

Davenport and Brown & Sharpe Tooling



www.elklaketool.com

203 E.C. LOOMIS DRIVE, P.O. BOX 79, ELK RAPIDS, MICHIGAN 49629 (231) 264-5616

Table of contents

Description	Page
Davenport and Brown and Sharpe .500 IC Inserts	2
Davenport Insert Station Layout	3
Davenport and Brown and Sharpe .750 IC Inserts	4
Brown and Sharpe . Inserts Right Hand Rotation (Forward Rotation) Traub BS205& BS205N	6 & 7
Brown and Sharpe . Inserts Left Hand Rotation (Backward Rotation) Traub BS206& BS206N	8 & 9
Davenport and Brown and Sharpe Box Tool Holders and Inserts	10
Davenport and Brown and Sharpe Special Form Applications and Inserts	11
Other Tool Holders	12
List of all Tool Holders and description	

The products on the follwing pages can be used on CNC or Traub Machines

3/16/2017

The Elk Lake Tool/Vibor Cutting Tool System

DAVENPORT

Tool holder information

ELT #	VIBOR #	Description
DP101	DITH-1	For use in all Positions
DP102	DITH-2	For use in Close Proximity of Spindle (STA 2, 3, & 4)

Insert information

All Inserts are Micro-Grain Carbide Titanium Nitride Coated Grade EL166

Cut-Off Inserts R.H. Machining

Part # RH	WOC	Lead Angle	Part # LH
DP115003	.062	0°	DP115007
DP115005		5°	DP115006
DP115008		10°	DP115009
DP115001		15°	DP115004
DP116003	.078	0°	DP116007
DP116005		5°	DP116006
DP116008		10°	DP116009
DP116001		15°	DP116004
DP117003	.093	0°	DP117007
DP117005		5°	DP117006
DP117008		10°	DP117009
DP117001		15°	DP117004
DP118003	.125	0°	DP118007
DP118005		5°	DP118006
DP118008		10°	DP118009
DP118001		15°	DP118004

RH:Cut-off close to spindle

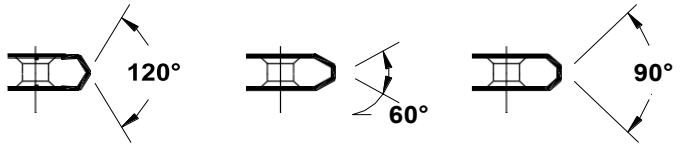
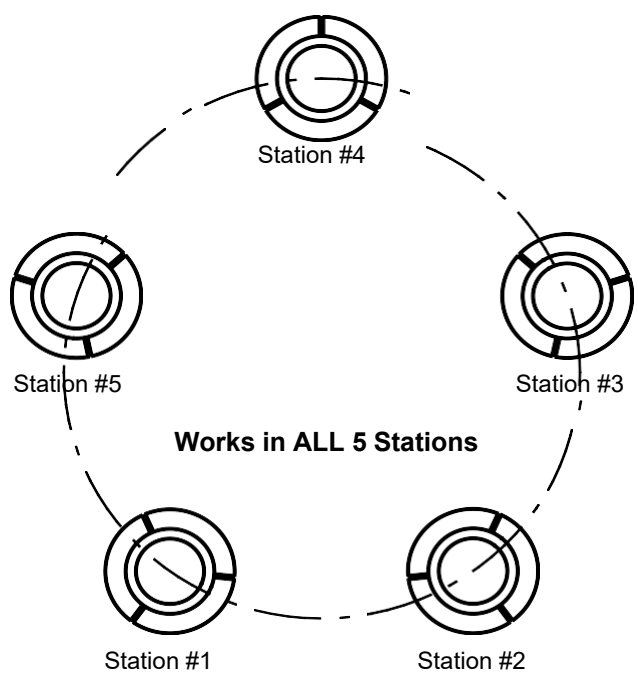
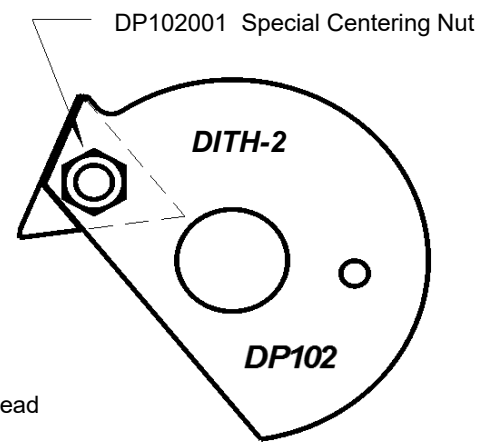
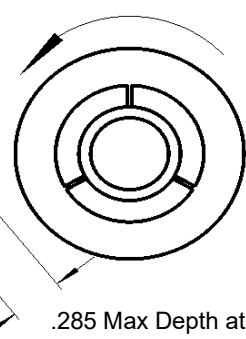
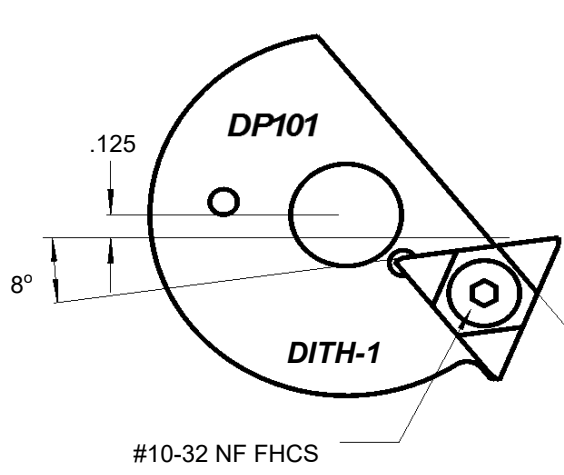
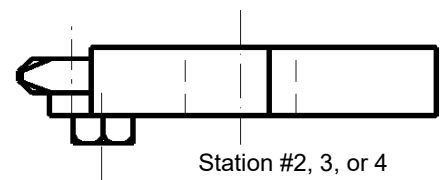
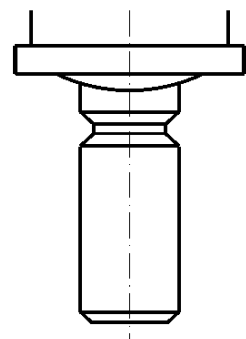
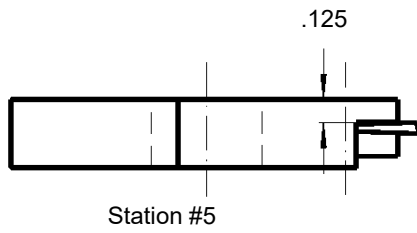
LH:Cut-off close to pick-off collet

Straight Form Inserts

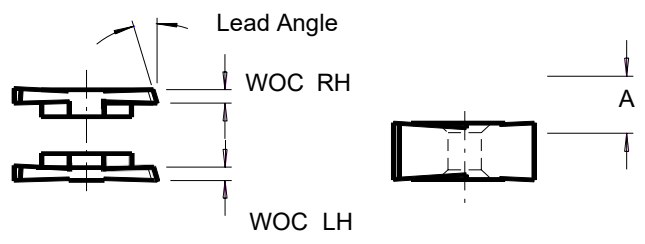
45° Double Chamfer Inserts

Part #	Width "A"	Part #	Max Chamfer	WOC
DP114009	.188	DP115002	.063 x 45°	.062
DP114010	.250	DP116002	.086 x 45°	.078
DP114011	.313	DP117002	.079 x 45°	.093
DP114012	.375	DP118002	.063 x 45°	.125
DP114013	.500	60° Included Double Chamfer Insert		
DP114014	.625	Add - 60 to the Part # above		
DP114015	.750	120° Included Double Chamfer Insert		
		Add - 120 to the Part # above		





Double Chamfer Inserts



Tool holder information

ELT #	VIBOR #	Description
DP103	DITH-35	For use in Station 5 and 3 only

Insert information

All Inserts are Micro-Grain Carbide Titanium Nitride Coated Grade EL166

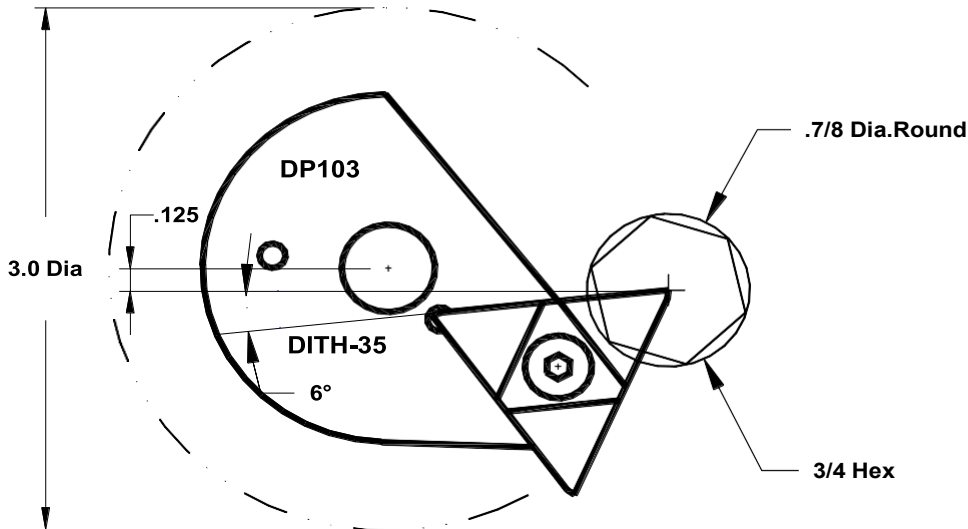
Cut-Off Inserts R.H. Maching

Part # RH	WOC	Lead Angle	Part # LH
BS250003	.062	0°	BS250007
BS250005		5°	BS250006
BS250008		10°	BS250009*
BS250001		15°	BS250004*
BS251003	.078	0°	BS251007
BS251005		5°	BS251006*
BS251008		10°	BS251009*
BS251001		15°	BS251004*
BS252003	.093	0°	BS252007
BS252005		5°	BS252006
BS252008*		10°	BS252009
BS252001		15°	BS252004*
BS253003	.125	0°	BS253007
BS253005		5°	BS253006*
BS253008		10°	BS253009*
BS253001		15°	BS253004*

RH:Cut-off close to spindle

LH:Cut-off close to pick-off collet

* NON STOCK



BROWN and SHARPE Forward Rotation
Counter Clockwise Rotation (RIGHT Hand Machining)

AND

BROWN and SHARPE Backward Rotation
Clockwise Rotation (LEFT Hand Machining)

The Elk Lake Tool/Vibor Cutting Tool System

BROWN & SHARPE - RH or FORWARD ROTATION

Tool holder information

ELT #	VIBOR #	Description	Screw	Center hole
BS205 *	00BS.5RH	.500 I.C. Insert RH Machining	#10-32 FHCS	3/8 - 16
BS207	0BS.5RH	.500 I.C. Insert RH Machining	#10-32 FHCS	1/2 - 13
BS202	2BS.5R	.500 I.C. Insert RH Machining	#10-32 FHCS	5/8 - 11
BS210 **	2BS.75R	.750 I.C. Insert RH Machining	#10-32 FHCS	5/8 - 11

All Inserts are Micro-Grain Carbide Titanium Nitride Coated Grade EL166

*** Also TRAUB Machines**
Insert information

**** #3 B&S Modify Hook Bolt May be Required**

Cut-Off Inserts

Part # RH	WOC	Lead Angle	Holder
DP115003	.062	0°	205, 207, 202
DP115005		5°	
DP115008		10°	
DP115001		15°	
BS250003		0°	210
BS250005		5°	
BS250008		10°	
BS250001		15°	
DP116003	.078	0°	205, 207, 202
DP116005		5°	
DP116008		10°	
DP116001		15°	
BS251003		0°	210
BS251005		5°	
BS251008		10°	
BS251001		15°	

Part # RH	WOC	Lead Angle	Holder
DP117003	.093	0°	205, 207, 202
DP117005		5°	
DP117008		10°	
DP117001		15°	
BS252003		0°	210
BS252005		5°	
BS252008		10°	
BS252001		15°	
DP118003	.125	0°	205, 207, 202
DP118005		5°	
DP118008		10°	
DP118001		15°	
BS253003		0°	210
BS253005		5°	
BS253008		10°	
BS253001		15°	

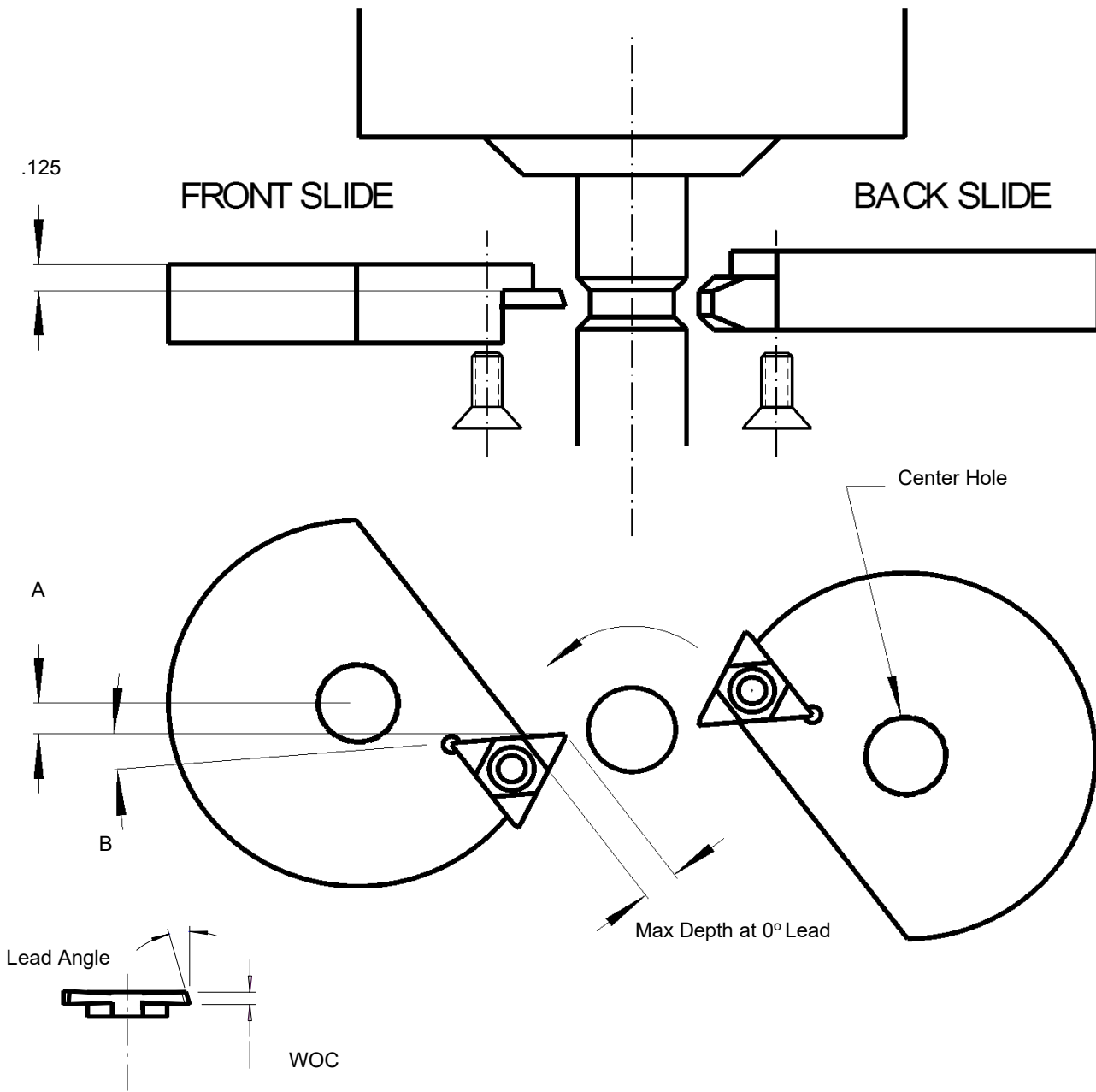
*** NON STOCK**

Double Chamfer Inserts (see page 1 & 2)



The Elk Lake Tool/Vibor Cutting Tool System

BROWN & SHARPE - RH or FORWARD ROTATION



Cut-off Inserts

	A	B	Max Depth
205	.125	5°	.285
207	.156	5°	.285
202	.250	5°	.285
210	.250	5°	.510

See page #2 for other inserts



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629
 Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com

The Elk Lake Tool/Vibor Cutting Tool System

BROWN & SHARPE - LH or BACKWARD ROTATION

Tool holder information

ELT #	VIBOR #	Description	Screw	Center hole
BS206	00BS.5LH	.500 I.C. LH Machining	#10-32 FHCS	3/8 - 16
BS208	0BS.5LH	.500 I.C. LH Machining	#10-32 FHCS	1/2 - 13
BS203	2BS.5L	.500 I.C. LH Machining	#10-32 FHCS	5/8 - 11
BS211	2BS.75L	.750 I.C. LH Machining	#10-32 FHCS	5/8 - 11

All Inserts are Micro-Grain Carbide Titanium Nitride Coated Grade EL166

Insert information

Cut-Off Inserts L.H. Machining

Part #LH	WOC	Lead Angle	Holder
DP115007	.062	0°	{ 206, 208, 203
BS220001		15°	
BS250007	.062	0°	211 *
BS225005*		5°	
BS225008*		10°	
BS225001*		15°	
DP116007	.078	0°	{ 206, 208, 203
BS221001		15°	
BS251007*	.078	0°	211 *
BS226005*		5°	
BS226008*		10°	
BS226001*		15°	

Part #LH	WOC	Lead Angle	Holder
DP117007	.093	0°	{ 206, 208, 203
BS222001		15°	
BS252007*	.093	0°	211 *
BS227005*		5°	
BS227008*		10°	
BS227001*		15°	
DP118007	.125	0°	{ 206, 208, 203
BS223001		15°	
BS253007*	.125	0°	211 *
BS228005*		5°	
BS228008*		10°	
BS228001*		15°	

* .750 IC Insert

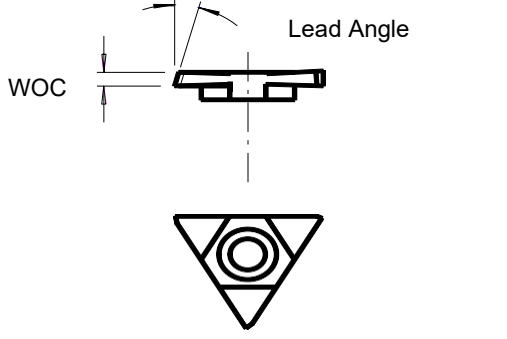
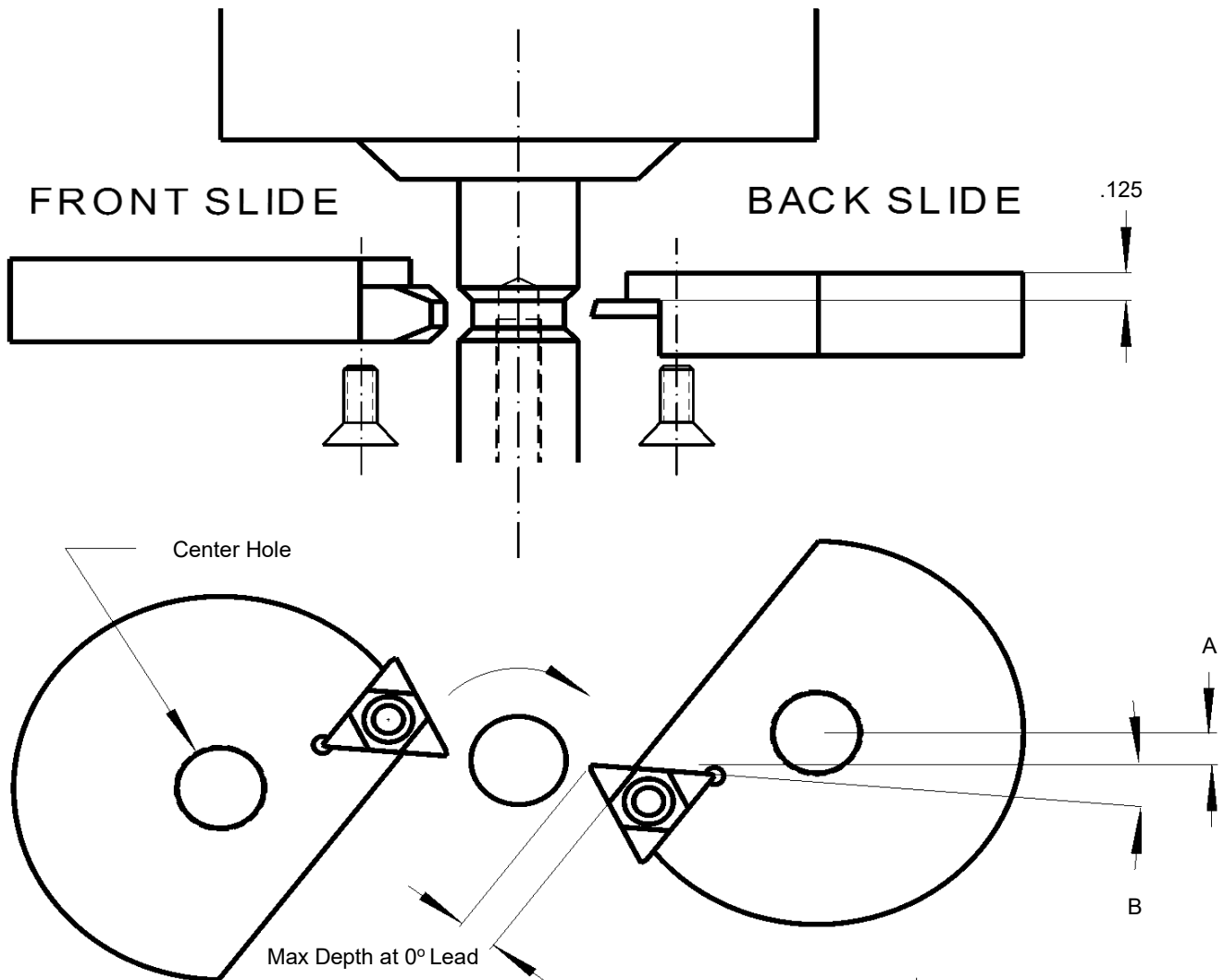
Double Chamfer Inserts (see page 1 & 2)



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629
 Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com

The Elk Lake Tool/Vibor Cutting Tool System

BROWN & SHARPE - LH or BACKWARD ROTATION



Cut-off Inserts L.H. Rotation

	A	B	Max Depth
206	.125	5°	.285
208	.156	5°	.285
203	.250	5°	.285
211	.250	5°	.510

See page #2 for other inserts



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629
 Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com

The Elk Lake Tool/Vibor Cutting Tool System

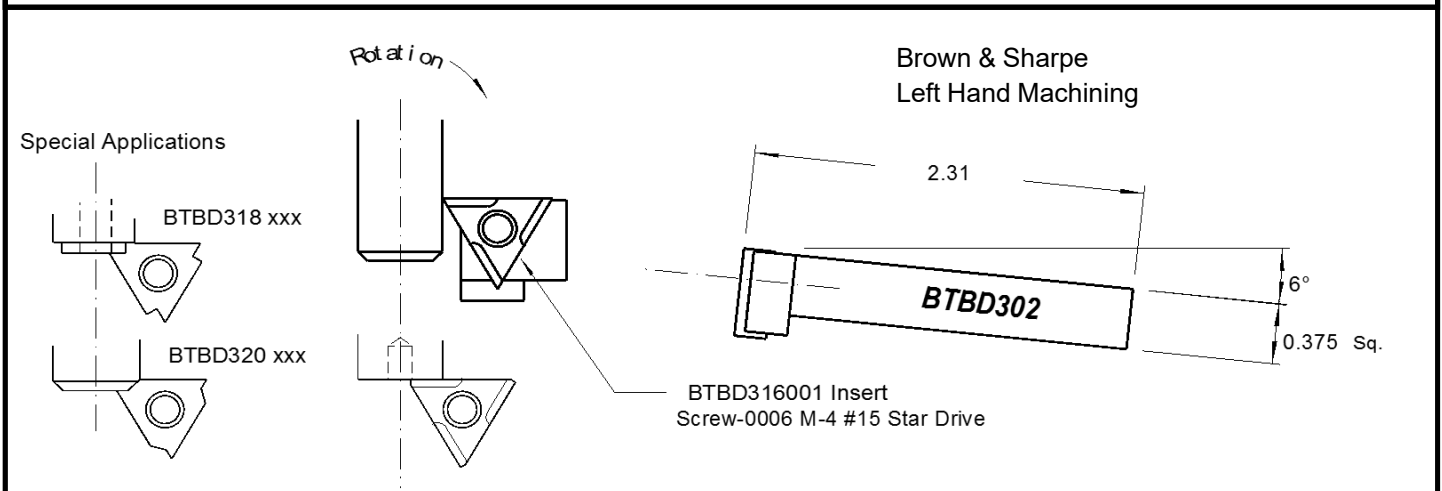
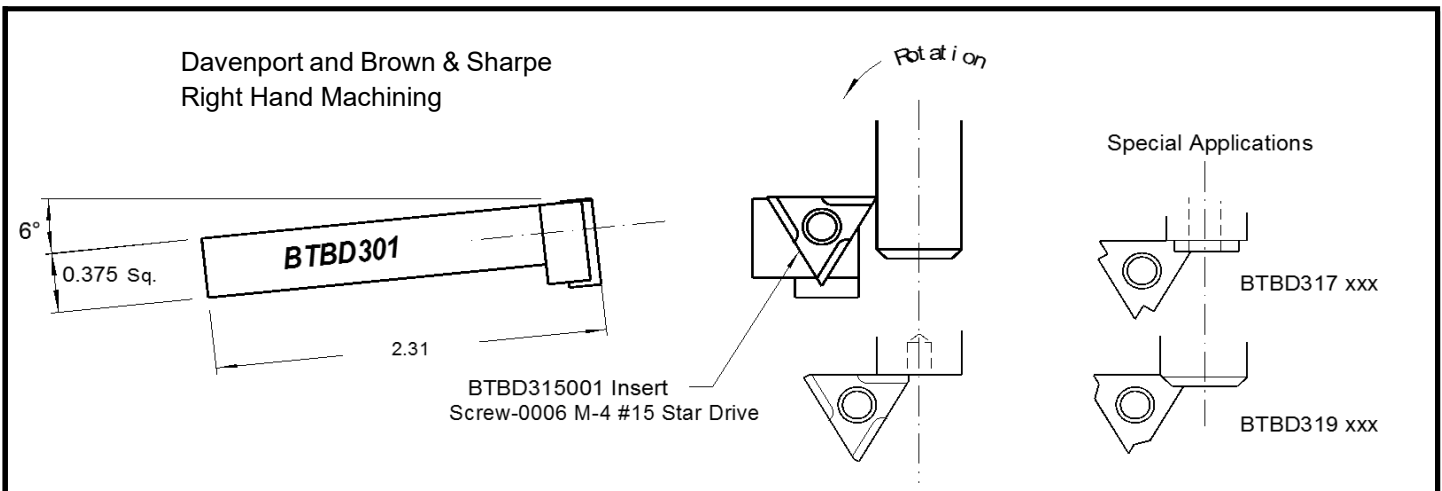
Davenport and Brown & Sharpe Box Tool

Tool holder information BTBD#

ELT BTBD#	VIBOR #	Description
301	BTIH-1	For Right Hand Machining
302	BTIH-2	For Left Hand Machining

Insert information All Inserts are Micro-Grain Carbide Titanium Nitride Coated Grade EL166

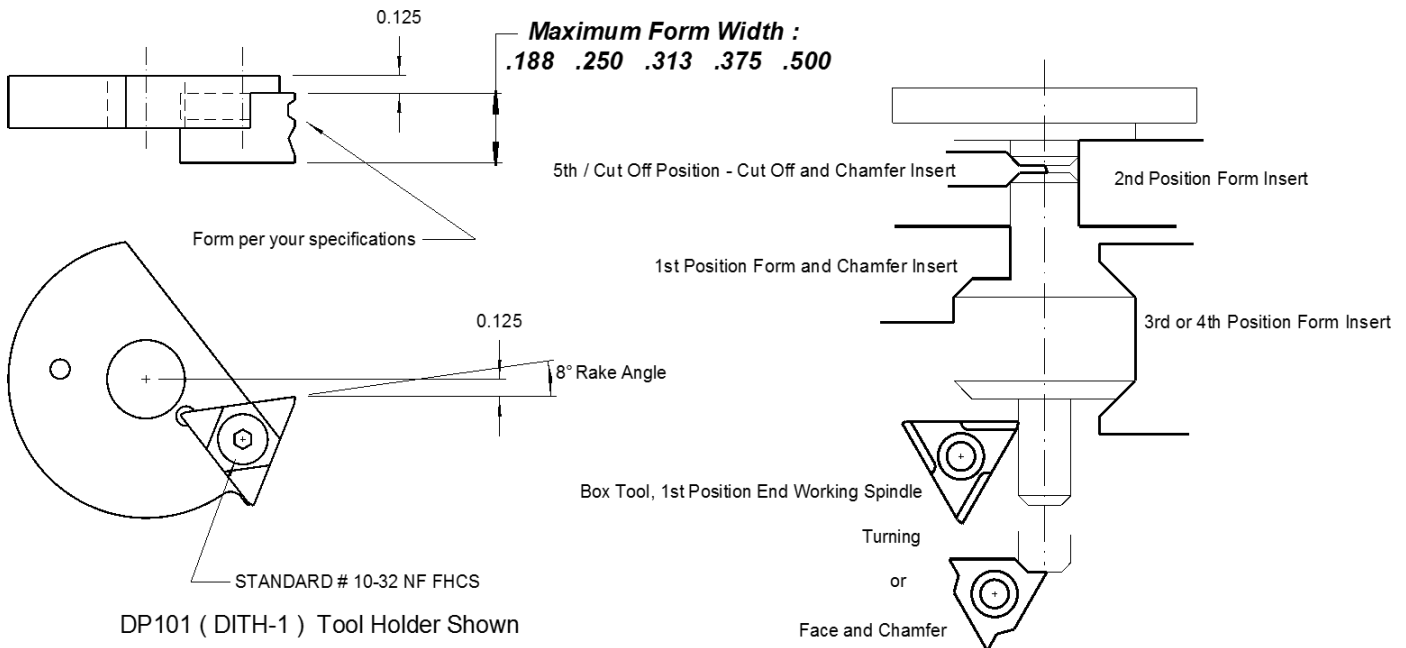
Insert #	Rotation	I.C.	Thickness	Hole	Insert Screw
315001	R.H.	0.375	0.188	0.173	Screw-0006 (M-4) Wrench-0002
316001	L.H.	0.375	0.188	0.173	Screw-0006 (M-4) Wrench-0002
317xxx	R.H.	} Special Face & Turn - Specify dimensions when ordering			
318xxx	L.H.				
319xxx	R.H.	} Special Face & Chamfer - Specify dimensions when ordering			
320xxx	L.H.				



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629
Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com

The Elk Lake Tool/Vibor Cutting Tool System

DAVENPORT and BROWN & SHARPE Special Form Tool Applications (Concept for Davenport shown)



DAVENPORT AND 00, 0, 02 - BROWN & SHARPE

Part #	Description	I.C.	Width	
DP114001	TNEC-43	.500	.188	
DP114002	TNEC-44	.500	.250	
DP114003	TNEC-45	.500	.313	
DP114004	TNEC-46	.500	.375	
DP114005	TNEC-48	.500	.500	
DP114007	TNEC-412	.500	.750	
314001	TNEW-33	.375	.188	Box Tool

All Davenport Tool Holders can be used in all (5) stations.

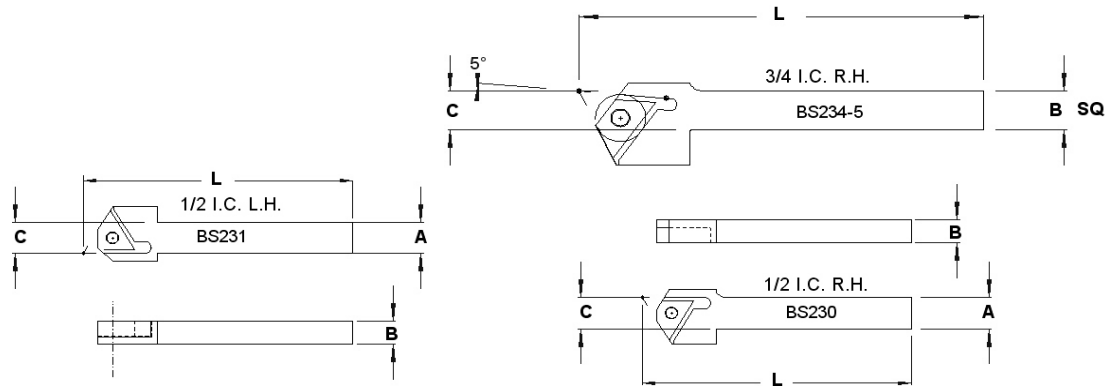
Send your Part print or Insert sketch, we will quote per your request.



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629
Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com

The Elk Lake Tool/Vibor Cutting Tool System

DAVENPORT and BROWN & SHARPE Additional Tool Holders



Part#	Insert Size	A	B	C	L	R.H. / L.H.	Rake Angle
BS230	I.C. 0.500	0.500.	0.375	0.500.	4.0.	R.H.	0°
BS231	I.C. 0.500	0.500.	0.375	0.500.	4.0.	L.H.	0°
BS232	I.C. 0.500	0.500.	0.500.	0.500.	4.0.	R.H.	0°
BS233	I.C. 0.500	0.500.	0.500.	0.500.	4.0.	L.H.	0°
BS236	I.C. 0.750	0.500.	0.500.	0.500.	6.0.	R.H.	0°
BS237	I.C. 0.750	0.500.	0.500.	0.500.	6.0.	L.H.	0°

DAV-ST-1	Shave tool holder for 3/8 Thick x width required C style Brazed Tool Bits
DAV-ST-2	Shave tool holder for 3/8 Thick x width required C style Brazed Tool Bits
DP105	Kwick Form Holder for C-6 3/8 square brazed Tools

WIRE EDM FORM TOOL SERVICE



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629
 Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com

DAVENPORT and BROWN & SHARPE

Holder List

ELT #	VIBOR #	Description
DP101	DITH-1	Davenport
DP101W	DITH-1.5	Davenport
DP102	DITH-2	Davenport
DP103	DITH-35	Davenport
BS202	2BS.5RH	Brown & Sharpe
BS202W		1.0 wide insert Holder
BS203	2BS.5LH	Brown & Sharpe
BS204	00BS.5RH	Brown & Sharpe
BS205N	00BS.5RH Neutral Rake	Brown & Sharpe
BS206	00BS.5LH	Brown & Sharpe
BS207	0BS.5RH	Brown & Sharpe
BS207N	0BS.5RH Neutral Rake	Brown & Sharpe
BS208	0BS.5LH	Brown & Sharpe
BS212	0BS.75RH	Brown & Sharpe
BS210	2BS.75RH	Brown & Sharpe
BS211	2BS.75LH	Brown & Sharpe
BTBD301	BTIH-1	Box Tool Holder - RH
BTBD302	BTIH-2	Box Tool Holder - LH
BS230	1/2 I.C. Insert	Stick Tool Holder R.H.
BS231	1/2 I.C. Insert	Stick Tool Holder L.H.
BS232	1/2 I.C. Insert	Stick Tool Holder R.H.
BS233	1/2 I.C. Insert	Stick Tool Holder L.H.
BS236	3/4 I.C. Insert	Stick Tool Holder R.H.
BS237	3/4 I.C. Insert	Stick Tool Holder L.H.

Stick Tools and Holders			
DAV-ST-1		Shave Tool Holder (1) Hole	
DAV-ST-2		Shave Tool Holder (2) Hole	
DP105	Kwik Form C-6 Style Holder	"A" Position Holder	
C-6	Form Tool Blank	.375 x .375	Micro Grain
C-7 x .375	Form Tool Blank	.438 x .375	Micro Grain
C-8 x .375	Form Tool Blank	.500 x .375	Micro Grain
C-10 x .375	Form Tool Blank	.625 x .375	Micro Grain
C-12 x .375	Form Tool Blank	.750 x .375	Micro Grain



203 E.C. Loomis Dr. P.O. Box 79 Elk Rapids, MI 49629

Phone: 888-292-4501 Fax: 1-231-264-5927 www.elklaketool.com