



M03 Speed

Micro-adjustable head
 \varnothing 24,8 to $> \varnothing$ 206 mm

Modular tool

$> \varnothing$ 206 mm

Lightweight adaptor

Mo3Speed



Micro-adjustable drilling head **M03Speed**

High-precision fine adjustment with balancing

- The demands on fine boring tools are primarily increasing improvements to surface finishes and at the same time higher cutting speeds for short machining times.
- Fine machining is a demanding bore machining operation. With M03 micro-adjustable heads KOMET has provided a tried and tested tool system which, with its high precision adjustment mechanism, from the rough adjustment for the rotating clamping holder to the graduation collar on the external diameter, allows fine adjustment steps of up to 0.002 millimeters in the diameter.
- The fine adjustment for wear compensation or after measurement is then carried out extremely accurately directly on the machine spindle. There is no need for clamping during and after this fine adjustment, which means that the dimension can be perfectly maintained.
- Balancing: when the insert position is changed, there is an automatic balancing adjustment by means of a moveable balancing weight which lies diametrically opposite. This is a balancing operation on the adjustment plane for the insert.
- This is based on six tool bodies to cover diameters from 24.8 to 206 millimeters. Maximum changeover accuracy is guaranteed with ABS connections (25, 32, 40, 50 and 63).
- Diameters from 38 to 206 are provided for by means of three adaptable and replaceable bridges.
- Just like the whole production range, the bridges - which are in a lightweight material with a hard surface coating - allow high machining speeds to be achieved.
- Flexibility with replaceable insert

holders: the replaceable insert holders are special feature of the new product range.

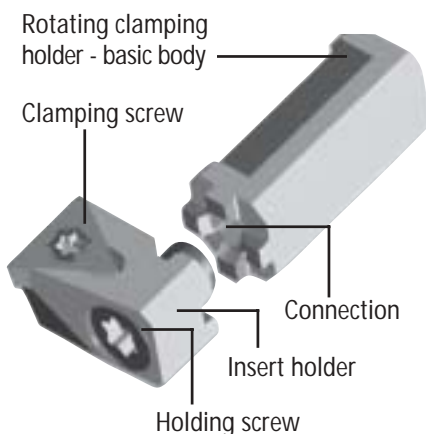
- The user has the facility to carry out forward and reverse machining with one tool with different approach angles. Using a specially designed connection, the changeover is fast, uncomplicated and safe.

The modular tool range

- For diameters over 206 millimeters KOMET offers bridging tools.
- In a modular design, these consist of standard elements and elements adjusted to length to customer specification.

Advantages

- Unique: our micro-adjustable head with automatic balancing in the slide.
- Micro-adjustment steps per graduation of 0.002 mm in the diameter.
- Geometrically the same as previous M03 design – and therefore compatible.
- Micro-adjustment without the need for clamping.



Design

Adjusting screw for coarse adjustment of insert holder

Holding screw for clamping holder

Slide with weight compensation

Clamping screw

Insert holder with KOMET geometry

Internal coolant directed onto insert

All scales have matt chrome finish

High resolution gives easy read-off **without** vernier

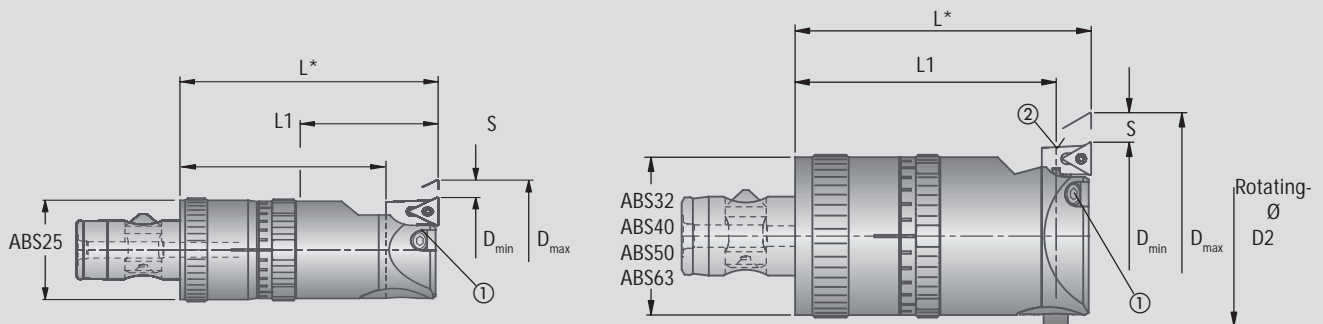
ABS connection for maximum changeover accuracy



Micro-adjustable drilling head **MO3Speed**

with ABS® connection

Ø 24,8 – 103,0 mm



¹⁾Note: Up to 25.5 mm diameters, the effective length corresponds to tool length L.

*dimension L see insert holder table on following pages

Order No.	ABS d	D _{min}	D _{max}	Rotating-Ø D2	L1	Coarse adjustment path S	Fine adjustment in diameter	permissible spindle speed min ⁻¹	kg	Spares	
										Clamping screw for holder Order No. Article	Holding screw Order No. Article
M03 00115	25	24,8 ¹⁾	33,0	24,5	39,9	4,5	0,25	40 000	0,15	55051 04504 M4x0,5x4	-
M03 00515	25	29,0	39,0	26,0	39,9	5,0	0,40	40 000	0,17		
M03 01025	32	38,0	42,0	33,0	52,9	6,0	0,40	31 000	0,35	55051 04504 M4x0,5x4	N00 56210 Tx S/M3,5x6,9
		42,0	50,0	D – 8							
M03 01535	40	49,0	63,0	41,0	60	7,0	0,40	24 000	0,63	55051 05506 M5x0,5x6	N00 56210 Tx S/M3,5x6,9
M03 02045	50	62,0	80,0	51,0	65	9,0	0,60	18 500	1,12		
M03 02555	63	79,0	95,0	65,0	66	12,0	0,60	15 000	1,91	55051 06008 M6x8	N00 56400 Tx S/M5x9,4
		95,0	103,0	D – 30							

Supply includes micro-adjustable drilling head ABS25:

Micro-adjustable drilling head with clamping screw (1). Please order insert holder and insert separately.

Supply includes micro-adjustable drilling head ABS32–ABS63:

Micro-adjustable drilling head with clamping screw (1) and holder with holding screw (2).

Please order insert holder and insert separately.

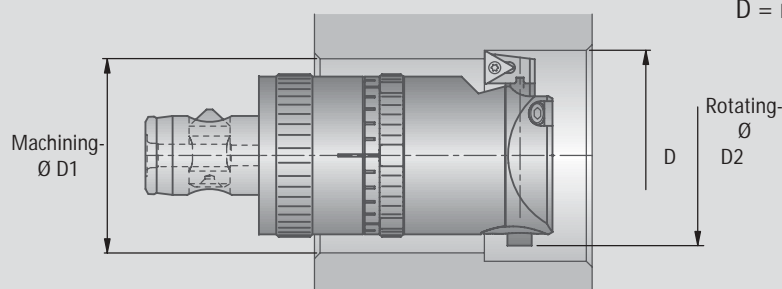
Calculation for reverse machining

$$D1 = \frac{D2 + D}{2} + 0,5$$

D1 = machining-Ø

D2 = rotating-Ø

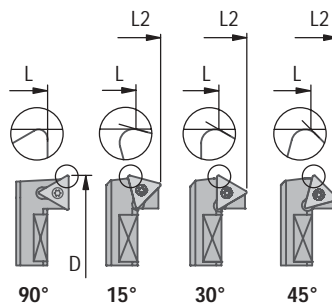
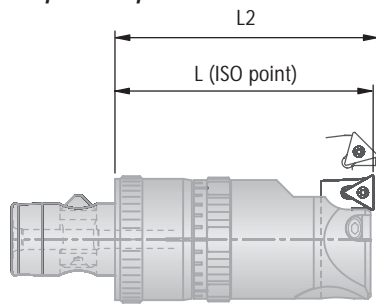
D = machining-Ø general



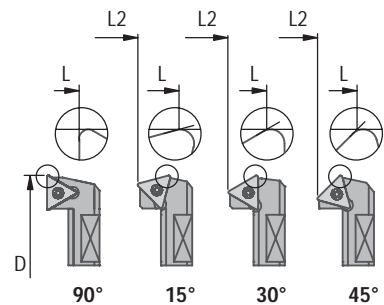
Micro-adjustable drilling head **M03Speed**

Insert holder

Ø 24,8 – 39,0 mm



Insert holder forwards



Insert holder reverse

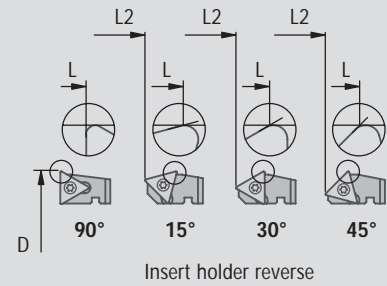
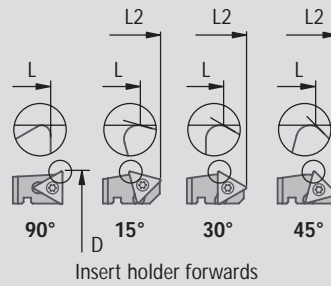
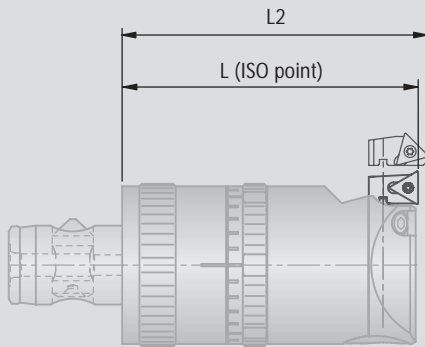
Micro-adjustable head	Insert holder forwards						Insert holder reverse						Insert		Spares	
	D	Order No.	α	L	L2	kg	D	Order No.	α	L	L2	kg	size ▼▼	size ▼▼	Clamping screw Order No. Article	Screw-driver Order No. Article
M03 00115 ABS25 24,8-33,0	M03 10011	90°	50,0	-	0,004	30,0-33,0	M03 12010	90°	35,8	-	0,004	W57 04040..... TOHX 06T1....	W30 04..... TOHX 06T1...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6	
	M03 11110	15°	44,4	50,3	0,004		M03 12110	15°	41,4	35,45	0,004					
	M03 11210	30°	45,4	50,7	0,004		M03 12210	30°	40,4	35,1	0,004					
	M03 11310	45°	46,4	50,7	0,004		M03 12310	45°	39,4	35,1	0,004					
M03 00515 ABS25 29,0-39,0	M03 10021	90°	50,0	-	0,005	34,0-39,0	M03 12000	90°	35,8	-	0,005	W57 04120..... TOHG 06T1....	W30 04..... TOHX 06T1...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6	
	M03 11100	15°	44,4	50,3	0,005		M03 12100	15°	41,4	35,4	0,005					
	M03 11200	30°	54,4	50,7	0,005		M03 12200	30°	40,4	35,1	0,005					
	M03 11300	45°	46,4	50,7	0,005		M03 12300	45°	39,4	35,1	0,005					

Supply includes insert holder:

Insert holder with clamping screw and screwdriver. Insert not included.

Micro-adjustable drilling head **M03Speed**

Insert holder
 Ø 38,0 – 103,0 mm



Micro-adjustable head	Insert holder forwards						Insert holder reverse						Insert		Spares	
	D	Order No.	α	L	L2	kg	D	Order No.	α	L	L2	kg	size ▼▼	size ▼▼	Clamping screw Order No. Article	Screw-driver Order No. Article
M03 01025 ABS32	38,0-50,0	M03 10033	90°	60,0	-	0,002	42,0-50,0	M03 12020	90°	45,8	-	0,002	W57 04040..... TOHX 06T1.... W57 04120..... TOHG 06T1.... W57 04140..... TOHG 06T1....	W30 04..... TOHX 06T1...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6
		M03 11120	15°	55,5	61,7	0,002		M03 12120	15°	50,4	44,2	0,002				
		M03 11220	30°	56,5	62,0	0,002		M03 12220	30°	49,4	43,9	0,002				
		M03 11320	45°	57,5	62,0	0,002		M03 12320	45°	48,4	43,9	0,002				
M03 01535 ABS40	49,0-63,0	M03 10043	90°	70,0	-	0,005	49,0-63,0	M03 12030	90°	50,0	-	0,005	W57 14040..... TOHX 0902....	W30 14..... TOHX 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8
		M03 11130	15°	63,5	71,9	0,005		M03 12130	15°	56,5	48,1	0,005				
		M03 11230	30°	64,5	72,0	0,005		M03 12230	30°	55,5	48,0	0,005				
		M03 11330	45°	66,8	72,9	0,005		M03 12330	45°	53,0	46,9	0,005				
M03 02045 ABS50	62,0-80,0	M03 10043	90°	75,0	-	0,005	62,0-80,0	M03 12030	90°	55,0	-	0,005	W57 14120..... TOHX 0902.... W57 14140..... TOHG 0902....	W30 14..... TOHX 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8
		M03 11130	15°	68,5	76,9	0,005		M03 12130	15°	61,5	53,1	0,005				
		M03 11230	30°	69,5	77,0	0,005		M03 12230	30°	60,5	53,0	0,005				
		M03 11330	45°	71,8	77,9	0,005		M03 12330	45°	58,0	51,9	0,005				
M03 02555 ABS63	79,0-103,0	M03 10063	90°	80,0	-	0,009	79,0-103,0	M03 12050	90°	52,0	-	0,009				
		M03 11150	15°	71,0	79,7	0,009		M03 12150	15°	61,0	52,6	0,009				
		M03 11250	30°	73,0	80,7	0,009		M03 12250	30°	59,0	51,5	0,009				
		M03 11350	45°	75,0	81,3	0,009		M03 12350	45°	57,0	50,9	0,009				

Supply includes insert holder:
 Insert holder with clamping screw and screwdriver. Insert not included.

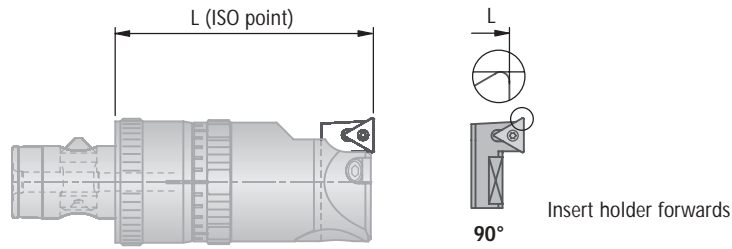
Further inserts and approach angles available on request.

Micro-adjustable drilling head **M03Speed**

Insert holder for machining aluminium

Ø 24,8 – 39,0 mm

Insert inclination above cutting edge + 5°



Micro-adjustable head	Insert holder forwards					Insert		Spares	
	D	Order No.	α	L	kg	size ▼▼	size ▼▼	Clamping screw Order No. Article	Screwdriver Order No. Article
M03 00115 ABS25	24,8-33,0	M03 10111	90°	50,0	0,004	W58 03120.0423 TPGX 060104 FN-12	W32 03..... TPHB 0601...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6
M03 00515 ABS25	29,0-39,0	M03 10121	90°	50,0	0,005				

Supply includes insert holder:

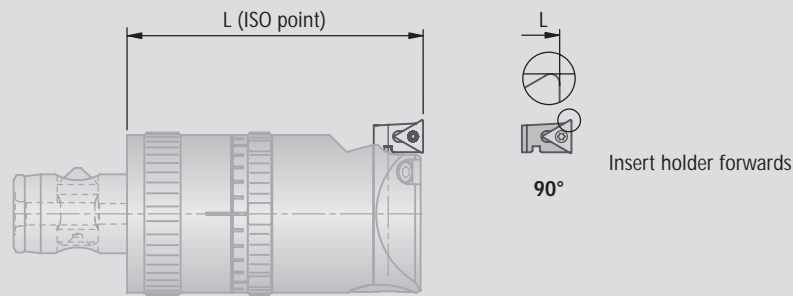
Insert holder with clamping screw and screwdriver. Insert not included.


Micro-adjustable drilling head **M03Speed**

Insert holder for machining aluminium

Ø 38,0 – 103,0 mm

Insert inclination above cutting edge + 5°



Micro-adjustable head	Insert holder forwards					Insert		Spares	
	D	Order No.	α	L		size ▼▼	size ▼▼	Clamping screw Order No. Article	Screwdriver Order No. Article
M03 01025 ABS32	38,0-50,0	M03 10133	90°	60,0	0,002	W58 03120.0423 TPGX 060104 FN-12	W32 03..... TPHB 0601...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6
M03 01535 ABS40	49,0-63,0	M03 10143	90°	70,0	0,005	W58 13120.0423 TPGX 090204 FN-12	W32 13..... TPHB 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8
M03 02045 ABS50	62,0-80,0	M03 10143	90°	75,0	0,005				
M03 02555 ABS63	79,0-103,0	M03 10163	90°	80,0	0,009				

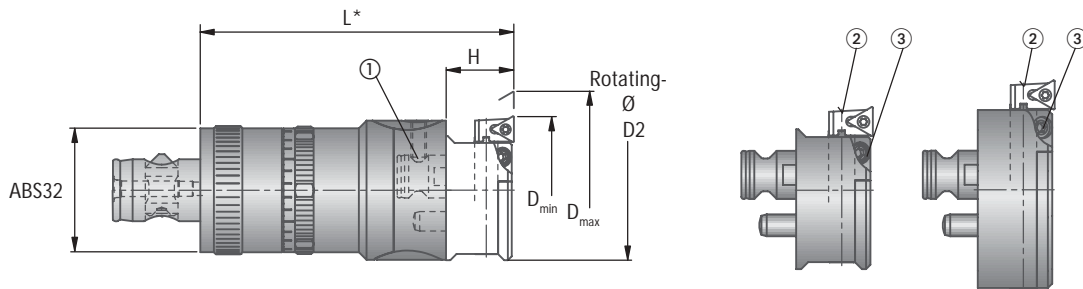
Supply includes insert holder:

Insert holder with clamping screw and screwdriver. Insert not included.

M03Speed

Micro-adjustable drilling head **M03Speed**

with ABS® connection Ø 38,0 – 63,0 mm
and replaceable bridge



D = machining-Ø

*dimension L see insert holder table on page 10-11

Micro-adjustable head			Spares	Replaceable bridge						Spares	
Order No.	ABS d	kg	① Clamping screw for replaceable bridge Order No. Article	D _{min} -D _{max}	Order No.	Rotating-Ø D2	H	permissible spindle speed min ⁻¹	kg	② Holding screw for insert holder Order No.	③ Clamping screw for holder Order No. Article
M03 20170	32	0,35	M03 20090.15 M8x10	38 - 51	M03 20180	D-3,2	17,5	31 000	0,06	N00 56210	5505104008 M4x8
				50 - 63	M03 20190	D-3,5	17,5	24 000	0,08		

Supply includes micro-adjustable drilling head:

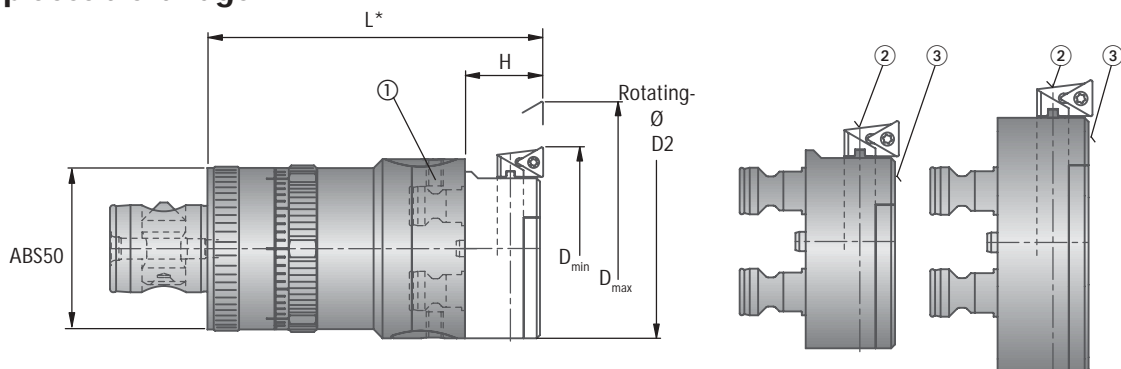
Micro-adjustable drilling head with clamping screw ①. Please order replaceable bridge separately.

Supply includes replaceable bridge:

Replaceable bridge with holding screw ② and clamping screw ③.

Please order insert holder separately.

with ABS® connection Ø 62,0 – 103,0 mm
and replaceable bridge



*dimension L see insert holder table on page 10-11

Micro-adjustable head			Spares	Replaceable bridge						Spares	
Order No.	ABS d	kg	① Clamping screw for replaceable bridge Order No. Article	D _{min} -D _{max}	Order No.	Rotating-Ø D2	H	permissible spindle speed min ⁻¹	kg	② Holding screw for insert holder Order No.	③ Clamping screw for holder Order No. Article
M03 20140	50	1,3	M03 20090.15 M8x10	63 - 83	M03 20150	55	24	18 500	0,20	N00 56210	5505104008 M4x8
				82 - 103	M03 20160	71	24	15 000	0,24		

Supply includes micro-adjustable drilling head:

Micro-adjustable drilling head with clamping screw ①. Please order replaceable bridge separately.

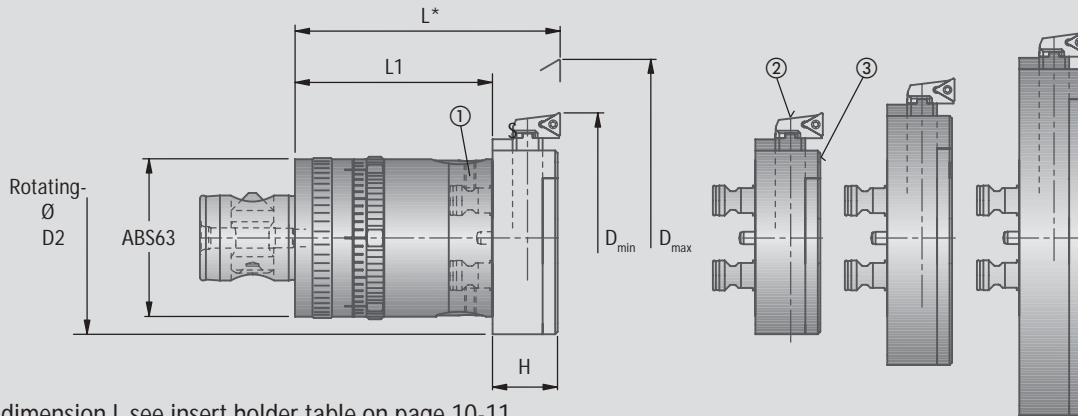
Supply includes replaceable bridge:

Replaceable bridge with holding screw ② and clamping screw ③.

Please order insert holder separately.

Micro-adjustable drilling head **M03Speed**

with ABS® connection Ø 100,0 – 206,0 mm
and replaceable bridge



*dimension L see insert holder table on page 10-11

Micro-adjustable head				Spares		Replaceable bridge					Spares	
Order No.	ABS d	L1	kg	① Clamping screw for replaceable bridge Order No. Article	D _{min} -D _{max}	Order No.	Rotating-Ø D2	H	permissible spindle speed min ⁻¹	kg	② Holding screw for insert holder Order No.	③ Clamping screw for holder Order No. Article
M03 20090	63	79	1,82	M03 20090.15 M8x10	100 - 130	M03 20100	85	26	11 500	0,39	N00 56400	5505104008 M4x8
					128 - 168	M03 20110	109	26	10 000	0,49		
					166 - 206	M03 20120	146	26	8 000	0,59		

Supply includes micro-adjustable drilling head:

Micro-adjustable drilling head with clamping screw ①. Please order replaceable bridge separately.

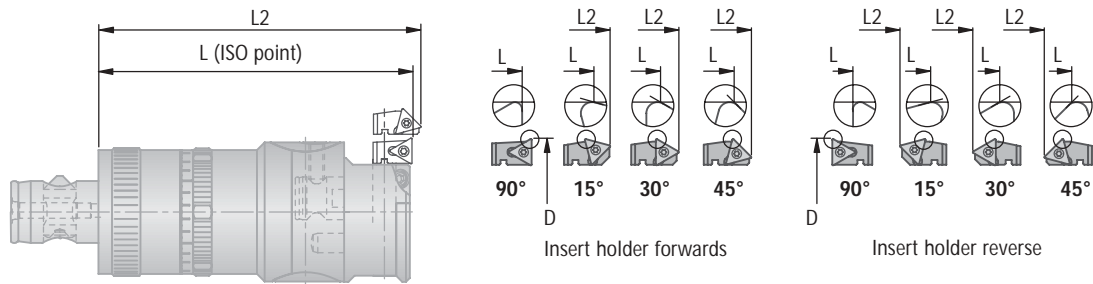
Supply includes replaceable bridge:

Replaceable bridge with holding screw ② and clamping screw ③.

Please order insert holder separately.

Micro-adjustable drilling head **M03Speed**

Insert holder Ø 38,0 – 103,0 mm

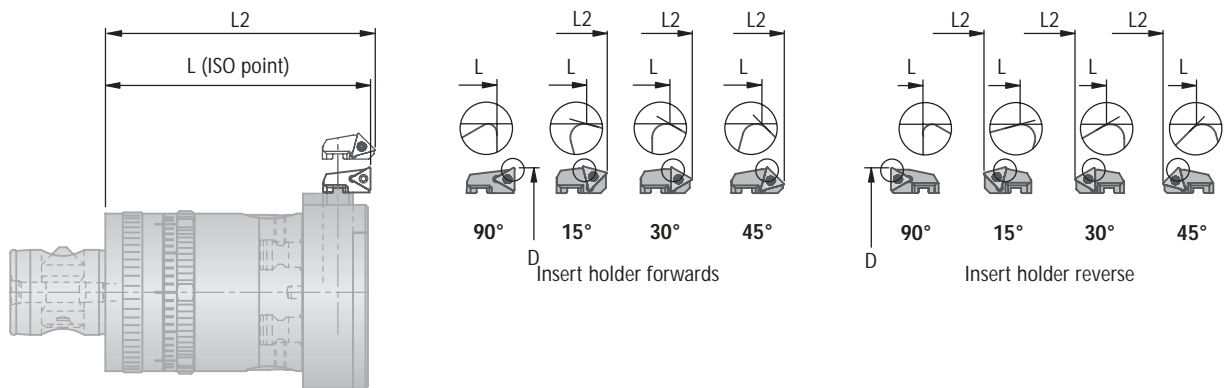


Micro-adjustable head	Insert holder forwards						Insert holder reverse						Insert		Spares	
	D	Order No.	α	L	L2	kg	D	Order No.	α	L	L2	kg	size ▼▼	size ▼▼	Order No. Article	Order No. Article
M03 20170 ABS32 38,0-63,0	M03 10033	90°	81	-	0,002	42,0-63,0	M03 12020	90°	66,8	-	0,002	W57 04040..... TOHX 06T1.... W57 04120..... TOHX 06T1.... W57 04140..... TOHG 06T1....	W30 04..... TOHX 06T1...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6	
	M03 11120	15°	76,5	82,7	0,002		M03 12120	15°	71,4	65,2	0,002					
	M03 11220	30°	77,5	83	0,002		M03 12220	30°	70,4	64,9	0,002					
	M03 11320	45°	78,5	83	0,002		M03 12320	45°	69,4	64,9	0,002					
M03 20140 ABS50 62,0-103,0	M03 10043	90°	103	-	0,005	62,0-103,0	M03 12030	90°	83	-	0,005	W57 14040..... TOHX 0902.... W57 14120..... TOHX 0902.... W57 14140..... TOHG 0902....	W30 14..... TOHX 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8	
	M03 11130	15°	96,5	104,9	0,005		M03 12130	15°	89,5	81,1	0,005					
	M03 11230	30°	97,5	105	0,005		M03 12230	30°	88,5	81	0,005					
	M03 11330	45°	99,8	105,9	0,005		M03 12330	45°	86	79,9	0,005					

Supply includes insert holder:

Insert holder with clamping screw and screwdriver. Insert not included.
Further inserts and approach angles available on request.

Insert holder Ø 100,0 – 206,0 mm



Micro-adjustable head	Insert holder forwards						Insert holder reverse						Insert		Spares	
	D	Order No.	α	L	L2	kg	D	Order No.	α	L	L2	kg	size ▼▼	size ▼▼	Order No. Article	Order No. Article
M03 20090 ABS63 100,0-206,0	M03 10070	90°	106,0	-	0,01	100,0-206,0	M03 12060	90°	80,0	-	0,01	W57 14040..... TOHX 0902.... W57 14120..... TOHX 0902.... W57 14140..... TOHG 0902....	W30 14..... TOHX 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8	
	M03 11160	15°	97,0	105,9	0,01		M03 12160	15°	89,0	80,6	0,01					
	M03 11260	30°	99,0	107,0	0,01		M03 12260	30°	87,0	79,5	0,01					
	M03 11360	45°	101,0	107,5	0,01		M03 12360	45°	85,0	78,9	0,01					

Supply includes insert holder:

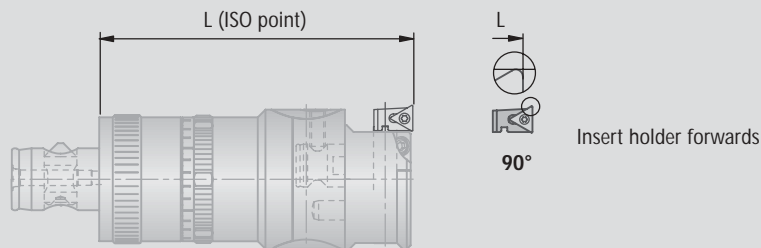
Insert holder with clamping screw and screwdriver. Insert not included.

Micro-adjustable drilling head **M03Speed**

Insert holder for machining aluminium

Ø 38,0 – 103,0 mm

Insert inclination above cutting edge + 5°



Micro-adjustable head	Insert holder forwards					Insert		Spares	
	D	Order No.	α	L	kg	size ▼▼	size ▼▼	Clamping screw Order No. Article	Screwdriver Order No. Article
M03 20170 ABS32	38,0-63,0	M03 10133	90°	81	0,002	W58 03120.0423 TPGX 060104 FN-12	W32 03..... TPHB 0601...	N00 56030 Tx S/M2x4,8	L05 00020 Tx 6
M03 20140 ABS50	62,0-103,0	M03 10143	90°	103	0,005	W58 13120.0423 TPGX 090204 FN-12	W32 13..... TPHB 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8

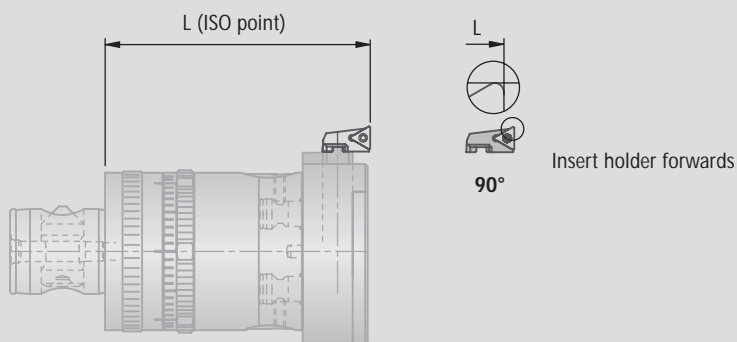
Supply includes insert holder:

Insert holder with clamping screw and screwdriver. Insert not included.

Insert holder for machining aluminium

Ø 100,0 – 206,0 mm

Insert inclination above cutting edge + 5°



Micro-adjustable head	Insert holder forwards					Insert		Spares	
	D	Order No.	α	L	kg	size ▼▼	size ▼▼	Clamping screw Order No. Article	Screwdriver Order No. Article
M03 20090 ABS63	100,0-206,0	M03 10170	90°	106,0	0,01	W58 13120.0423 TPGX 090204 FN-12	W32 13..... TPHB 0902...	N00 56100 TxS/M2,6x5,1	L05 00040 Tx 8

Supply includes insert holder:

Insert holder with clamping screw and screwdriver. Insert not included.

Micro-adjustable drilling head **M03Speed**

Set in case

A



Set in case Ø 38 – 63 mm, ABS 32
Order No. M03 20230

Case content			
	Order No.	Qty.	Article
①	M03 20180	1	Replaceable brigde Ø 38-51
②	M03 20190	1	Replaceable brigde Ø 50-63
③	M03 20170	1	Micro-adjustable head ABS32
④	M03 10033	2	Insert holder 90° forwards
⑤	1859110040	1	Allen key SW 4

B



Set in case Ø 62 – 103 mm, ABS 50
Order No. M03 20240

Case content			
	Order No.	Qty.	Article
①	M03 20150	1	Replaceable brigde Ø 62-83
②	M03 20160	1	Replaceable brigde Ø 82-103
③	M03 20140	1	Micro-adjustable head ABS50
④	M03 10043	2	Insert holder 90° forwards
⑤	1859110040	1	Allen key SW 4

C

**Set in case Ø 100 – 206 mm, ABS 63
Order No. M03 20130**



Case content			
	Order No.	Qty.	Article
①	M03 20100	1	Replaceable brigde Ø 100-130
②	M03 20110	1	Replaceable brigde Ø 128-168
③	M03 20120	1	Replaceable brigde Ø 166-206
④	M03 20090	1	Micro-adjustable head ABS63
⑤	M03 10070	3	Insert holder 90° forwards
⑥	L05 00040	1	Screwdriver Tx 8
	1859110020	1	Allen key SW 2
	1859110030	1	Allen key SW 3
	1859110040	1	Allen key SW 4

M03Speed

Lightweight modular tool

for $\varnothing > 206$ mm

Machining Example

Material: GG25
 Drilling dia.: $\varnothing 575$ mm+0,02
 $v_c = 120$ m/min
 $f = 0,17$ mm

Example of a complete tool

for fine boring with single insert $\varnothing 575$ mm:

Article	Order No.
1×Adaptor ISO50	A06 53880
	A05 25300
1×Replaceable bridge $\varnothing 575$ Special tool	XA
2×Cover plate - internal coolant	G05 00010
1×Holding plate - micro-adjustable cartridge	G05 10010
1×Micro-adjustable cartridge	M30 20050
1×Balancing weight	G05 10040

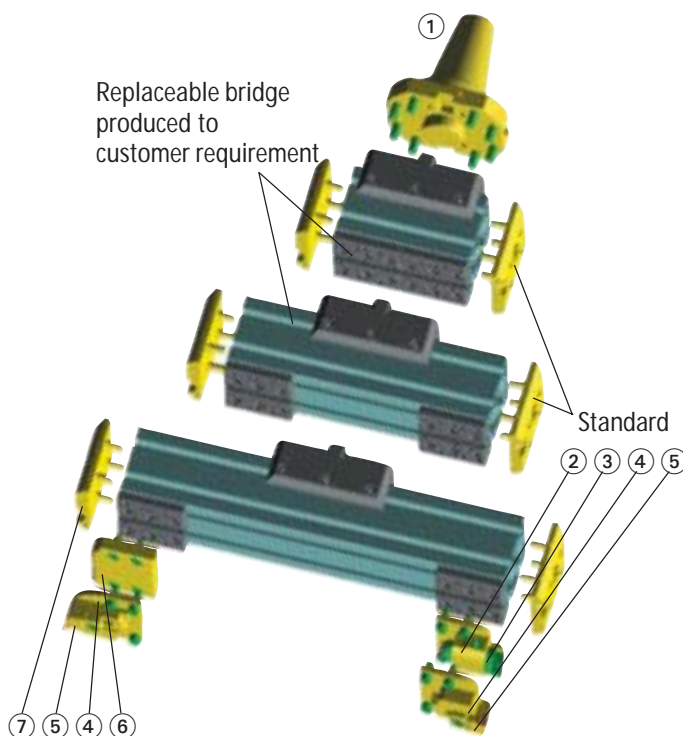


Modular design

- The tool consists of lightweight replaceable bridge to specific length and elements for fine boring or roughing (see accessories)
- Adjustment range relates to 70 mm diameter.

Accessories

Article	Order No.
① Adaptor HSK-A100	A06 53880
ABS100	A20 50080
ABS100 (ABS 90° rotated)	A20 50180
ISO50 DIN68871 AD/B	A05 25300
② Holding plate - fine machining	G05 10010
③ Micro-adjustable cartridge FF25	M30 20050
④ Holding plate - roughing cartridge	G05 20010
⑤ Roughing cartridge	G05 20020
⑥ Balancing weight	G05 10040
⑦ Cover plate with internal coolant	G05 00010



Note:

The application details shown depend on the environmental and application conditions (e.g. machine, ambient temperature, use of lubricant/coolant and the machining result required). These are subject to correct operating conditions, correct application and compliance with the spindle speed limits given for the tools.

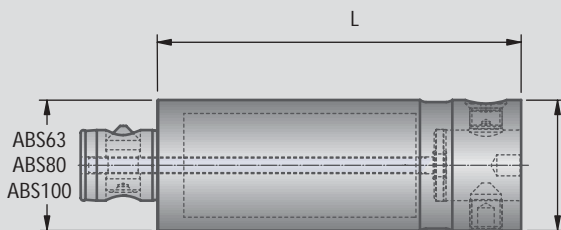
Lightweight adaptor



Features:

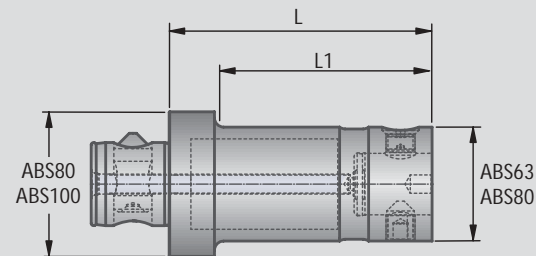
- Weight reduced by up to 45%
- Stable application conditions
- Steel construction - i.e. hardened faces - guarantees long life
- Coolant supply

Extension with ABS® connection



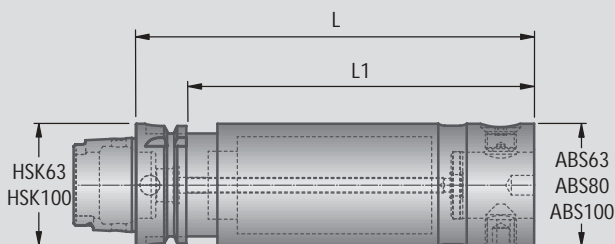
Article	Order No.	ABS d	L1	kg
ABS63-V125-LB	A20 01060	63	125	1,90
ABS63-V190-LB	A20 01160	63	190	2,60
ABS80-V170-LB	A20 01070	80	170	4,00
ABS80-V240-LB	A20 01170	80	240	5,30
ABS100-V200-LB	A20 01080	100	200	7,30
ABS100-V300-LB	A20 01180	100	300	9,70

Reducer with ABS® connection



Article	Order No.	ABS d	ABS d1	L	L1	kg
ABS80-R63-LB	A20 11560	80	63	145	120	2,80
ABS100-R80-LB	A20 11670	100	80	160	130	5,00

Adaptor HSK-A – ABS



Artikel	Bestell-Nr.	HSK d	ABS d1	L	L1	kg
HSK-A63-ABS63-LB	A06 30360	63	63	205	-	3,00
HSK-A100-ABS63-LB	A06 50360	100	63	205	176	4,20
HSK-A100-ABS80-LB	A06 50370	100	80	215	186	5,90
HSK-A100-ABS100-LB	A06 50380	100	100	260	-	8,90

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