

## Coolant tube sleeve related parts

### NABEYA insert nozzle BB type



| Model number | D  | L   |
|--------------|----|-----|
| BB101-3      | 10 | 6.4 |
| BB111-3      | 11 | 9.1 |
| BB121-3      | 12 | 9.1 |
| BB141-3      | 14 | 9.1 |
| BB151-3      | 15 | 9.1 |
| BB181-3      | 18 | 9.1 |
| BB221-3      | 22 | 9.1 |

※non-stock item

### Straight nozzle



| Model number | L  |
|--------------|----|
| SSS20-M6     | 15 |
| SSS30-M6     | 25 |
| SSS40-M6     | 35 |

### Drive-in type nozzle



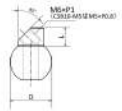
| Model number | D  | L  | A      |
|--------------|----|----|--------|
| Φ12-M5       | 12 | 8  | M5×0.8 |
| Φ14-M6       | 14 | 10 | M6×1   |

### Ball nozzle

It can be used in combination with straight nozzles.  
※Except CSB10-M5



Combination example



| Model number | D           | L   |
|--------------|-------------|-----|
| CSB10-M5     | 10          | 9   |
| CSB12-M6     | 12          | 9   |
| CSB12.7-M6   | 12.7 (1/2") | 9   |
| CSB14-M6     | 14          | 7.5 |
| CSB14.7-M6   | 14.7 (3/8") | 7.5 |
| CSB15-M6     | 15          | 7.5 |
| CSB15.8-M6   | 15.8 (5/8") | 7   |
| CSB16-M6     | 16          | 7   |

### Rectangular elbow



| Model number | L      | A      |
|--------------|--------|--------|
| CSE00-M5     | M5×0.8 |        |
| CSE05-M5     | 5      | M5×0.8 |
| CSE15-M5     | 15     | M5×0.8 |
| CSE25-M5     | 25     | M5×0.8 |
| CSE35-M5     | 35     | M5×0.8 |
| CSE00-M6     | M6×1   |        |
| CSE05-M6     | 5      | M6×1   |
| CSE15-M6     | 15     | M6×1   |
| CSE25-M6     | 25     | M6×1   |
| CSE35-M6     | 35     | M6×1   |

### PISCO Universal elbow



| Model number | L    | A  |
|--------------|------|----|
| PH4-M5       | 21.2 | M5 |
| PH4-M6       | 21.2 | M6 |
| PH6-M5       | 23.1 | M5 |
| PH6-M6       | 23.1 | M6 |

### Rectifier plate

(Included with inner diameter of Φ8 or less)



It is a part that regulates the flow of coolant.  
Please contact us if you have lost it.

### Sleeve spacer

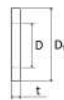


Spacer for sleeve protrusion adjustment.  
Makes it easier to blow coolant into the sleeve.

It is convenient when the distance between the sleeve end face and the coolant injection port of the turret is small, or when it is difficult to pour the coolant.

The position of the sleeve itself can be adjusted by inserting the sleeve spacer into the sleeve and setting it on the turret.

It can also be used when the sleeve screw hole and the turret screw hole overlap.



| Model number | D  | D <sub>2</sub> | t |
|--------------|----|----------------|---|
| SC-253       | 25 | 32             | 3 |
| SC-255       | 25 | 32             | 5 |
| SC-323       | 32 | 38             | 3 |
| SC-325       | 32 | 38             | 5 |
| SC-403       | 40 | 46             | 3 |
| SC-405       | 40 | 46             | 5 |

## NEW Boring bar sleeve for CNC lathe

# Coolant tube sleeve®

## Boring bar sleeve improves internal machining coolant

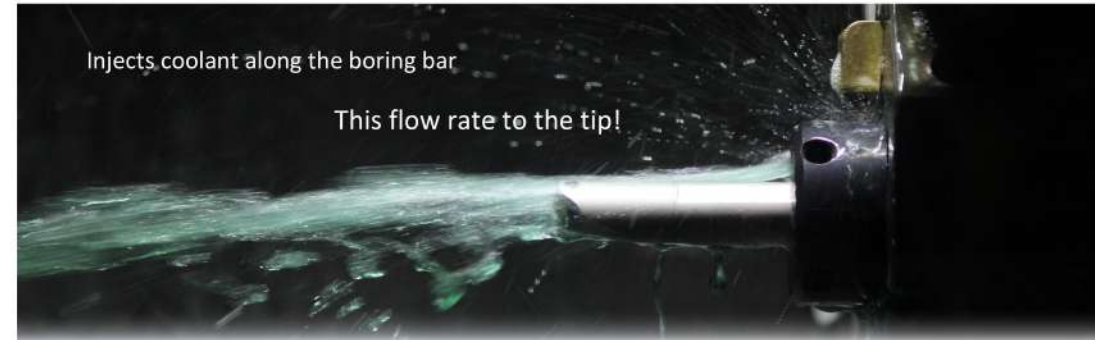
Stable supply of external coolant to the cutting edge.

Any turret type CNC lathe can be used regardless of the manufacturer or model year.

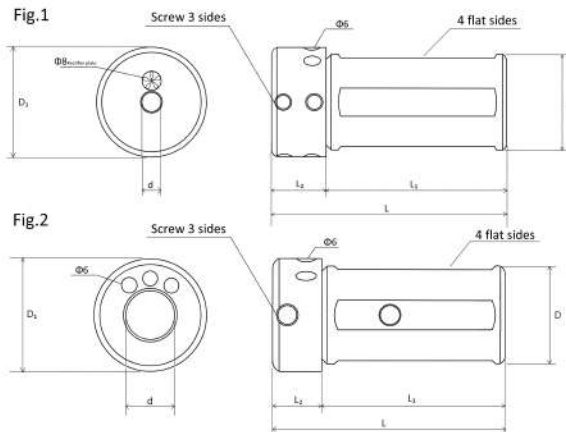
Troublesome coolant adjustment is not required, and complicated piping and connections are not required.

Injects coolant along the boring bar

This flow rate to the tip!



## Coolant tube sleeve dimension table



※Product specifications are subject to change without notice.

### CS- [Φd] [ΦD]

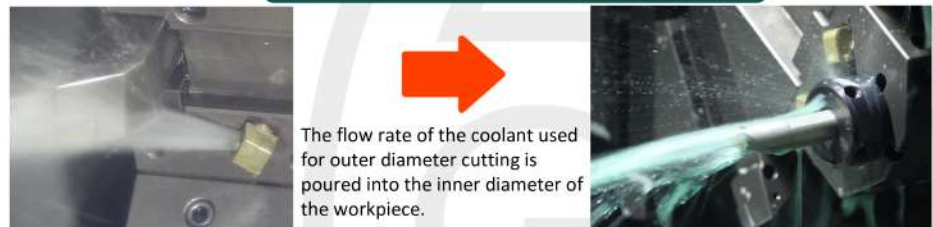
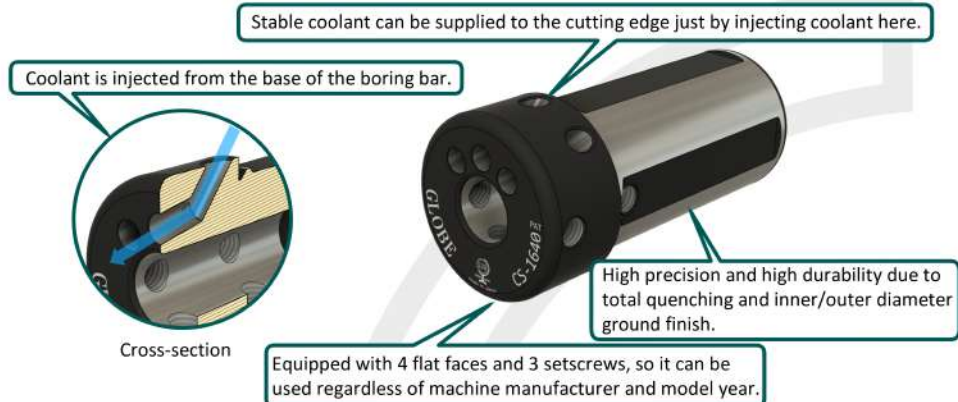
|         | d  | D  | L  | L <sub>1</sub> | L <sub>2</sub> | D <sub>1</sub> | screw | Fig. |
|---------|----|----|----|----------------|----------------|----------------|-------|------|
| CS-0525 | 5  | 25 | 68 | 50             | 18             | 32             | M4    | 1    |
| CS-0625 | 6  | 25 | 68 | 50             | 18             | 32             | M4    | 1    |
| CS-0725 | 7  | 25 | 68 | 50             | 18             | 32             | M5    | 1    |
| CS-0825 | 8  | 25 | 68 | 50             | 18             | 32             | M5    | 1    |
| CS-1025 | 10 | 25 | 68 | 50             | 18             | 32             | M6    | 2    |
| CS-1225 | 12 | 25 | 68 | 50             | 18             | 32             | M6    | 2    |
| CS-1425 | 14 | 25 | 65 | 50             | 15             | 34             | M6    | 2    |
| CS-1625 | 16 | 25 | 65 | 50             | 15             | 34             | M5    | 2    |
| CS-0532 | 5  | 32 | 85 | 65             | 20             | 38             | M4    | 1    |
| CS-0632 | 6  | 32 | 85 | 65             | 20             | 38             | M4    | 1    |
| CS-0732 | 7  | 32 | 85 | 65             | 20             | 38             | M5    | 1    |
| CS-0832 | 8  | 32 | 85 | 65             | 20             | 38             | M5    | 1    |
| CS-1032 | 10 | 32 | 85 | 65             | 20             | 38             | M6    | 2    |
| CS-1232 | 12 | 32 | 85 | 65             | 20             | 38             | M6    | 2    |
| CS-1432 | 14 | 32 | 85 | 65             | 20             | 38             | M8    | 2    |
| CS-1632 | 16 | 32 | 80 | 65             | 15             | 38             | M8    | 2    |
| CS-2032 | 20 | 32 | 81 | 65             | 16             | 40             | M8    | 2    |
| CS-0540 | 5  | 40 | 98 | 75             | 23             | 46             | M4    | 1    |
| CS-0640 | 6  | 40 | 98 | 75             | 23             | 46             | M4    | 1    |
| CS-0740 | 7  | 40 | 98 | 75             | 23             | 46             | M5    | 1    |
| CS-0840 | 8  | 40 | 98 | 75             | 23             | 46             | M5    | 1    |
| CS-1040 | 10 | 40 | 98 | 75             | 23             | 46             | M6    | 2    |
| CS-1240 | 12 | 40 | 98 | 75             | 23             | 46             | M6    | 2    |
| CS-1440 | 14 | 40 | 98 | 75             | 23             | 46             | M8    | 2    |
| CS-1640 | 16 | 40 | 98 | 75             | 23             | 46             | M8    | 2    |
| CS-2040 | 20 | 40 | 95 | 75             | 20             | 46             | M8    | 2    |
| CS-2540 | 25 | 40 | 95 | 75             | 20             | 50             | M8    | 2    |

Patented  
PAT.No.6596113

Total quenching.  
Highest grade inner and outer diameter ground finish.

There is an introduction video.  
Please have a look once!





### Inject coolant along the boring bar!

**General boring bar sleeve**

Coolant is blocked by the sleeve. Coolant does not enter inside the work.

With conventional boring bar sleeves, coolant could not be sprayed from the base of the boring bar because the sleeve was in the way. Therefore, when the boring bar actually enters the inner diameter of the workpiece, the coolant is applied to the outer diameter of the workpiece, and there is a problem that no coolant is supplied to the cutting edge.

**Coolant tube sleeve**

Injects coolant from the base of the boring bar. Coolant is delivered up to the cutting edge.

When using a **Coolant tube sleeve**, coolant is injected from the **root of the boring bar** and along the boring bar to the cutting edge. Even if the boring bar penetrates deep into the inner diameter of the workpiece, the coolant is **reliably and stably supplied** to the cutting edge. In addition, since the coolant is injected from the base of the boring bar, **the amount of protrusion of the boring bar can be minimized**, which helps prevent chattering.

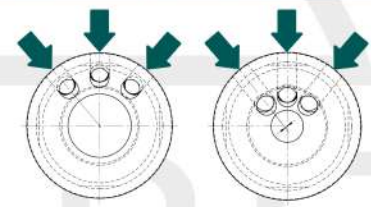
There is an introduction video. Please see from the QR code.

Since the coolant is jetted into the air and the direction is changed, **There is no need for complicated connections such as pipes!**



Conventional boring bar sleeves require complex bending of copper pipes, etc., in order to accurately spray coolant onto the boring bar. In addition, for sleeves that use internally supplied coolant, the method differs depending on the manufacturer and model year of the machine, and it must be connected with a dedicated pipe.

The position of the hole for pouring coolant is the same for each size. **No need to adjust the coolant injection direction!**



Coolant tube sleeves have the same coolant flow position, so once the nozzle is set on the turret, there is **almost no need to adjust** the coolant direction even when changing setups such as sleeve replacement.

There is a video on how to use it. Please see from the QR code.

### Nozzles suitable for each CNC lathe manufacturer are available.

|   |  |  |
|---|--|--|
| <p>OKUMA DMG MORI<br/>NAKAMURA-TOME etc.</p> <p>A type of holder that fixes a ball-shaped nozzle with a screw</p> <p>There are products made in-house, products made by NABEYA, etc. It can accommodate different ball sizes.</p> | <p>MAZAK etc.</p> <p>A holder with a threaded coolant nozzle</p> <p>There are products made in-house, products made by PISCO, etc. A wide variety of screws and lengths are available.</p> | <p>Others</p> <p>A holder of the type in which pipes, etc. are directly protruding from the turret</p> <p>Use the pipes that come with your machine, or use our own copper pipes</p> |
|---|--|--|

There is also a spacer that is convenient when it is difficult to adjust the coolant. For details, please refer to "Sleeve Spacer" on the back side.