

Common cavities and tooling

RE 18325-70/10.12

Replaces: RE 18325-70/07.12

2-way

3-way / 3-way short

4-way

Summary

Description **Page**

Common cavity **2-way**

CA-08A-2N	2
CA-10A-2N	2
CA-12A-2N	2
CA-16A-2N	2
CA-20A-2N	2
Tools	2

Common cavity **3-way short**

CA-08A-3C	3
CA-10A-3C	3
CA-12A-3C	3
CA-16A-3C	3
CA-20A-3C	3
Tools	3

Description **Page**

Common cavity **3-way**

CA-08A-3N	4
CA-10A-3N	4
CA-12A-3N	4
CA-16A-3N	4
CA-20A-3N	4
Tools	4

Common cavity **4-way**

CA-08A-4N	5
CA-10A-4N	5
CA-12A-4N	5
CA-16A-4N	5
CA-20A-4N	5
Tools	5

Common cavities - Tools

2-way

1 mm = 0.03937 in

1 in = 25.4 mm

TWO WAY		CA-08A-2N	CA-10A-2N	CA-12A-2N	CA-16A-2N	CA-20A-2N
<p>General tolerance : ± 0.3 mm</p> <p> 0.03 0.02 </p>	A	3/4-16 UNF-2B	7/8-14 UNF-2B	1-1/16 12 UN-2B	1-5/16 12 UN-2B	1-5/8 12 UN-2B
	B	26	30	35	42	48
	C	20.6 ^{+0.1} ₋₀	23.9 ^{+0.1} ₋₀	29.2 ^{+0.1} ₋₀	35.5 ^{+0.1} ₋₀	43.5 ^{+0.1} ₋₀
	D1	12.7 ^{+0.05} ₋₀	15.87 ^{+0.05} ₋₀	22.22 ^{+0.05} ₋₀	28.60 ^{+0.05} ₋₀	36.52 ^{+0.05} ₋₀
	E	2.6 ^{+0.3} ₋₀	2.6 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.4 ^{+0.3} ₋₀
	F	13	15	20	20	22
	G	9	12	18	19	25
	G1	12	15	19	24	35
	H1	14	18	26	25	31
	L1	20.5	25.5	36.5	36	46
	L2	29	34.5	48	49	59
	M	1.5	1.5	-	-	-

TOOLS (ALUMINIUM/STEEL *)	ORDERING CODE				
DRILL 	Ø G1	Ø G1	Ø G1	Ø G1	Ø G1
FORM DRILL 	P-CA-08A-2N	P-CA-10A-2N	P-CA-12A-2N	P-CA-16A-2N	P-CA-20A-2N
FORM REAMER 	A-CA-08A-2N	A-CA-10A-2N	A-CA-12A-2N	A-CA-16A-2N	A-CA-20A-2N
PLUG TAP 	M-CA-08A	M-CA-10A	M-CA-12A	M-CA-16A	M-CA-20A

* NOTE: tools only suitable for small series production.

Common cavities - Tools 3-way short

1 mm = 0.03937 in
1 in = 25.4 mm

THREE WAY SHORT		CA-08A-3C	CA-10A-3C	CA-12A-3C	CA-16A-3C	CA-20A-3C
<p>General tolerance : ± 0.3 mm</p> <p>⊙ 0.03 ⊥ 0.02</p>	A	3/4-16 UNF-2B	7/8-14 UNF-2B	1-1/16 12 UN-2B	1-5/16 12 UN-2B	1-5/8 12 UN-2B
	B	26	30	35	42	48
	C	20.6 ^{+0.1} ₋₀	23.9 ^{+0.1} ₋₀	29.2 ^{+0.1} ₋₀	35.5 ^{+0.1} ₋₀	43.5 ^{+0.1} ₋₀
	D1	15.87 ^{+0.05} ₋₀	19.05 ^{+0.05} ₋₀	23.80 ^{+0.05} ₋₀	28.60 ^{+0.05} ₋₀	36.52 ^{+0.05} ₋₀
	D2	14.27 ^{+0.05} ₋₀	17.47 ^{+0.05} ₋₀	22.22 ^{+0.05} ₋₀	25.42 ^{+0.05} ₋₀	33.35 ^{+0.05} ₋₀
	E	2.6 ^{+0.3} ₋₀	2.6 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.4 ^{+0.3} ₋₀
	F	12	13	21	16.5	20
	G	8	14	14	15	28
	G1	3	4	5	5	7
	G2	12	15	19	24	30
	H1	12.5	14	22.5	17.5	20
	H2	26.5	31.5	40.5	38	50
	L1	16	18	26.5	22	25.5
	L2	32	40	49.5	47.5	65.5
L3	40	49	60	58	78	
M	-	-	-	2	-	
M1	-	-	-	2	-	

TOOLS (ALUMINIUM/STEEL *)	ORDERING CODE				
DRILL 	Ø G2	Ø G2	Ø G2	Ø G2	Ø G2
FORM DRILL 	P-CA-08A-3C	P-CA-10A-3C	P-CA-12A-3C	P-CA-16A-3C	P-CA-20A-3C
FORM REAMER 	A-CA-08A-3C	A-CA-10A-3C	A-CA-12A-3C	A-CA-16A-3C	A-CA-20A-3C
PLUG TAP 	M-CA-08A	M-CA-10A	M-CA-12A	M-CA-16A	M-CA-20A

* NOTE: tools only suitable for small series production.

Common cavities - Tools

3-way

1 mm = 0.03937 in

1 in = 25.4 mm

THREE WAY		CA-08A-3N	CA-10A-3N	CA-12A-3N	CA-16A-3N	CA-20A-3N
<p>General tolerance : ± 0.3 mm</p> <p>⊙ (0.03) ⊥ (0.02)</p>	A	3/4-16 UNF-2B	7/8-14 UNF-2B	1-1/16 12 UN-2B	1-5/16 12 UN-2B	1-5/8 12 UN-2B
	B	26	30	35	42	54
	C	20.6 ^{+0.1} ₋₀	23.9 ^{+0.1} ₋₀	29.2 ^{+0.1} ₋₀	35.5 ^{+0.1} ₋₀	43.5 ^{+0.1} ₋₀
	D1	15.87 ^{+0.05} ₋₀	17.47 ^{+0.05} ₋₀	23.80 ^{+0.05} ₋₀	28.60 ^{+0.05} ₋₀	36.52 ^{+0.05} ₋₀
	D2	14.27 ^{+0.05} ₋₀	15.87 ^{+0.05} ₋₀	22.22 ^{+0.05} ₋₀	27.00 ^{+0.05} ₋₀	33.35 ^{+0.05} ₋₀
	E	2.6 ^{+0.3} ₋₀	2.6 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.4 ^{+0.3} ₋₀
	F	13	14	20	20	22
	G1	12	15	19	24	30
	H1	15	18	28	25.5	31
	H2	29	34	53	54	72
	L1	19.5	23.5	36.5	35.5	46
	L2	33.5	39.5	61.5	64	87.5
	L3	43	48.5	73	75	100
	M	-	(1.5)	-	-	-
	M1	-	-	-	-	-
	*	-	-	-	-	25.5

TOOLS (ALUMINIUM/STEEL *)	ORDERING CODE				
DRILL 	Ø G1	Ø G1	Ø G1	Ø G1	Ø G1
FORM DRILL 	P-CA-08A-3N	P-CA-10A-3N	P-CA-12A-3N	P-CA-16A-3N	P-CA-20A-3N
FORM REAMER 	A-CA-08A-3N	A-CA-10A-3N	A-CA-12A-3N	A-CA-16A-3N	A-CA-20A-3N
PLUG TAP 	M-CA-08A	M-CA-10A	M-CA-12A	M-CA-16A	M-CA-20A
* NOTE: tools only suitable for small series production.					

Common cavities - Tools

4-way

1 mm = 0.03937 in
1 in = 25.4 mm

FOUR WAY		CA-08A-4N	CA-10A-4N	CA-12A-4N	CA-16A-4N	CA-20A-4N
<p>Technical drawing of a four-way cavity tool. Dimensions include diameters (Ø A, Ø B, Ø C, Ø D1, Ø D2, Ø D3, Ø G, Ø G1 max), heights (H1, H2, H3), lengths (L1, L2, L3, L4), and chamfered edges (1.6, 3.2, R 0.15). Tolerances are specified as 0.002 (0.03) for circular features and 0.008 (0.02) for linear features. General tolerance is ± 0.012 (0.3 mm).</p>	A	3/4-16 UNF-2B	7/8-14 UNF-2B	1-1/16 12 UN-2B	1-5/16 12 UN-2B	1-5/8 12 UN-2B
	B	26	30	35	42	48
	C	20.6 ^{+0.1} ₋₀	23.9 ^{+0.1} ₋₀	29.2 ^{+0.1} ₋₀	35.5 ^{+0.1} ₋₀	43.5 ^{+0.1} ₋₀
	D1	15.87 ^{+0.05} ₋₀	19.05 ^{+0.05} ₋₀	23.80 ^{+0.05} ₋₀	28.60 ^{+0.05} ₋₀	36.52 ^{+0.05} ₋₀
	D2	14.27 ^{+0.05} ₋₀	17.47 ^{+0.05} ₋₀	22.22 ^{+0.05} ₋₀	27.00 ^{+0.05} ₋₀	33.35 ^{+0.05} ₋₀
	D3	12.70 ^{+0.05} ₋₀	15.87 ^{+0.05} ₋₀	20.62 ^{+0.05} ₋₀	25.42 ^{+0.05} ₋₀	31.75 ^{+0.05} ₋₀
	E	2.6 ^{+0.3} ₋₀	2.6 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.3 ^{+0.3} ₋₀	3.4 ^{+0.3} ₋₀
	F	13	15	19	20	22
	G	6	8	14	16	25
	G1	12	15	19	24	30
	H1	15	18	28	25	32
	H2	29	34	53	53.5	72
	H3	43	50	78	82	114
	L1	19.5	23.5	36.5	35.5	46
	L2	33.5	39.5	61.5	64	87
	L3	47.5	55.5	87.5	92.5	128.5
L4	56	64.5	99	104	142	
M	-	-	-	-	-	
M1	-	-	-	-	-	
M2	-	-	-	-	-	

TOOLS (ALUMINIUM/STEEL *)	ORDERING CODE				
DRILL 	Ø G1	Ø G1	Ø G1	Ø G1	Ø G1
FORM DRILL 	P-CA-08A-4N	P-CA-10A-4N	P-CA-12A-4N	P-CA-16A-4N	P-CA-20A-4N
FORM REAMER 	A-CA-08A-4N	A-CA-10A-4N	A-CA-12A-4N	A-CA-16A-4N	A-CA-20A-4N
PLUG TAP 	M-CA-08A	M-CA-10A	M-CA-12A	M-CA-16A	M-CA-20A

* NOTE: tools only suitable for small series production.

