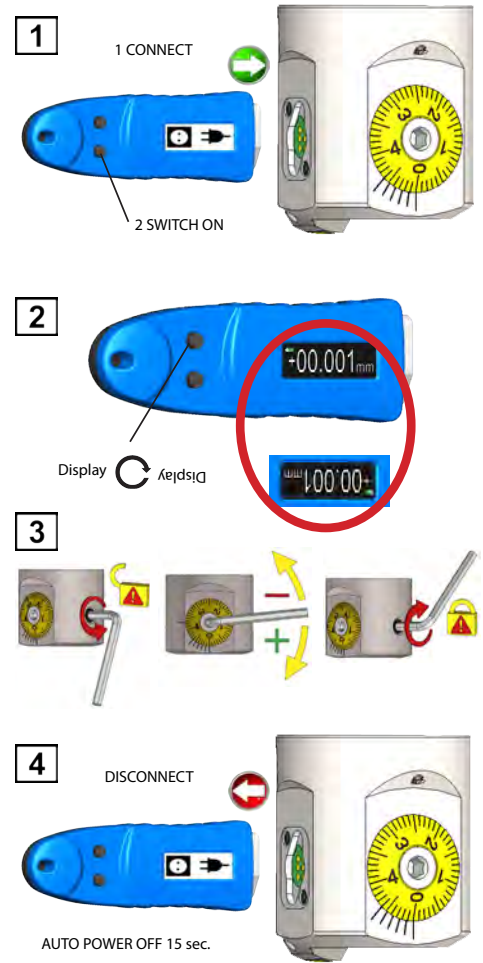


**Digital display unit**

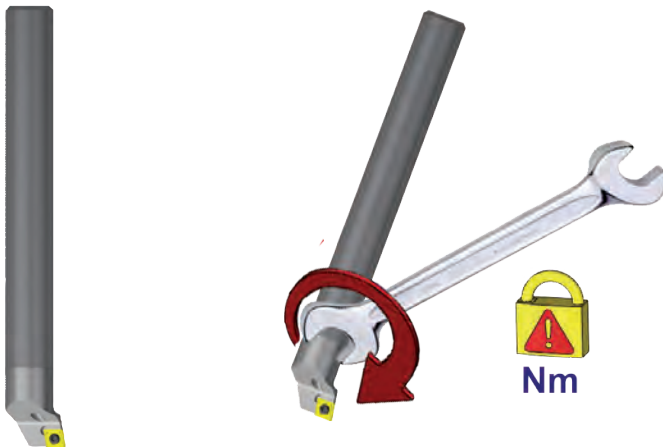
**Function / maintenance**



**Handling**



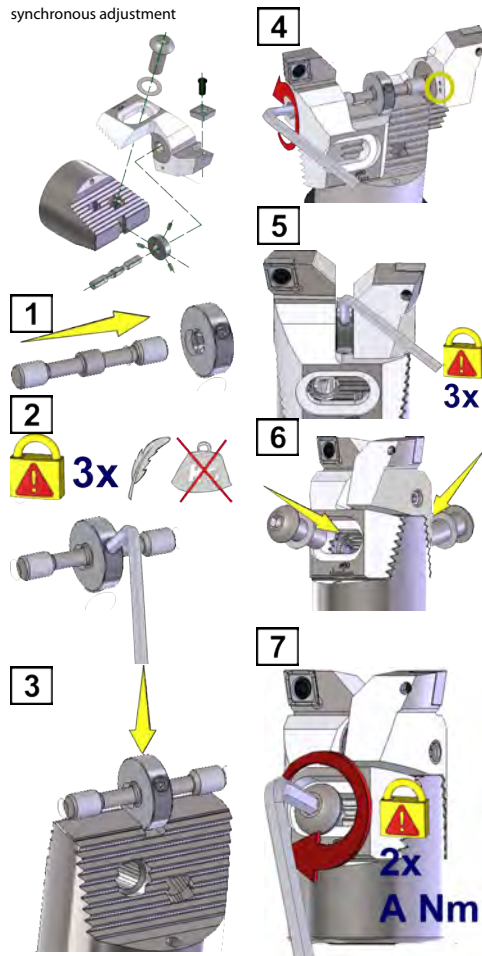
**assembling boring bar**



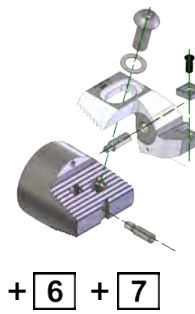
ø A min.	ø A max.	D	L	L1	Wendeplatte / Insert	M	SW	Nm
8.75	14.1	8	56	91	CC...06 02...	5	7	6
9.75	15.1	9	63	98	CC...06 02...	5	8	6
10.75	16.1	10	70	105	CC...06 02...	6	8	9
11.75	17.1	11	77	112	CC...06 02...	6	9	9
12.75	18.1	12	84	119	CC...06 02...	6	10	9
13.75	19.1	13	91	126	CC...06 02...	6	11	9
14.75	20.1	14	98	133	CC...06 02...	6	12	9
15.75	21.1	14	98	133	CC...06 02...	6	12	9
16.75	22.1	16	112	147	CC...06 02...	10	14	20
17.75	23.1	16	112	147	CC...06 02...	10	14	20
19.75	25.1	16	112	147	CC...06 02...	10	14	20
21.75	27.1	16	112	147	CC...06 02...	10	14	20
24.75	30.1	16	112	147	CC...06 02...	10	14	20
27.75	33.1	16	112	147	CC...06 02...	10	14	20
31.75	37.1	16	112	147	CC...06 02...	10	14	20
34.75	40.1	16	112	147	CC...06 02...	10	14	20

**ROUGH BORING HEAD**  
Ø 23 - 153 mm

assembling insertholder  
synchronous adjustment



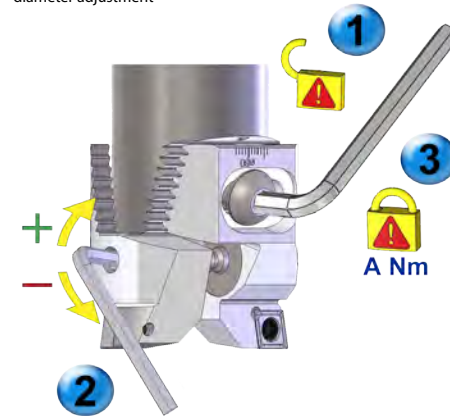
single adjustment



torque / revolution

Rough boring head	Nm A	max. rpm
D20 / Ø 23-31	2,4	12.000
D25 / Ø 31-40	5	10.000
D32 / Ø 40-51	9	8.000
D42 / Ø 51-67	20	6.500
D55 / Ø 67-87	35	5.000
D72 / Ø 87-116	35	4.000
D94 / Ø 116 - 153	35	3.000

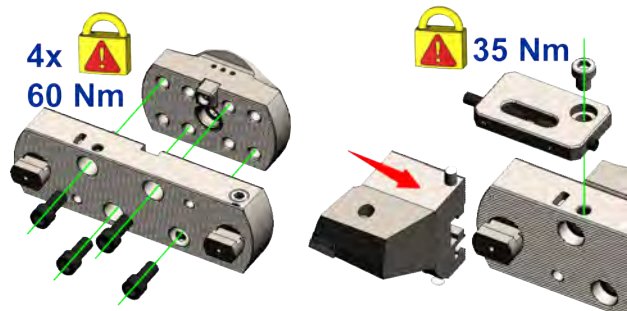
diameter adjustment



**INSTRUCTION MANUAL**  
**BRIDGE TOOLS Ø 150 - 655 mm**



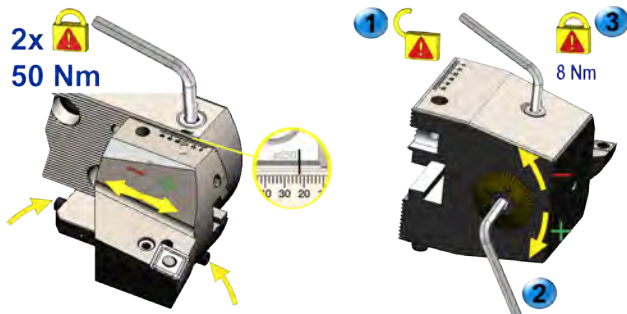
assembling



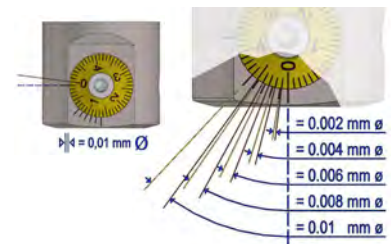
revolution

diameter	max. rpm
Ø150-205	1.250
Ø200-255	1.000
Ø250-305	850
Ø300-355	700
Ø350-405	600
Ø400-455	530
Ø450-505	480
Ø500-555	440
Ø550-605	400
Ø600-655	360

pre adjustment



scale / vernier



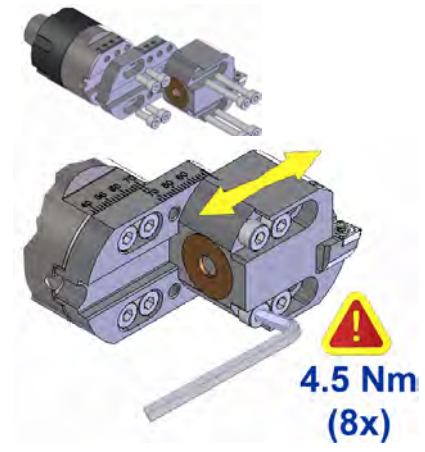
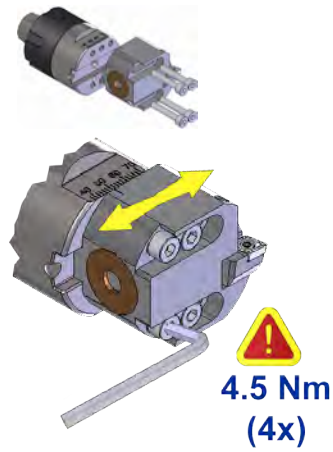
pin turning



**INSTRUCTION MANUAL  
ECO HEAD Ø 39.9 - 100.1 mm**

assembling rough adjustment Ø 39.9 - 70.1mm

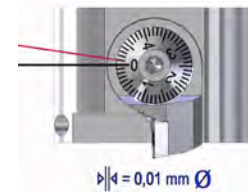
assembling rough adjustment Ø 69.9 - 100.1mm



diameter fine adjustment



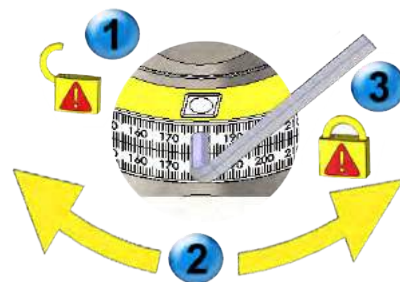
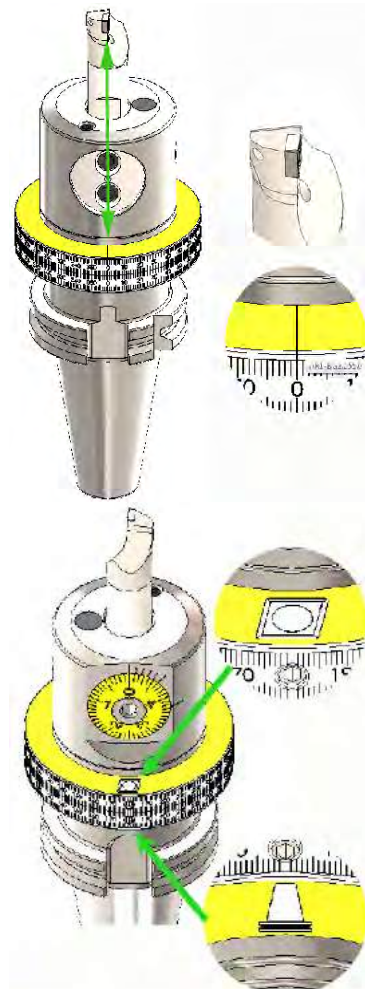
scale / vernier



maximum spindle speed

$V_{\text{max}} = 450 \text{ m/min } (\varnothing 40-70)$   
 $V_{\text{max}} = 250 \text{ m/min } (\varnothing 70-100)$

**Balancing ring**



**Auswuchttabelle / balancing chart**

Ausdrehkopf / fine boring head  
Bestellnummer / order number: 262.550.045  
Ausdrehkopf / boring bar  
Bestellnummer / order number:

Einstellwert am Auswuchtring / presetting value on the balancing ring

	0	1	2	3	4	5	6	7	8	9
272.010.006	10	103	284	11	81	290	12	84	291	13
272.012.006	12	104	285	13	81	291	14	84	292	15
272.014.006	14	104	290	15	81	291	16	83	292	17
272.015.006	15	105	287	18	82	292	17	83	293	18
272.016.006	16	107	299	17	82	293	18	83	294	19
272.018.006	18	108	301	19	83	294	20	83	295	21





**SWISS  TOOLS**<sup>®</sup> Swiss Tool Systems AG  
Wydenstrasse 28  
CH-8575 Bürglen  
Phone +41 (0)71 634 85 20  
Fax +41 (0)71 634 85 29  
[www.swisstools.org](http://www.swisstools.org)