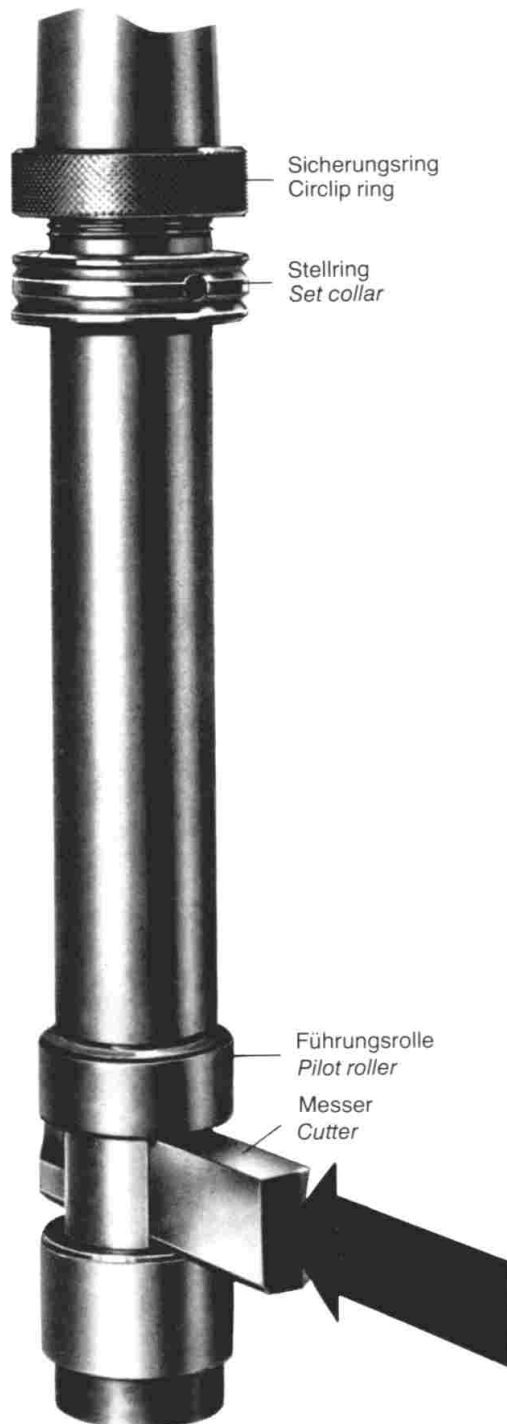


GFS - Backspotfacing System RSQ for small-lot production



The GFS back spotfacing system, type RSQ, is a heavy-duty, simple tool with rapid payback and extremely inexpensive owing to the interchangeability of the proven GFS cutters and guide rollers. It consists of a holder, circlip, set collar, guide roller and cutter. Suitable for use on all modern machine tools with taper shanks (MK) and holdback key slots to DIN 1806 or draw-in thread to DIN 228 A.

Advantages :

- 1) Simple cutter change by adjusting the set collar without any need for a tool
- 2) Usually functional even without adjusting the circlip
- 3) Standard versions consisting of Weldon shank, morse taper shank and shank with receiver thread, each in 5 sizes from 18 mm / 0.710'' - 4.330''.
- 4) The Size 01 boring bar is supplied with a 12 mm / 0.4724'' receiver shaft (Weldon). Also supplied as standard is a 15 mm / 0.5906'' diameter, ground ring that keeps the cutter level and also serves as a guide roller forwards.

The boring bar is easy to handle and no special tools are required. Within a single holder size, any cutter can be combined with any guide roller, thus covering a wide range of pilot bore and spotfacing diameters.

Should you require a fully automatic back spotfacing system for use on CNC machines, we recommend our patented RASMUC back spotfacing system.

GFS - Backspotfacing System RSQ for small-lot production

Different boring bar versions for all machine types are available :

Size 01 :	Weldon 12 mm / 0.4724''
Size 0 :	Weldon 25 mm / 0.9843'', MT3 and MT3 A
Size 1 :	Weldon 32 mm / 1.2598'', MT4 and MT4 A
Size 2 :	Weldon 32 mm / 1.2598'', MT4 and MT4 A
Size 3 :	Weldon 32 mm / 1.2598'', MT4 and MT4 A

The cutters are produced in the following versions :

- | | | |
|----------------|---|---|
| Type A | : | for pilot boring, point angle 164° (Size 01 120°)
High-Speed-Steel (Cobalt Alloy) |
| Type B | : | for spotfacing, point angle 180°
High-Speed-Steel (Cobalt Alloy) |
| Type HM | : | for spotfacing, point angle 180°
brazed carbide , for hard and brittle
materials (grey cast iron, brass) |
| Type WP | : | for spotfacing, point angle 180°
with reversible carbide tips, for small
lot production on machines with
powerful drives |

<i>Size</i>	<i>Diameter Range</i>	<i>A</i>	<i>B</i>	<i>HM</i>	<i>WP</i>
01	18 mm - 30 mm / 0.700'' - 1.180''	x	x	x	-
0	32 mm - 50 mm / 1.260'' - 2.000''	x	x	x	*
1	50 mm - 70 mm / 2.000'' - 2.760''	x	x	x	*
2	65 mm - 92 mm / 2.560'' - 3.620''	x	x	x	*
3	80 mm - 110mm / 3.150'' - 4.330''	x	x	x	*

x = from stock * = short time delivery - = not available

TiN-coated cutters are available at short notice

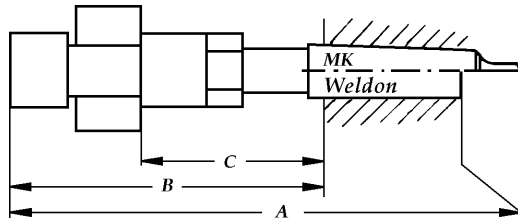
Rückwärtssenkensystem RSQ
Sistema di allargatura a ritroso

Backspotfacing System RSQ
Système de fraisage arrière

Größe 01 - Size 01 - Misura 01 - Dimension 01

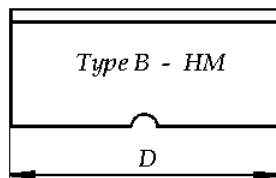
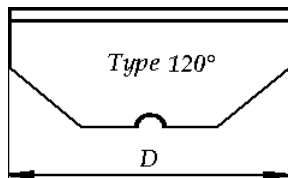
Bohrstange - Boring bar - Barra alesatrice - Porte-outil

Größe - Size	Bereich - Range	A	B	C	Art. No.
01 / Weldon Ø 12 mm	18 mm - 30 mm	203	155	95	203340



Messer - Cutters - Coltelli - Couteaux

Ø mm	Type B HSS/E Art.No.	Type B TIN Art.No.	Type B HM Art.No.	Type 120° Art.No.	Type 120° TIN Art.No.
18	203018	207018	204018	205018	206018
19	203019	207019	204019	205019	206019
20	203020	207020	204020	205020	206020
21	203021	207021	204021	205021	206021
22	203022	207022	204022	205022	206022
23	203023	207023	204023	205023	206023
24	203024	207024	204024	205024	206024
25	203025	207025	204025	205025	206025
26	203026	207026	204026	205026	206026
27	203027	207027	204027	205027	206027
28	203028	207028	204028	205028	206028
29	203029	207029	204029	205029	206029
30	203030	207030	204030	205030	206030



4,3 mm x 13 mm x D

Führungsrolle rückwärts - Pilot roller backward - Rullo di guida ritrosa - Rouleau de guidage arrière

Ø mm	Art. No.	Ø mm	Art. No.	Ø mm	Art. No.
15	603015	19	603019	23	603023
16	603016	20	603020	24	603024
17	603017	21	603021	25	603025
18	603018	22	603022		

Rückwärtssenkensystem RSQ
Sistema di allargatura a ritroso

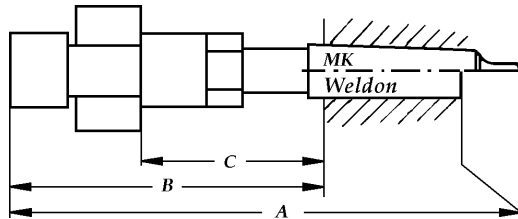
Backspotfacing System RSQ
Système de fraisage arrière

Größe 0 - Size 0 - Misura 0 - Dimension 0

Bohrstange - Boring bar - Barra alesatrice - Porte-outil

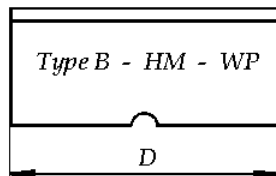
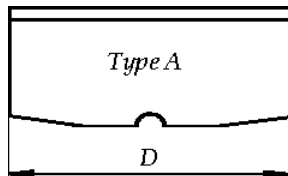
Größe - Size	Bereich - Range	A	B	C	Art. No.
0 / MK3 (MT3)	32 mm - 50 mm	313	182	138,5	203310
0 / MK3 (MT3) "A"	32 mm - 50 mm	302	182	138,5	200300
Weldon 25	32 mm - 50 mm	270	182	138,5	200600

"A" = Anzugsgewinde - Fastening thread - Filettatura di fissaggio - DIN 228A



Messer - Cutters - Coltelli - Couteaux

Ø mm	Type A HSS/E Art.No.	Type A TIN Art.No.	Type B HSS/E Art.No.	Type B TIN Art.No.	Type HM Art.No.	Type WP Art.No.
32	301032	306032	401032	406032	402032	405032
33	301033	306033	401033	406033	402033	405033
34	301034	306034	401034	406034	402034	405034
35	301035	306035	401035	406035	402035	405035
36	301036	306036	401036	406036	402036	405036
37	301037	306037	401037	406037	402037	405037
38	301038	306038	401038	406038	402038	405038
39	301039	306039	401039	406039	402039	405039
40	301040	306040	401040	406040	402040	405040
41	301041	306041	401041	406041	402041	405041
42	301042	306042	401042	406042	402042	405042
43	301043	306043	401043	406043	402043	405043
44	301044	306044	401044	406044	402044	405044
45	301045	306045	401045	406045	402045	405045
46	301046	306046	401046	406046	402046	405046
47	301047	306047	401047	406047	402047	405047
48	301048	306048	401048	406048	402048	405048
49	301049	306049	401049	406049	402049	405049
50	301050	306050	401050	406050	402050	405050



8 mm x 18 mm x D

Führungsrolle rückwärts - Pilot roller backward - Rullo di guida ritrosa - Rouleau de guidage arrière

Ø mm	Art. No.	Ø mm	Art. No.	Ø mm	Art. No.
22	608022	25	608025	28	608028
23	608023	26	608026	29	608029
24	608024	27	608027	30	608030

Rückwärtssenkensystem RSQ
Sistema di allargatura a ritroso

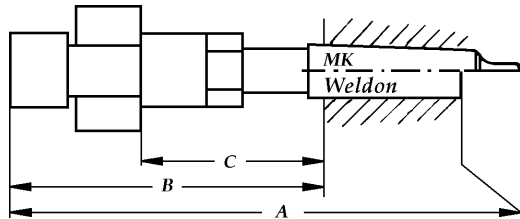
Backspotfacing System RSQ
Système de fraisage arrière

Größe 1 - Size 1 - Misura 1 - Dimension 1

Bohrstange - Boring bar - Barra alesatrice - Porte-outil

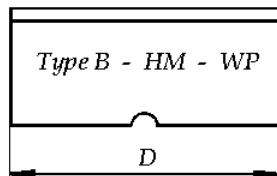
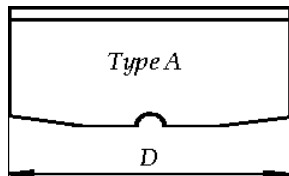
Größe - Size	Bereich - Range	A	B	C	Art. No.
1 / MK4 (MT4)	50 mm - 70 mm	348	192	140,5	213410
1 / MK4 (MT4) "A"	50 mm - 70 mm	333	192	140,5	210400
Weldon 32	50 mm - 70 mm	284	192	140,5	210600

"A" = Anzugsgewinde - Fastening thread - Filettatura di fissaggio - DIN 228A



Messer - Cutters - Coltelli - Couteaux

Ø mm	Type A HSS/E Art.No.	Type A TIN Art.No.	Type B HSS/E Art.No.	Type B TIN Art.No.	Type HM Art.No.	Type WP Art.No.
50	311050	316050	411050	416050	412050	415050
51	311051	316051	411051	416051	412051	415051
52	311052	316052	411052	416052	412052	415052
53	311053	316053	411053	416053	412053	415053
54	311054	316054	411054	416054	412054	415054
55	311055	316055	411055	416055	412055	415055
56	311056	316056	411056	416056	412056	415056
57	311057	316057	411057	416057	412057	415057
58	311058	316058	411058	416058	412058	415058
59	311059	316059	411059	416059	412059	415059
60	311060	316060	411060	416060	412060	415060
61	311061	316061	411061	416061	412061	415061
62	311062	316062	411062	416062	412062	415062
63	311063	316063	411063	416063	412063	415063
64	311064	316064	411064	416064	412064	415064
65	311065	316065	411065	416065	412065	415065
66	311066	316066	411066	416066	412066	415066
67	311067	316067	411067	416067	412067	415067
68	311068	316068	411068	416068	412068	415068
69	311069	316069	411069	416069	412069	415069
70	311070	316070	411070	416070	412070	415070



10 mm x 20 mm x D

Führungsrolle rückwärts - Pilot roller backward - Rullo di guida ritrosa - Rouleau de guidage arrière

Ø mm	Art.No.	Ø mm	Art.No.	Ø mm	Art.No.
30	618030	34	618034	38	618038
31	618031	35	618035	39	618039
32	618032	36	618036	40	618040
33	618033	37	618037		

Rückwärtssenkensystem RSQ
Sistema di allargatura a ritroso

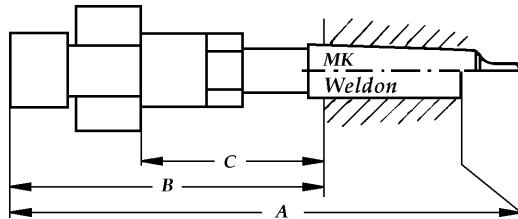
Backspotfacing System RSQ
Système de fraisage arrière

Größe 2 - Size 2 - Misura 2 - Dimension 2

Bohrstange - Boring bar - Barra alesatrice - Porte-outil

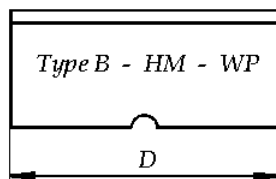
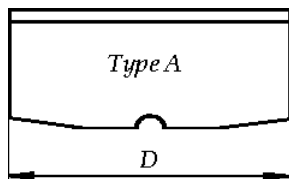
Größe - Size	Bereich - Range	A	B	C	Art. No.
2 / MK4 (MT4)	65 mm - 92 mm	396	240	176,5	223410
2 / MK4 (MT4) "A"	65 mm - 92 mm	381	240	176,5	220400
Weldon 32	65 mm - 92 mm	332	240	176,5	220600

"A" = Anzugsgewinde - Fastening thread - Filettatura di fissaggio - DIN 228A



Messer - Cutters - Coltelli - Couteaux

Ø mm	Type A HSS/E Art.No.	Type A TIN Art.No.	Type B HSS/E Art.No.	Type B TIN Art.No.	Type HM Art.No.	Type WP Art.No.
65	321065	326065	421065	426065	422065	425065
66	321066	326066	421066	426066	422066	425066
68	321068	326068	421068	426068	422068	425068
70	321070	326070	421070	426070	422070	425070
72	321072	326072	421072	426072	422072	425072
74	321074	326074	421074	426074	422074	425074
75	321075	326075	421075	426075	422075	425075
76	321076	326076	421076	426076	422076	425076
78	321078	326078	421078	426078	422078	425078
80	321080	326080	421080	426080	422080	425080
82	321082	326082	421082	426082	422082	425082
84	321084	326084	421084	426084	422084	425084
85	321085	326085	421085	426085	422085	425085
86	321086	326086	421086	426086	422086	425086
88	321088	326088	421088	426088	422088	425088
90	321090	326090	421090	426090	422090	425090
92	321092	326092	421092	426092	422092	425092



11 mm x 28 mm x D

Führungsrolle rückwärts - Pilot roller backward - Rullo di guida ritrosa - Rouleau de guidage arrière

Ø mm	Art.No.	Ø mm	Art.No.	Ø mm	Art.No.
34	628034	38	628038	42	628042
35	628035	39	628039	43	628043
36	628036	40	628040	44	628044
37	628037	41	628041	45	628045

Rückwärtssystem RSQ
Sistema di allargatura a ritroso

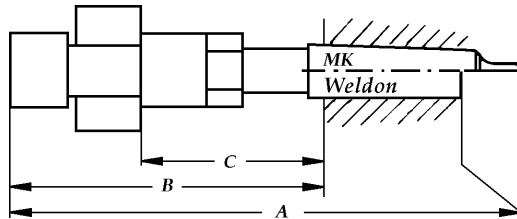
Backspotfacing System RSQ
Système de fraisage arrière

Größe 3 - Size 3 - Misura 3 - Dimension 3

Bohrstange - Boring bar - Barra alesatrice - Porte-outil

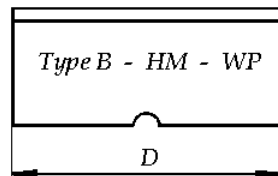
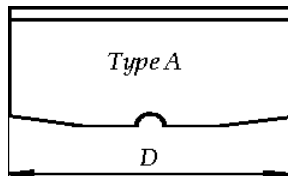
Größe - Size	Bereich - Range	A	B	C	Art. No.
3 / MK4 (MT4)	80 mm - 110 mm	432	276	203,5	233410
3 / MK4 (MT4) "A"	80 mm - 110 mm	417	276	203,5	230400
Weldon 32	80 mm - 110 mm	368	276	203,5	230600

"A" = Anzugsgewinde - Fastening thread - Filettatura di fissaggio - DIN 228A



Messer - Cutters - Coltelli - Couteaux

Ø mm	Type A HSS/E Art.No.	Type A TIN Art.No.	Type B HSS/E Art.No.	Type B TIN Art.No.	Type HM Art.No.	Type WP Art.No.
80	331080	336080	431080	436080	432080	435080
82	331082	336082	431082	436082	432082	435082
84	331084	336084	431084	436084	432084	435084
85	331085	336085	431085	436085	432085	435085
86	331086	336086	431086	436086	432086	435086
88	331088	336088	431088	436088	432088	435088
90	331090	336090	431090	436090	432090	435090
92	331092	336092	431092	436092	432092	435092
94	331094	336094	431094	436094	432094	435094
95	331095	336095	431095	436095	432095	435095
96	331096	336096	431096	436096	432096	435096
98	331098	336098	431098	436098	432098	435098
100	331100	336100	431100	436100	432100	435100
102	331102	336102	431102	436102	432102	435102
104	331104	336104	431104	436104	432104	435104
105	331105	336105	431105	436105	432105	435105
106	331106	336106	431106	436106	432106	435106
108	331108	336108	431108	436108	432108	435108
110	331110	336110	431110	436110	432110	435110



14 mm x 32 mm x D

Führungsrolle rückwärts - Pilot roller backward - Rullo di guida ritrosa - Rouleau de guidage arrière

Ø mm	Art.No.	Ø mm	Art.No.	Ø mm	Art.No.	Ø mm	Art.No.
40	638040	44	638044	48	638048	52	638052
41	638041	45	638045	49	638049	53	638053
42	638042	46	638046	50	638050	54	638054
43	638043	47	638047	51	638051	55	638055