



ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing



Drilling



Reaming



Burnishing



Threading



Specials



Wohlhaupter®

► **BORING**

Special Boring Solutions

WOHLHAUPTER®

North America

Allied Machine

120 Deeds Drive
Dover, OH 44622
United States

Allied Machine

485 West 3rd Street
Dover, OH 44622
United States

ThreadMills USA™

4185 Crosstowne Ct #B
Evans, GA 30809
United States

Superion®

1285 S Patton St.
Xenia, OH 45385
United States

Europe

Allied Machine Europe

93 Vantage Point
Pensnett Estate
Kingswinford
West Midlands
DY6 7FR, United Kingdom

Wohlhaupter® GmbH

Maybachstrasse 4
Postfach 1264
72636 Frickenhausen
Germany

Asia

Wohlhaupter® India

B-23, 3rd Floor
B Block Community Centre
Janakpuri, New Delhi - 110058
India



Allied Machine & Engineering is a worldwide leader in holemaking and finishing solutions. We are committed to providing practical and dependable solutions to our customers through innovative designs and superior customer and technical support.

We continue to expand our product offering in order to provide new and different solutions. With Field Sales Engineers located around the world, we position ourselves to provide technical support on site, right at your spindle.



**ALLIED MACHINE
& ENGINEERING**

www.alliedmachine.com



Wohlhaupter® Special Boring Solutions

CATALOG

Allied Machine & Engineering

The Foundation

Since 1941, Allied Machine & Engineering has provided dependable and practical holmaking solutions to the world. What was once a small job shop in Ohio is now a worldwide leader in cutting tool technology. With three manufacturing facilities in Ohio, one in Georgia, another in Germany, and headquarters in both the United States and Europe, Allied Machine is positioned to bring innovative solutions and technical expertise directly to the customers' hands.



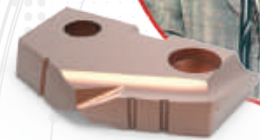
The Beginning

Harold E. Stokey founded Allied Machine & Engineering to aid the war effort, manufacturing taper bearing lock nuts for the production of M1 tanks. Years later, after a sales meeting gone wrong, Stokey possessed a warehouse stocked with spade drill inserts. He set forth into the industry that would become Allied Machine's thriving identity: holmaking.

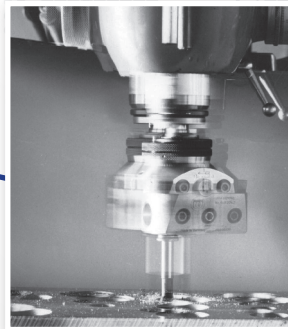


The T-A®

When Harold's son, William H. Stokey, became the president and CEO, he developed the Throw Away, or T-A®, spade drill insert system. The T-A revolutionized the holmaking industry, launching Allied Machine ahead of the competition. Since then, numerous innovations and advancements have been created from the T-A's inspiration.



Wohlhaupter®



The Foundation

On October 1, 1929, Emil Wohlhaupter founded a small mechanical workshop in Stuttgart-Feuerbach, Germany, reconditioning cutting and stamping tools by hand. A few years later, the company was subcontracted to carry out small-scale batch productions.

The UPA Beginning

In 1936, the first model of the Universal Facing and Boring head was developed. One year later, it was shown at the Leipzig Trade Fair. The UPA became known around the world along with Wohlhaupter's name. The Universal Facing and Boring head can be used on different machines for individual and batch productions. Since then, numerous boring innovations and advancements have been created.

The MultiBore® System

Wohlhaupter developed the world's first modular boring system in 1973 called MultiBore. MultiBore was created with a system of modular components that is compatible with every machine spindle.

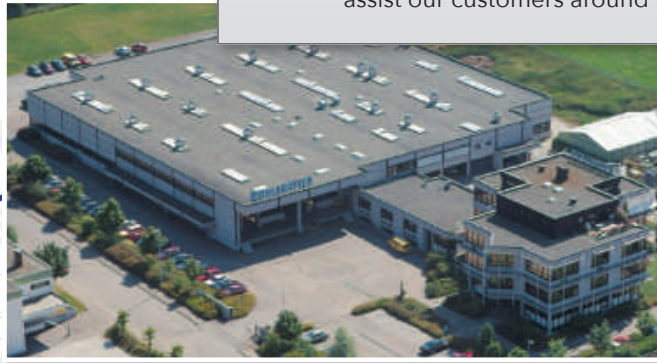
The Innovation

Since the development of the T-A®, Allied Machine has expanded its product offering to support a vast range of customer applications, including large diameter and deep hole drilling, boring, reaming, burnishing, porting, and threading.



Today

In 2016, Allied Machine & Engineering joined forces with Wohlfahrt to create a globally sought after specialist for the entire holmaking process. Our customer support is crucial to what we do, and that's why we make sure the best engineers and customer service associates are in place to assist our customers around the world.



Steve Stokey
Executive Vice President
Allied Machine & Engineering

Frank-M. Wohlfahrt
Managing Director
Wohlfahrt GmbH

Paul Crawford
Managing Director
Allied Machine & Engineering
(Europe) Ltd.

William H. Stokey
President and CEO

Mike Stokey
Executive Vice President
Allied Machine & Engineering



**ALLIED MACHINE
& ENGINEERING**

Holemaking Solutions for Today's Manufacturing

WOHLHAUPTER



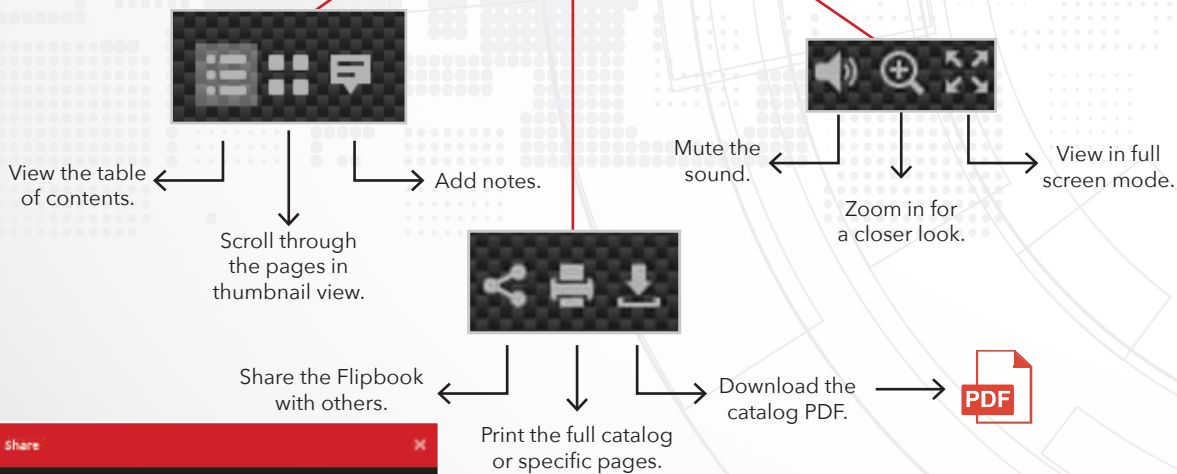
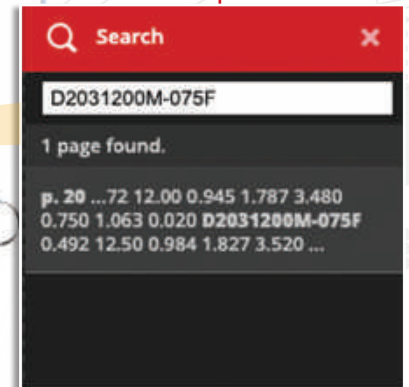
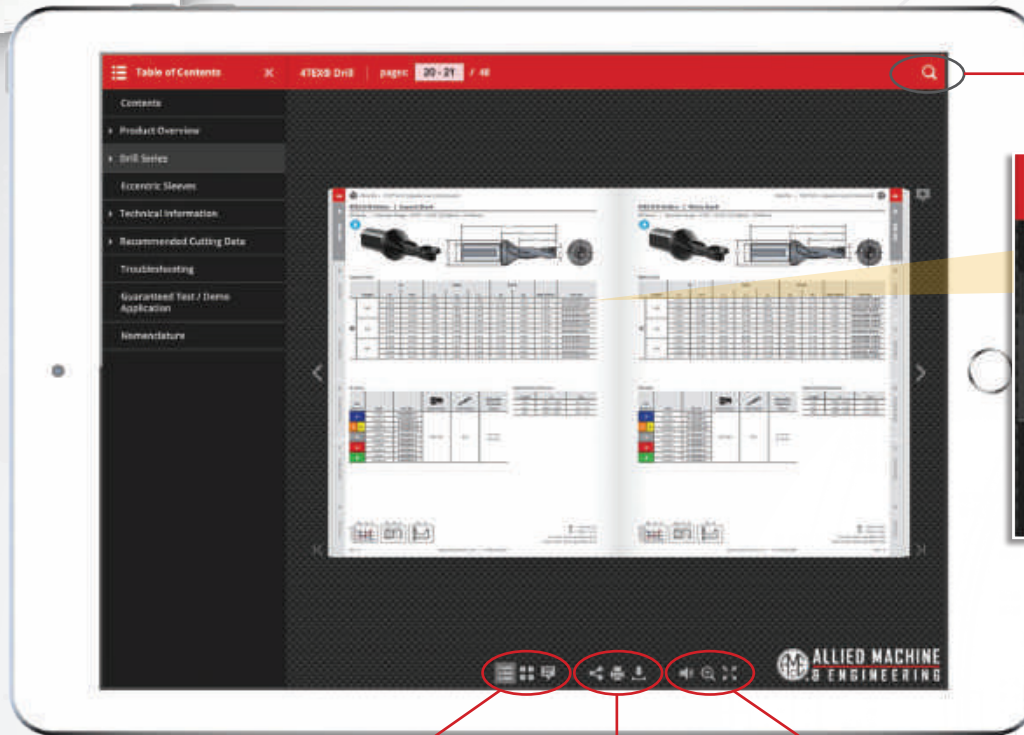
SUPERION

CRITERION

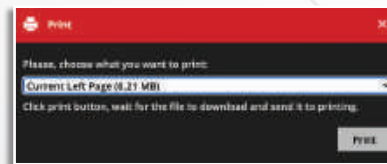


Find what you need. Now.

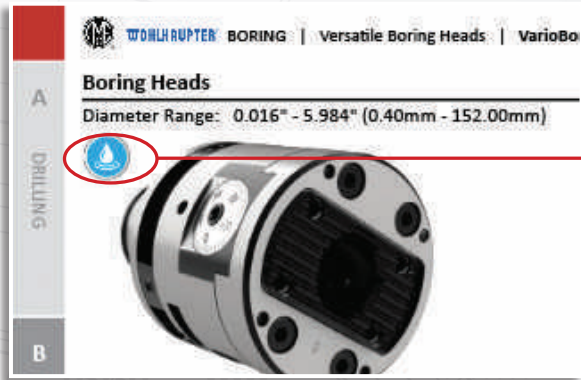
Flipbooks give you the ability to search for specific item numbers, download PDFs, print pages, and share with others. Save time searching the catalog by hand by using the easy search function. View our flipbooks now at alliedmachine.com/support/literature.



Share the link to each Flipbook via email and social media.



Icon Reference Guide



Navigate with ease.

The following icons will appear throughout the catalog to help you navigate between products and find the best solution quickly.

Tool Options



Coolant Through

Safety Information

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

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There are safety signal words also used in the catalog. Safety messages follow these words.

WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

Visit www.alliedmachine.com for the most up-to-date information and procedures.

Patent Information

Allied Machine & Engineering and Wohlhaupter patent information can be found at www.alliedmachine.com/patents



Product Offering Overview

Replaceable Insert Drills

- Reduce costs by decreasing setup time and utilizing a single holder for the lives of multiple inserts
- Provide flexibility to quickly switch between inserts with different geometries
- Products:
 - GEN3SYS® XT | GEN3SYS® XT Pro
 - T-A® | T-A® GEN2 | T-A Pro®
 - High Performance | Universal



Indexable Insert Drills

- Protect your investment and reduce your inventory with replaceable cartridges that allow the same holder to be used repeatedly
- Indexable inserts increase productivity and tool life while reducing costs
- Products:
 - 4TEX® Drill
 - Revolution Drill®
 - Opening Drill®



Replaceable / Indexable Insert Drills

- Drill large diameter holes and maximize penetration rates even on low horsepower machines
- Delivers strength and versatility needed for any deep hole drilling application
- Holders cover a range of sizes with the replaceable heads determining the cutting diameter
- Products:
 - APX™ Drill



Solid Carbide Drills

- Offer greater strength and stability when drilling tougher materials
- Available in diameters from 3mm - 20mm
- Can be made to order specifically for your application (Superion® quoted specials)
 - ASC 320®
 - Superion®



Structural Steel Solutions



- Deliver outstanding performance and durability in structural steel applications
- Designed to produce optimal results in difficult-to-machine materials
- Available in multiple lengths and diameters
- T-A® style drills have different insert geometry options to improve performance depending on material
- Products:
 - T-A® | T-A® GEN2
 - GEN3SYS® XT Pro

BTA (STS) Machining Solutions

- The internal ejection system flushes chips and debris from the hole with no interference to the cutting process
- Utilizes the advantages of the T-A® drill insert
- Designed to significantly increase penetration rates over brazed heads and traditional gun drills
- Products:
 - BT-A Drill



Hydraulic Port Contour Cutters

- Save significant time and money by performing four processes in one step
- Replaceable insert design reduces costs, inventory, and setup times
- Available in four industry specifications:
 - Imperial: SAE J-1926
 - Metric: ISO 6149-1:2006
 - Military: SAE AS5202
 - John Deere: JDS-G173.1
- Products:
 - AccuPort 432®



Enhanced Special Drilling Capabilities

- Allied Machine engineers are available to meet with you to evaluate your application and recommend the best solution for you
- Special drilling solutions can incorporate advanced features such as adjustable diameter locations, multiple steps, additional coolant designs, special lengths and diameters, and more
- Special drills can drastically reduce your cost per hole and increase your overall productivity by eliminating multiple processes and increasing tool life

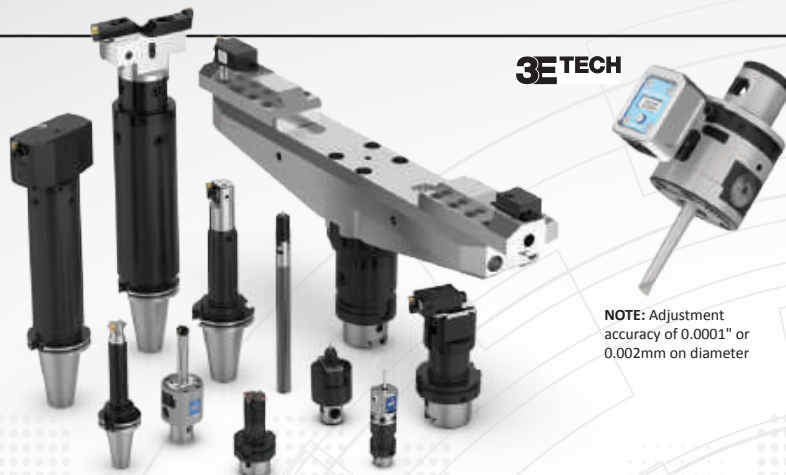


Product Offering Overview

WOHLHAUPTER®

High Precision Boring Systems

- Designs available for high volume applications that increase rigidity to improve performance
- Versatile boring heads that are flexible with changing applications while maintaining excellent performance
- Provides high precision with absolute repeatability to ensure every part is held to tolerance
- Offers an industry leading modular shank connection that maintains rigidity and reduces inventory on your boring system
- Available with both digital and analog settings
- Products:
 - Wohlhaupter® Boring Tools



NOTE: Adjustment accuracy of 0.0001" or 0.002mm on diameter



CRITERION®

Modular Boring Systems

- The modular capabilities are ideal for use across multiple different projects
- Offers versatile boring heads suitable for job shops and tooling rooms
- Provides an economical solution for low volume and/or short-term production applications
- Offers finish boring solutions
- Products:
 - Criterion® Boring Tools

S.C.A.M.I.®

Expandable Reaming Solutions

- Expandable cutting diameters accommodate for wear, which extends tool life
- Replaceable cutting heads and rings reduce waste and improve production time versus solid high speed steel and carbide reamers
- Hold tight tolerances to ensure processes are performed to accurate specifications
- Reduce tooling costs because many items are available for reconditioning
- Products:
 - ALVAN® Reamers



S.C.A.M.I.®

Roller Burnishing Solutions

- Produce excellent surface finishes
- Provide accurate size control
- Increase surface hardness
- Solutions for both through hole and blind hole applications
- Products:
 - S.C.A.M.I.® Roller Burnishing Tools





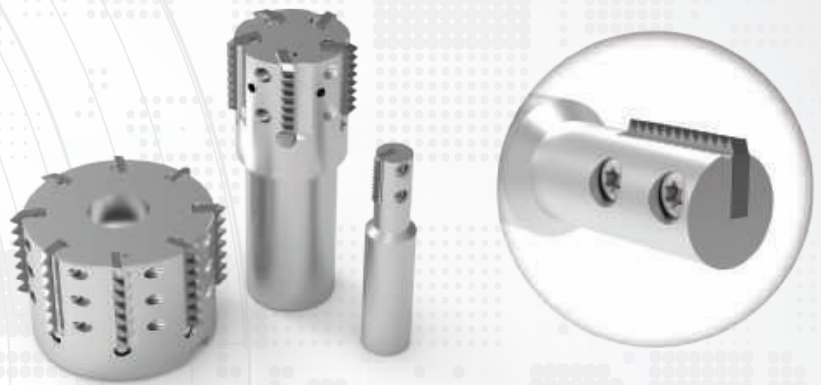
Solid Carbide Thread Mills

- Available with coolant through options
- Cover a wide range of thread forms
- Provide optimal solutions for both high production projects and short-run applications
- Products
 - AccuThread® 856
 - AccuThread® T3
 - ThreadMills USA™



Indexable Insert Thread Mills

- Three insert lengths are available that cover a wide range of thread forms
- Holders can utilize inserts with different pitches and thread forms
- Repeatability is achieved by both the bolt-in style and the pin style locking systems
- Increase tool life by 25 - 50% with Allied Machine's AM210® coating
- Products
 - AccuThread® 856: Bolt-in Style
 - AccuThread® 856: Pin Style




SPECIAL CAPABILITIES

When it comes to designing and developing special solutions for customers, Allied Machine is the top choice. If your application requires special tooling, give us a call. Our engineered specials are developed by the brightest engineers in the industry. Most of our standard tooling can be altered as specials, or we can create entirely new concepts for particularly unique applications.

One special tooling solution is Insta-Quote®, the online system that allows you to design your own special tooling 24/7. Receive a quote and drawings within minutes just by following the steps.

And with the addition of Superior® technology and capabilities, we can customize made-to-order solid carbide tools to achieve optimal results for your applications.

Whatever your application, Allied Machine has the answer.

Insta-Quote® 



 **SUPERIOR**



ToolMD®

Increase the production and success of your applications today.

- Direct access to 2D drawings and 3D models
- Assemble and view tool images in your browser
- Download drawings for use in most machining software programs
- Browse products, search item numbers, and save assemblies for future use

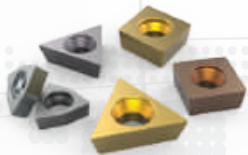


toolmd.com

WOHLHAUPTER® Boring Insert Selector

Find the best insert for your application.

- Generate the correct boring insert for your job in just six easy steps
- Choose type, shape, substrate, insert form, nose radius, and material
- Order easily by adding the item to your cart



alliedmachine.com/bis

Product Selector

Use the product selector to find the right tool for your application.

- Follow guided steps to generate the right tool for your application
- Learn about your recommended tool and how to maximize its performance



alliedmachine.com/productselector

Insta-Code®



Eliminate the wait. Get your program now.

- Choose the best thread mill for your application
- Create program code for your machine
- Available as a PC download app (that can be used offline)
- Website app available 24/7



Insta-Code also has a
Cycle Time Calculator

alliedmachine.com/InstaCode



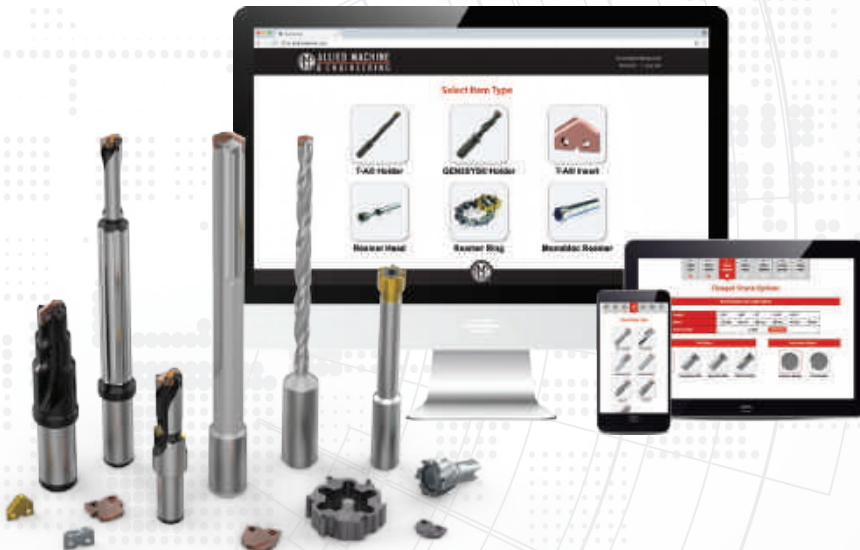
Insta-Quote®



Design your custom tooling and receive a drawing and quote...all within minutes.

- Design and quote your own tooling
- Generate the solution you need in just a few steps
- Features the following products:

- T-A® Inserts
- T-A® Holders
- GEN3SYS® XT Holders
- ALVAN® Reamers



iq.alliedmachine.com

Solution Hub App

All Allied all the time.

- Quickly look up product information
- Links to our free online tools
- Locate distributors
- Stay up to date on news and events



Machinist Tool App

Quickly convert cutting tool parameters for the machine inputs you need.

- Input data to calculate the RPM and speed and feed rates
- Also features the Boring Insert Selector
- Access product literature right at your fingertips



Customer Support

Support You Can Count On

Allied Machine has many lines of support to ensure we're available to assist you at all times. It's important to establish relationships with new customers, but we also know it's equally important to strengthen and support relationships with existing customers. Whether you need help with an order or you need someone to come assist you at the spindle, we have the right people to get you what you need.



1

Inside Sales Support

Our inside sales team is trained to handle your account information and general inquiries. We are happy to assist you and find the answers to your questions.

☎ 1.330.343.4283 ext. 8610

☎ 1.800.321.5537 (toll free United States and Canada)

✉ insidesales@alliedmachine.com



2

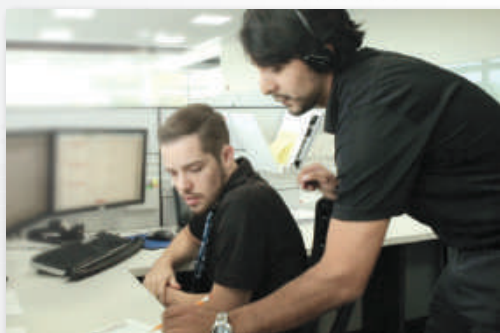
Engineering Support

Our highly trained and skilled Application Engineers are here to assist you. If you are experiencing technical difficulties, our engineers will recommend the best solutions to the problem. Speeds and feeds, coolant pressure, and other machining components all affect the performance of our tooling. Our AEs are experienced in working with difficult materials in many different environments. Give us a call and put our knowledge to the test.

☎ 1.330.343.4283 ext. 7611

☎ 1.800.321.5537 (toll free United States and Canada)

✉ appeng@alliedmachine.com



3

Field Support

Allied Machine provides local engineering support all over the world. Our Field Sales Engineers (FSEs) spend months training in-house before going to the field. This support line allows us to provide assistance to our customers right at the spindle. They are available to visit your facility, run demos and tests, and work hand-in-hand with machine operators and engineers to find the best possible tooling solutions.

NOTE: If you do not know your local FSE, please contact us

☎ 1.330.343.4283

☎ 1.800.321.5537 (toll free United States and Canada)

✉ info@alliedmachine.com





Allied Tool Academy

Online | On-site Technical Education Seminar (TES) | LIVE (Broadcasting)

Online Training

Get **all** the tooling training of our 3-day in-person Technical Education Seminar (TES) through the online **Allied Tool Academy** training platform. Level up your tooling IQ through a series of product overviews, demos, and short quizzes.

- Online TES Certification as well as other training modules
- On demand
- On YOUR schedule



Register online today:
www.alliedtoolacademy.com



Allied LIVE (Broadcasting)

Join us for **LIVE broadcast** training events where you will have the ability to learn about our tooling, watch live demos, and ask our trainers questions.

- Online
- Quick brief presentation provides basic knowledge of our products
- Watch live demos of tools at the spindle at different speeds and feeds

Register online today:
www.alliedmachine.com/live

On-site Technical Education Seminar (TES)

Allied Machine's **Technical Education Seminar (TES)** puts the attendees in front of the machines. When you attend our three day TES program, you'll gain first-hand experience in **real-life** application situations. Test and experiment with different speeds and feeds, observe the results, and discover the best solution.

- Training Lab: In-depth training at the spindle allows you to choose speeds and feeds
- Learning Lab: Quick, brief sessions provide basic knowledge of our products
- Facility Tours: Take guided tours of our two manufacturing facilities located in Dover, Ohio



Register online today:
www.alliedmachine.com/TES



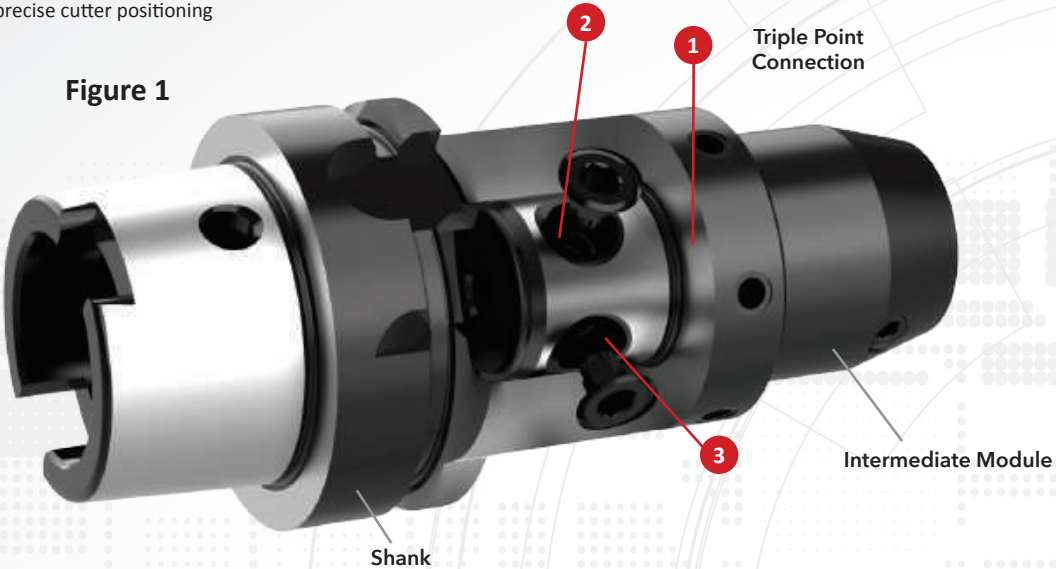
Allied Machine
Training Facility
485 West 3rd Street
Dover, OH 44622

The MVS Connection

Wohlhaupter® GmbH developed the world's first modular tooling system called MultiBore® in 1973. The modular tooling system was designed to be compatible with all machine spindles, and its connection features a triple point clamp (Figure 1). The triple point clamp maximizes rigidity and creates an accuracy less than 3µm when the tool is changed.

- Ensures high axial clamping forces on mating surfaces
- Provides maximum rigidity
- Threaded taper pins for precise cutter positioning

Figure 1



MVS Connection Color Guide

Wohlhaupter® created a unique color-coding system to find the right connections for different tool components quickly and easily. Each Wohlhaupter / MVS connection size has its own color-coding. Simply match the colors to select the correct combination of tool components (Figure 2). We've also incorporated the color-coding system into our packaging to reduce setup time even more.

Figure 2



M 8	19,5 - 22	22 - 11	25 - 14	32 - 18	40 - 22	50 - 28	63 - 36	80 - 36	100 - 56	D 40	D 60
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MVS Connection Example - Selecting the Correct Intermediate Module

Example Machining Parameters

Hole Diameter: 1.968" (50.00mm)

Hole Depth: 3.149" (80.00mm)

Machine Spindle: HSK-A 63 DIN 69893

1 Select your boring tool

Example: 364 Balance Boring Head

2 Select the tool that meets the required boring range

MVS connection: **32 - 18**

A = 1.496" - 1.988" (38.00mm - 50.50mm)

Part No.: **364033**



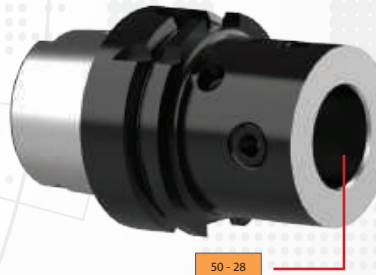
3 Select the master shank that fits your spindle

Machine spindle: DIN 69893 HSK

4 Choose the connection that fits your application

MVS connection: **50 - 28**

Part No.: **245012**



5 Select the correct intermediate module

Must meet the hole depth requirements and MVS connections for both the boring head and shank

Hole depth: 3.149" (80.00mm)

Boring tool 364033 length (X₁): 2.598" (66mm)

Minimum required length of adapter: 0.551" (14mm)

Boring tool 364033 MVS connection: **32 - 18**

Master shank 245012 MVS connection: **50 - 28**

Adapter Part No.: **219032**



1 Balance 365 (364) Boring Head

2

MVS Connection		Boring Range		Part No.	
D ₁ & D ₂	A	A	A	Insert Holder	Boring Head
19 - 11	20.00 - 24.50	46.00	364077	364030	
22 - 11	24.50 - 29.50	46.00	210059	364031	
22 - 11	24.50 - 29.50	46.00	210069	364031	
25 - 14	29.00 - 38.50	56.00	210059	364032	
25 - 14	29.00 - 38.50	56.00	210069	364032	
32 - 18	38.00 - 50.50	66.00	264051	364033	
32 - 18	38.00 - 50.50	66.00	264077	364033	
40 - 22	50.00 - 65.50	75.00	210052	364034	
40 - 22	50.00 - 65.50	75.00	210062	364034	

3 Master Shanks

Imperial: **DIN 69893 HSK**

Taper Size	Conn.	Connection	Part No.
40	40	40 - 22	246016
40	50	50 - 28	246014
50	40	40 - 22	246015
50	50	50 - 28	245011
63	25	25 - 14	246012
63	32	32 - 18	246013
63	40	40 - 22	246014
63	50	50 - 28	245012
63	63	63 - 36	245013
63	80	80 - 50	240009
63	80	80 - 50	252000*

4

5

Adapter	Part No.
40 - 22	219038
40 - 22	219039
40 - 22	219040
50 - 28	219051
50 - 28	219041
50 - 28	219052
50 - 28	119094
50 - 28	119054
50 - 28	119055
50 - 28	119010
50 - 28	219030*
63 - 36	219085
63 - 36	219086
63 - 36	119012
63 - 36	219032
63 - 36	219037
63 - 36	219088
63 - 36	119058

The background of the entire page is a solid red color. Overlaid on this background is a complex geometric pattern. It features several concentric circles that are centered towards the left side of the page. Intersecting these circles is a grid of thin, light-red lines. Some of these lines are straight, while others are curved, following the circular pattern. The overall effect is a technical or architectural drawing style, reminiscent of a blueprint or a specialized grid used in engineering or design.

SECTION

B10-K

Special Boring Solutions

Wohlhaupter® Special Boring Solutions



Special Design Tooling

When it comes to special solutions for customers, Wohlhaupter has unique capabilities to effectively design and develop special boring tools. Our special boring tools are designed for specific machines, processes, and materials to help save you time and money.

If you have a particularly unique or difficult application, give our Application Engineering team a call.

phone: 330.343.4283 ext: 7611 | email: appeng@alliedmachine.com

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



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Visit www.alliedmachine.com for the most up-to-date information and procedures.

Applicable Industries



Aerospace



Agriculture



Automotive



Firearms



General
Machining



Oil & Gas



Renewable
Energy

Wohlhaupter® Special Boring Solutions Table of Contents

Special Tooling Solutions

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Padded Line Boring Tool	5
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Online Tools

ToolMD®	8
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GROOVING TOOLS

EK GROOVER

- ▶ Create complex grooves faster and deeper than ever before
- ▶ Eliminate chatter in hard-to-reach internal forms
- ▶ The electronically-controlled insert release can be adapted to most machine tools
- ▶ Single or double grooving in one operation

ROUGH BORING TOOLS

LAY DOWN CARTRIDGE

- ▶ Increase the productivity of your roughing tool while protecting your investment
- ▶ If the tool is ever damaged, simply replace a cartridge and resume making chips

Anti-Vibration | Multi-Step Boring Tool



SPECIAL BORING TOOLS

ANTI-VIBRATION

- ▶ Vibration dampening rings
- ▶ Optimized tool weight
- ▶ Used to reduce harmonic vibration in deeper boring applications



SPECIAL BORING TOOLS

MULTI-STEP BORING TOOL

- ▶ Fine adjustment tool for reverse machining
- ▶ Combined with multi-diameter fine adjustable cartridgess for finish machining



OD Turning | Padded Line Boring Tool



SPECIAL BORING TOOLS

OD TURNING TOOLS

- ▶ Multi-step OD turning
- ▶ Drastically reduce cycle time
- ▶ Improve surface finish and feature concentricity

SPECIAL BORING TOOLS

PADDED TOOLING

- ▶ Aids in stable part processing
- ▶ Expands length to diameter capabilities
- ▶ Improves surface finish
- ▶ Pads are replaceable to extend tool life



3E^{TECH} BORING TOOL

MULTI-STEP BORING TOOL

- ▶ Easy diameter adjustments with 3E^{TECH}
- ▶ One digital readout module to use on all steps



3E^{TECH} BORING TOOL

LINE BORING TOOL

- ▶ One digital readout module used on all steps
- ▶ Easy diameter adjustment at the machine spindle



DigiBore Special Boring Tools



FINISH BORING TOOLS

DIGIBORE WITH 249 (248)

- ▶ Standard DigiBore head, standard 249(248) head, and special slide for precise 2-step bore
- ▶ MVS connection



FINISH BORING TOOLS

DIGIBORE SPECIAL

- ▶ Standard DigiBore boring head with OD turn and OD chamfer insert holder
- ▶ MVS connection

Combi-Line Special Boring Tool



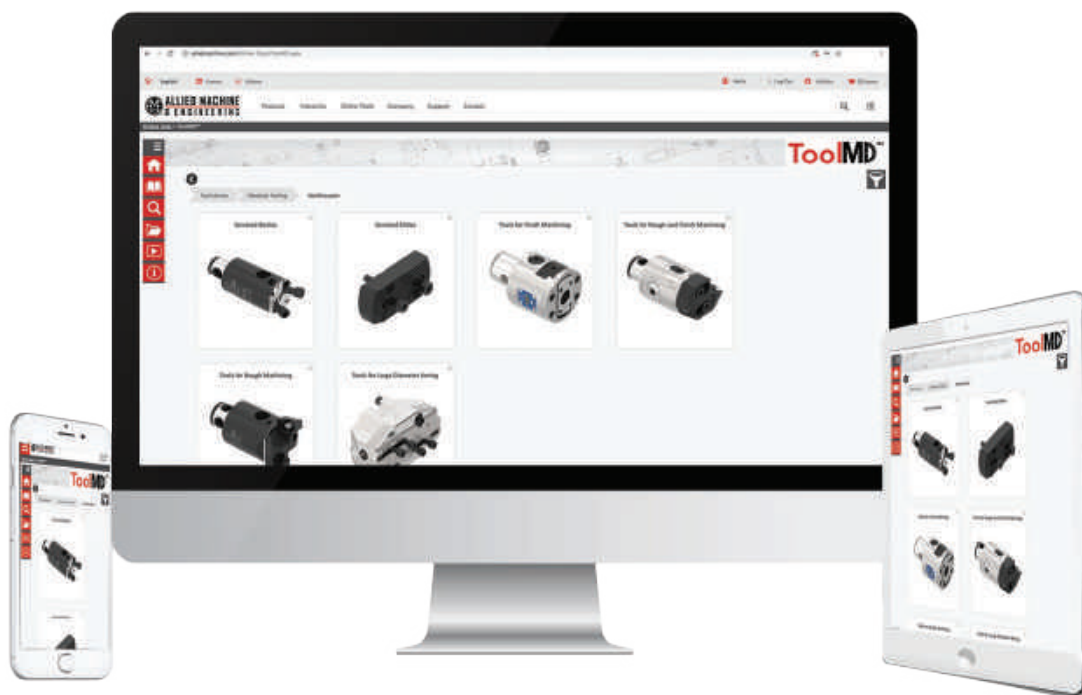
ROUGH, FINISH, and CHAMFER BORING TOOLS

COMBI-LINE

- ▶ Standard Combi-Line tooling with added chamfer cartridge
- ▶ MVS connection

ToolMD

ToolMD[®]
www.toolmd.com



Design Your Own Solutions

ToolMD is a configurator for Wohlhaupter modular tooling systems that allows customers to virtually build their own solution. This online-based simulator puts the entire Wohlhaupter product line at your fingertips. It provides a digital bank of every individual part that Wohlhaupter manufactures in either inch or metric.

Once you select a component, you will be guided by a series of user-friendly prompts to select the next components until you have built your tooling system. Throughout the process, you can monitor the size of your custom tool and ensure what you're building matches your real-life specifications. Once a complete system is virtually assembled, the program will render the tool in either a 2D or 3D drawing to view on your device.

Designing your tools with ToolMD saves you time and allows you to instantly obtain the right tool for the job.



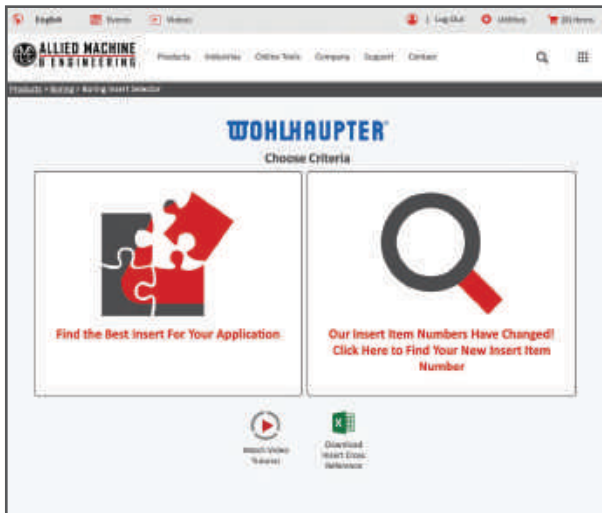
Design anytime from anywhere.
 Available online 24/7.



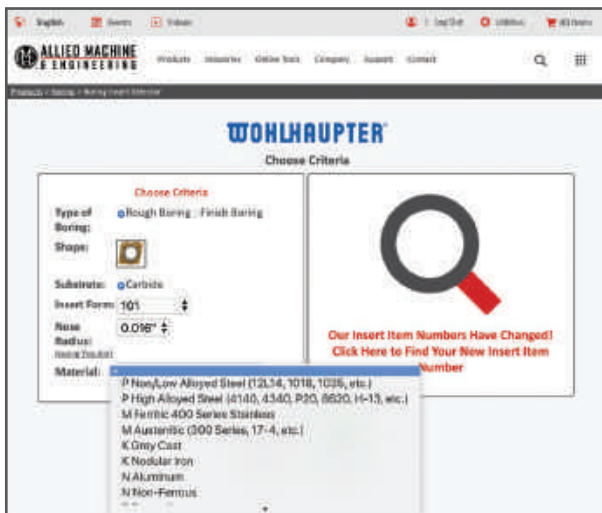
Boring Insert Selector

WOHLHAUPTER® | Boring Insert Selector

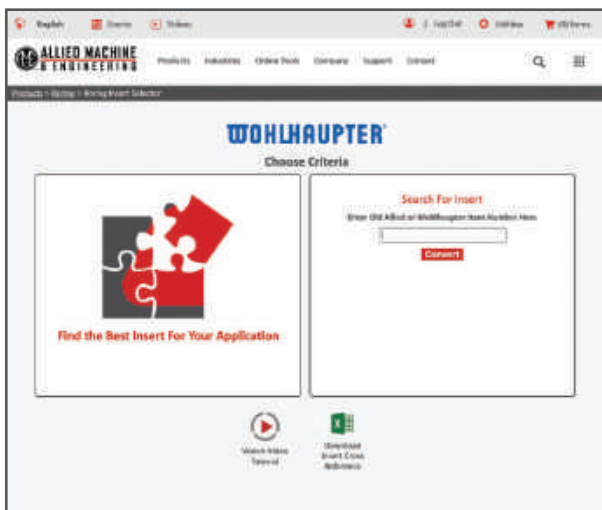
www.alliedmachine.com/bis



- Generate the correct boring insert for your application in just six easy steps



- Choose type, shape, substrate, insert form, nose radius, and workpiece material
- Order easily by adding the item to your cart



- Search for your new insert item number by entering your old item number

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