

GFS - Rasmuc

**The unique one piece - two edge cutting Reverse Counterboring System
for CNC Machines. Patent DPD Nr. 3429971**

**RASMUC Reverse Counterboring System - new improved version
To be used only on machines with internal cooling**



The GFS RASMUC reverse counterboring system has decisive advantages over all the other back spotfacers available on the market. Because of the cutter's doubled-edge, the cutting forces are uniformly distributed, so there is no deflection of the boring bar and a high chip production. The cutter is locked during the working process so that even interrupted cutting does not pose any problems.

Advantages :

- 1) Fully automatic working even in poorly accessible places
- 2) No manual intervention necessary during the process, hence :
 - a) No machine downtime
 - b) Absolute repeat precision
- 2) Single-piece HSS-E cutter with optimized blade geometry, hence smooth cutting, high stability and high chip production
- 3) Unlimited interchangeability of set sleeves and cutters within a single boring bar size
- 4) Cutters also available brazed carbide and TiN-coated

A monitoring system, i.e. „Mawomatic“, is recommended for continuous operation.

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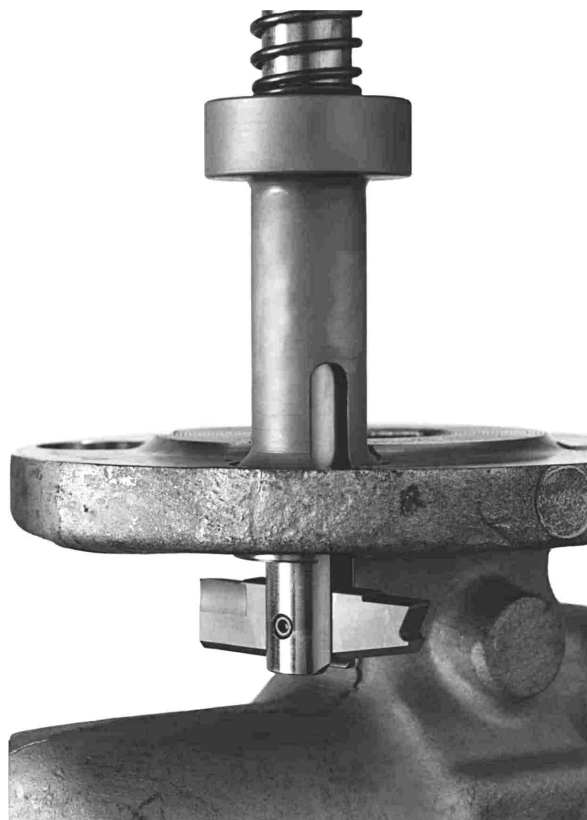
Operating Description :

In its folded state the tool passes through the bore until the control edge of the set sleeve rests against the workpiece. By travelling further with minimal forward feed, the boring bar advances axially through the sleeve. The cutter concealed within the boring bar is pushed out of the sleeve, unfolded by the pressure of the coolant flowing through the boring bar and locked in its working position.

Now the working operation can be started.

Reverse counterboring can now commence. At the end of the process, the patented GFS reversing mechanism is actuated and the cutter folds back into the boring bar.

The RASMUC boring bar can now be retracted with ease through the bore and is ready for the next work cycle.



NOTICE :

The RASMUC reverse counterboring system can be employed on any modern machine tool, internal coolant supply is absolutely necessary.

**The *GFS RASMUC Reverse Counterboring System* is available for
drillholes from 16 mm up to 60 mm dia, in special cases even
drillholes down to 10 mm dia and below are possible**

***You can see an animation of this process on our Internet page:
<http://www.gfs.websale.de>.***

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The available standard sizes are divided into four diameter ranges, each of which covers three different maximum working lengths. The shortest possible length of tool should be chosen for each job in order to maximize tool stability.

The following standard sizes are available :

Size	10	11	12
Drill-hole dia X	16 - 25 mm / 0.630'' - 1.000''	16 - 25 mm	16 - 25 mm
counterboring dia Y	17 - 30 mm / 0.670'' - 1.180''	17 - 30 mm	17 - 30 mm
max counterb. depth B	30 mm / 1.180''	60 mm / 2.360''	90 mm / 3.540''
minimum clearance A	39 mm / 1.540''	39 mm / 1.540''	39 mm / 1.540''
projection length	205 mm / 8.070''	235 mm / 9.250''	265 mm / 10.430''

Size	20	21	22
Drill-hole dia X	22 - 35 mm / 0.860'' - 1.375''	22 - 35 mm	22 - 35 mm
counterboring dia Y	30 - 50 mm / 1.180'' - 2.000''	30 - 50 mm	30 - 50 mm
max counterb. depth B	40 mm / 1.575''	80 mm / 3.150''	120 mm / 4.725''
minimum clearance A	51 mm / 2.010''	51 mm / 2.010''	51 mm / 2.010''
projection length	270 mm / 10.630''	310 mm / 12.200''	350 mm / 13.780''

Size	30	31	32
Drill-hole dia X	31 - 45 mm / 1.220'' - 1.770''	31 - 45 mm	31 - 45 mm
counterboring dia Y	50 - 70 mm / 2.000'' - 2.750''	50 - 70 mm	50 - 70 mm
max counterb. depth B	50 mm / 2.000''	100 mm / 4.000''	150 mm / 6.000''
minimum clearance A	71 mm / 2.800''	71 mm / 2.800''	71 mm / 2.800''
projection length	340 mm / 13.385''	390 mm / 15.350''	440 mm / 17.320''

Size	40	41	42
Drill-hole dia X	40 - 60 mm / 1.575'' - 2.360''	40 - 60 mm	40 - 60 mm
counterboring dia Y	70 - 90 mm / 2.750'' - 3.550''	70 - 90 mm	70 - 90 mm
max counterb. depth B	65 mm / 2.560''	130 mm / 5.120''	195 mm / 7.680''
minimum clearance A	91 mm / 3.580''	91 mm / 3.580''	91 mm / 3.580''
projection length	420 mm / 16.540''	485 mm / 19.100''	550 mm / 21.650''

We can produce any other size, provided it is technically feasible! Please contact us .

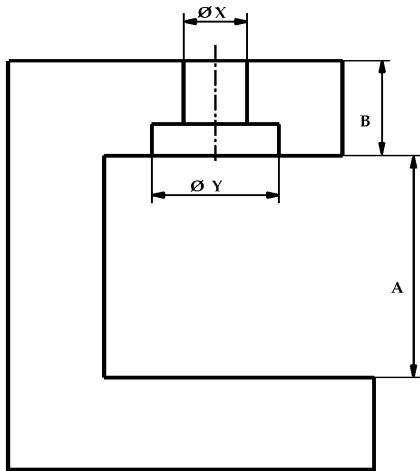
ANFRAGE / REQUEST

AN / TO : GFS Spantechnik
Ostringstraße 4 - 6
D-90574 Rosstal

Fax : +49 9127 959195

VON/FROM :

Tel. : Fax :



$\varnothing X$:

$\varnothing Y$:

A :

B :

Werkstoff / Material:

Rückwärtssenkensystem RASMUC**Backspotfacing System RASMUC****Sistema di allargatura a ritroso RASMUC****Système automatique de fraisage arrière RASMUC****System - System - Sistema - Systeme**

Größe - Size	Art. No.	Größe - Size	Art. No.	Größe - Size	Art. No.
10	40560300	11	40560310	12	40560320
20	40560330	21	40560340	22	40560350
30	40560360	31	40560370	32	40560380
40	40560390	41	40560400	42	40560410

Messer - Cutters - Coltelli - Couteaux**Größe 10 - Size 10 - Misura 10 - Dimension 10**

Ø mm	Type HSS Art.No.	Type TIN Art.No.	Type HM Art.No.
17	3010017	3011017	3012017
18	3010018	3011018	3012018
19	3010019	3011019	3012019
20	3010020	3011020	3012020
21	3010021	3011021	3012021
22	3010022	3011022	3012022
23	3010023	3011023	3012023
24	3010024	3011024	3012024
25	3010025	3011025	3012025
26	3010026	3011026	3012026
27	3010027	3011027	3012027
28	3010028	3011028	3012028
29	3010029	3011029	3012029
30	3010030	3011030	3012030

Größe 20 - Size 20 - Misura 20 - Dimension 20

Ø mm	Type HSS Art.No.	Type TIN Art.No.	Type HM Art.No.
30	3020030	3021030	3022030
31	3020031	3021031	3022031
32	3020032	3021032	3022032
33	3020033	3021033	3022033
34	3020034	3021034	3022034
35	3020035	3021035	3022035
36	3020036	3021036	3022036
37	3020037	3021037	3022037
38	3020038	3021038	3022038
39	3020039	3021039	3022039
40	3020040	3021040	3022040
41	3020041	3021041	3022041
42	3020042	3021042	3022042
43	3020043	3021043	3022043
44	3020044	3021044	3022044
45	3020045	3021045	3022045
46	3020046	3021046	3022046
47	3020047	3021047	3022047
48	3020048	3021048	3022048
49	3020049	3021049	3022049
50	3020050	3021050	3022050

Rückwärtssenkensystem RASMUC**Backspotfacing System RASMUC****Sistema di allargatura a ritroso RASMUC Système automatique de fraisage arrière RASMUC**

Größe 30 - Size 30 - Misura 30 - Dimension 30

Ø mm	Type HSS Art.No.	Type TIN Art.No.	Type HM Art.No.
50	3030050	3031050	3032050
51	3030051	3031051	3032051
52	3030052	3031052	3032052
53	3030053	3031053	3032053
54	3030054	3031054	3032054
55	3030055	3031055	3032055
56	3030056	3031056	3032056
57	3030057	3031057	3032057
58	3030058	3031058	3032058
59	3030059	3031059	3032059
60	3030060	3031060	3032060
61	3030061	3031061	3032061
62	3030062	3031062	3032062
63	3030063	3031063	3032063
64	3030064	3031064	3032064
65	3030065	3031065	3032065
66	3030066	3031066	3032066
67	3030067	3031067	3032067
68	3030068	3031068	3032068
69	3030069	3031069	3032069
70	3030070	3031070	3032070

Größe 40 - Size 40 - Misura 40 - Dimension 40

Ø mm	Type HSS Art.No.	Type TIN Art.No.	Type HM Art.No.
70	3040070	3041070	3042070
71	3040071	3041071	3042071
72	3040072	3041072	3042072
73	3040073	3041073	3042073
74	3040074	3041074	3042074
75	3040075	3041075	3042075
76	3040076	3041076	3042076
77	3040077	3041077	3042077
78	3040078	3041078	3042078
79	3040079	3041079	3042079
80	3040080	3041080	3042080
81	3040081	3041081	3042081
82	3040082	3041082	3042082
83	3040083	3041083	3042083
84	3040084	3041084	3042084
85	3040085	3041085	3042085
86	3040086	3041086	3042086
87	3040087	3041087	3042087
88	3040088	3041088	3042088
89	3040089	3041089	3042089
90	3040090	3041090	3042090