



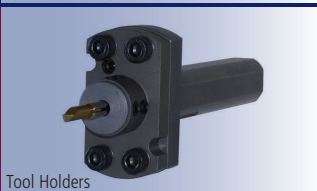
Ultramini



Minicut



System DED / System ZTP



Tool Holders



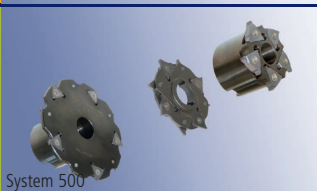
Broaching



Mikromill



Minimill



System 500



Swissline



ROTALINE

PRECISION BORING STARTING AT Ø 0.4 mm

Express Delivery Only Item

premium carbide cutting tools



Dümmel



rotaline

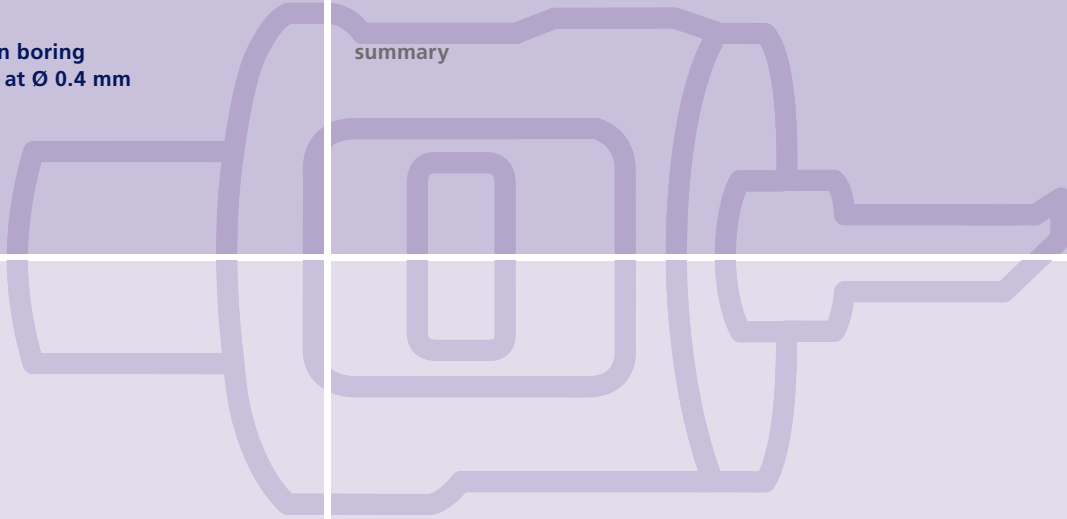


Precision boring starting at \varnothing 0.4 mm

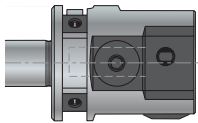
ROTALINE

precision boring
starting at Ø 0.4 mm

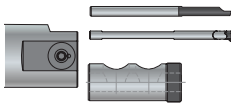
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carbide mini boring tool
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TIPP!

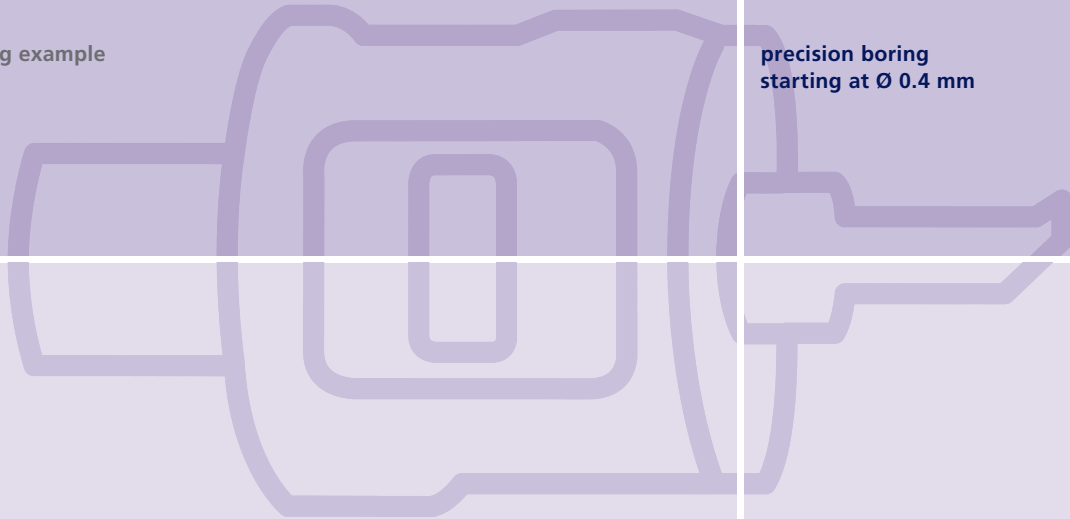
rotaline

ROTALINE

Ausspindeln
ab \varnothing 0.4 mm

machining example

precision boring
starting at \varnothing 0.4 mm



Dümmel
WERKZEUGFABRIK



You can now improve precision, quality and efficiency when finish boring smallest diameters. With our new, universal high speed precision boring tool with integrated digital display for boring operations from a diameter of 0.4 mm.

- Max. permissible speed of 35 000 min⁻¹
- Body diameter 40 mm
- Due to its small size this tool is ideally suited for compact machines from a spindle size of SK 30 or HSK 40.

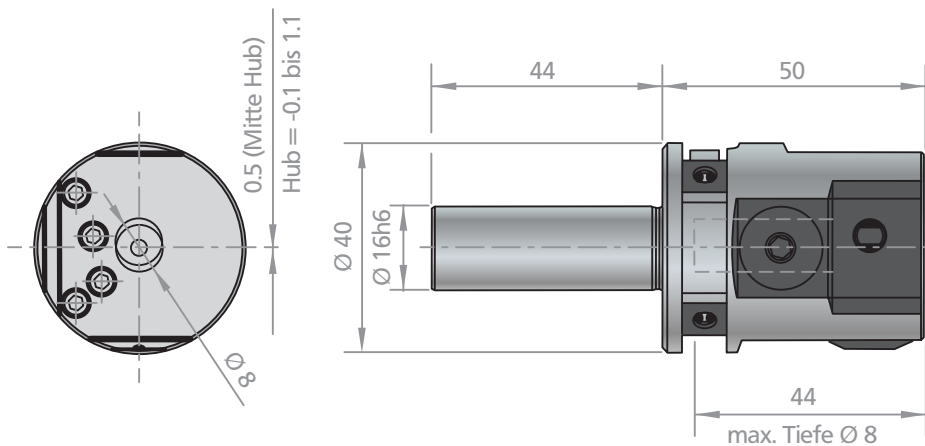
The tool is augmented by a complete range of accessories, which have been designed for this tool – flexible, efficient and extremely accurate.

Check out the performance of the high-speed tools for yourself – come and try us out!

ROTALINE

precision boring
starting at $\varnothing 0.4$ mm

characteristics



weight kg

boring range A

0.42

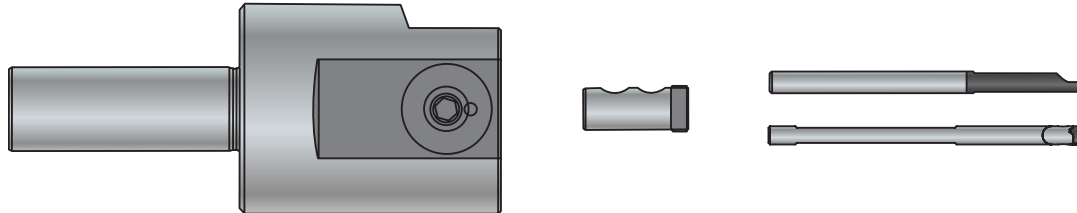
0.4 - 15

- Easiest possible handling thanks to digital display
- Feed-in accuracy 0.002 mm in diameter
- 1.2 mm radial stroke adjustment
- Continuously variable axially-adjustable cutting tools
- Automatically defined cutting edge position
- Cylindrical shaft for flexible applications
- Internal coolant supply for all accessory parts
- Manual precision balancing through balancing weights
- Protected against water and dust according to IP65

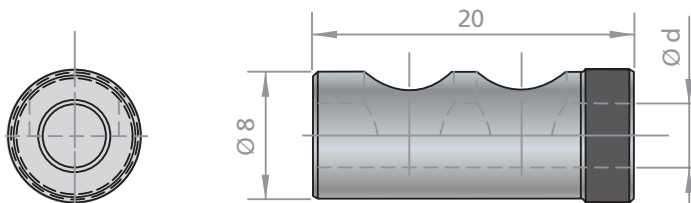
ROTALINE

configuration | reducing sleeves

precision boring
starting at $\varnothing 0.4$ mm



precision boring tool	reducing sleeve	mini boring tool	
ROTA-HSP0410	RB04-ROTA	ROTA04-020 R ROTA06-030 R ROTA08-040 R ROTA10-050 R ROTA15-075 R ROTA20-100 R ROTA25-125 R ROTA28-140 R ROTA35-180 R ROTA40-200 R	
	RB05-ROTA	ROTA50-255 R	
	RB06-ROTA	ROTA60-320 R	
	RB07-ROTA	ROTA70-405 R	
	—	ROTA80-505 R	
	RB06-ROTA	V08.006.4 HM	RS08.1846.02
		V11.008.4 HM	RS11.1855.02 RS11.1867.02



part number	d		
RB04-ROTA	4		
RB05-ROTA	5		
RB06-ROTA	6		
RB07-ROTA	7		

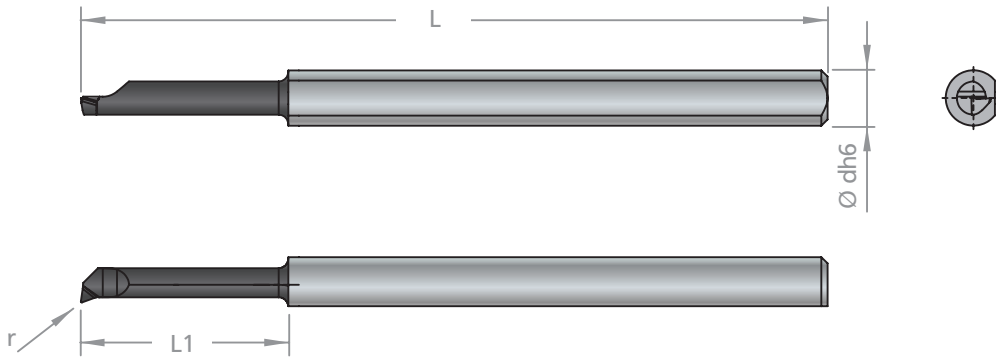


ROTALINE

precision boring
starting at Ø 0.4 mm

carbide mini boring tool

bore Ø from 0.4 – 10.4 mm



part number

D min.

d h6

L

L1

r

basic version

ROTA04-020 R	0.4	4	42.0	2.0	0.03
ROTA06-030 R	0.6	4	43.0	3.0	0.04
ROTA08-040 R	0.8	4	44.0	4.0	0.04
ROTA10-050 R	1.0	4	45.0	5.0	0.05
ROTA15-075 R	1.5	4	47.5	7.5	0.05
ROTA20-100 R	2.0	4	50.0	10.0	0.05
ROTA25-125 R	2.5	4	52.5	12.5	0.05
ROTA28-140 R	2.8	4	54.0	14.0	0.07
ROTA35-180 R	3.5	4	58.0	18.0	0.10
ROTA40-200 R	4.0	4	60.0	20.0	0.10
ROTA50-255 R	5.0	5	66.0	25.5	0.12
ROTA60-320 R	6.0	6	75.0	32.0	0.15
ROTA70-405 R	7.0	7	82.0	40.5	0.20
ROTA80-505 R	8.0	8	92.0	50.5	0.20

AL41F

XC2A-NH

AL41F
XC2A-NH

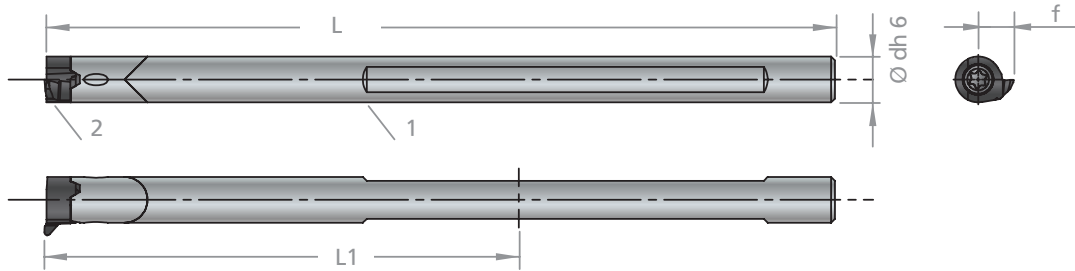
basic version
for hard machining up to 66 HRC

ROTALINE

carbide mini boring tool

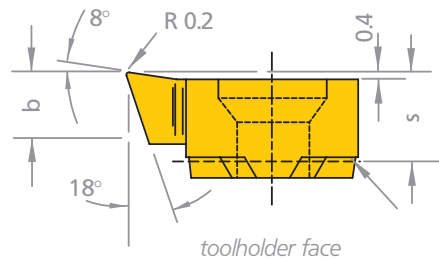
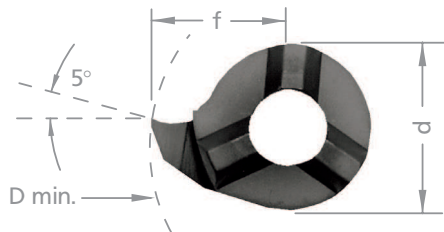
bore Ø from 9.3 – 15.8 mm

precision boring
starting at Ø 0.4 mm



1

part number	D min.	D max.	d h6	L	L1 min.	L1 max.	insert
V08.0006.4 HM	9.3	11.7	6	103	58	73	RS08
V11.0008.4 HM	11.0	15.8	8	129	84	100	RS11



state right (R) version

dimensions in mm

2

part number	D min.	D max.	b	f	s	d	Ap max.*
RS08.1846.02	9.3	11.7	3.30	4.65	3.5	6	0.6
RS11.1855.02	11.0	13.4	3.90	5.50	4.2	8	1.0
RS11.1867.02	13.4	15.8	3.90	6.70	4.2	8	1.0

* Ap. max = maximum depth of cut (depending on material)

Attention: cutting edge has to face towards the clamp screw!

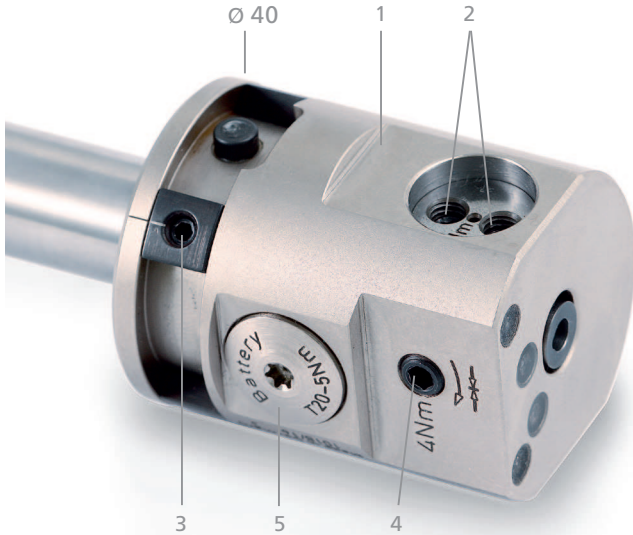
Over diameter 12 mm reduce cutting data about 30%!

order-example:
righthand version and grade AL41F:
RS08.1846.02/AL41F

ROTALINE

precision boring
starting at Ø 0.4 mm

spare parts / max. rpm



spare parts

part number	key	number	moment Nm
1	ROTA-HSP0410		
2	ROTA-M5	T-Schlüssel SW2.5 DS SW25	3
3	ROTA-M4	T-Schlüssel SW2 DS SW20	2.5
4	ROTA-M6	T-Schlüssel SW3 DS SW30	4
5	ROTA-DCK ROTA-DIC	Torx T20 TORX T20F	5

max. rpm

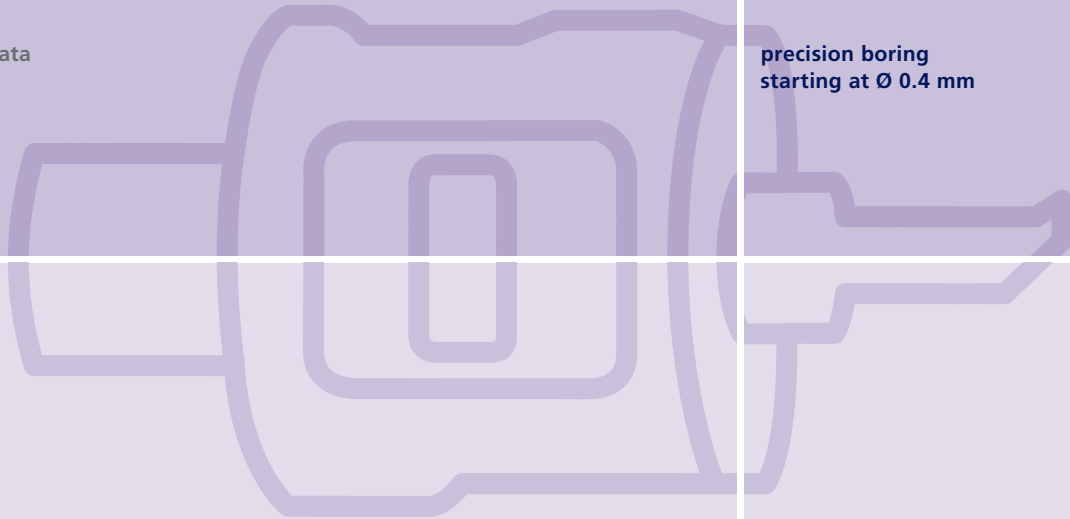
boring range Ø mm	length	max. rpm (1/min)
0.4 - 6.0	max.	35.000
6.0 - 12.0	< 5x shank-Ø	35.000
6.0 - 12.0	< 5x shank-Ø	25.000

ROTALINE



cutting data

precision boring
starting at Ø 0.4 mm



	machining material	boring range	cutting speeds Vc = m/min	feed
	steel unalloyed	0.4 - 1.0	30 - 100	0.01 - 0.02
		1.0 - 8.0	60 - 180	0.02 - 0.06
	steel alloyed	0.4 - 1.0	30 - 100	0.01 - 0.02
		1.0 - 8.0	60 - 150	0.02 - 0.06
	steel high alloyed	0.4 - 1.0	30 - 100	0.01 - 0.02
		1.0 - 8.0	60 - 120	0.02 - 0.06
	steel stainless	0.4 - 1.0	30 - 80	0.01 - 0.02
		1.0 - 8.0	40 - 130	0.02 - 0.06
	cast iron	0.4 - 1.0	30 - 100	0.01 - 0.02
		1.0 - 8.0	50 - 170	0.02 - 0.06
	spheroidal graphite cast iron	0.4 - 1.0	30 - 100	0.01 - 0.02
		1.0 - 8.0	50 - 170	0.02 - 0.06
	aluminium alloy, long-chipped	0.4 - 1.0	40 - 200	0.01 - 0.02
		1.0 - 8.0	180 - 600	0.02 - 0.06
	aluminium alloy, short-chipped	0.4 - 1.0	40 - 200	0.01 - 0.02
		1.0 - 8.0	180 - 600	0.02 - 0.06
	high temperature alloy	0.4 - 1.0	20 - 60	0.01 - 0.02
		1.0 - 8.0	30 - 80	0.02 - 0.06
	hardend steel to 66 HRC	0.4 - 1.0	50 - 100	0.01 - 0.02
		1.0 - 8.0	50 - 100	0.02 - 0.06

