

A comparison – hollow bar vs solid bar

Boring from hollow bar	Drilling from solid bar
No drilling is necessary and a shorter time cycle for the manufacture of each component is made possible.	Time is required for drilling from solid bar and the boring operation may still be required.
Boring from hollow bar creates less swarf resulting in low material wastage and less-frequent machine cleaning.	Drilling from solid bar creates an excessive amount of swarf resulting in high wastage and frequent machine cleaning.
Coolant may not be needed.	Coolant most likely required.

Hollow bar: product range and theoretical weights

OD (mm)	ID (mm)	Weight (kg/m)	OD (mm)	ID (mm)	Weight (kg/m)	OD (mm)	ID (mm)	Weight (kg/m)
32	16	4.85	75	45	22.70	100	80	22.80
32	20	3.98	75	50	19.70	106	56	50.60
36	16	6.54	75	56	15.80	106	63	45.50
36	20	5.66	75	60	13.34	106	71	30.80
36	25	4.29	80	40	30.10	106	80	30.50
40	20	7.54	80	45	27.50	106	85	25.40
40	25	6.17	80	50	24.50	112	63	53.70
40	28	5.20	80	56	20.60	112	71	47.10
45	20	10.18	80	63	15.50	112	80	38.70
45	28	7.83	85	45	32.60	112	90	28.20
45	32	6.36	85	50	29.70	118	63	62.30
50	25	11.74	85	55	26.40	118	71	55.60
50	32	9.30	85	67	17.40	118	80	47.30
50	36	7.63	90	45	37.45	118	85	42.59
56	28	14.49	90	50	35.10	118	90	36.80
56	32	13.02	90	56	31.20	118	95	32.08
56	36	11.60	90	63	26.00	125	71	66.20
56	40	9.70	90	67	22.95	125	80	57.80
63	32	18.50	90	71	19.40	125	90	47.30
63	36	16.80	95	50	40.80	125	95	41.60
63	40	14.90	95	60	33.45	125	100	35.60
63	45	12.30	95	56	36.90	132	80	67.96
63	50	9.40	95	63	32.08	132	71	77.50
71	36	23.50	95	67	28.60	132	80	69.10
71	40	21.70	95	75	21.50	132	90	58.60
71	45	19.00	100	56	42.90	132	98	49.40
71	50	16.10	100	63	37.80	132	106	39.30
71	56	12.20	100	71	31.20	140	90	72.10
75	40	25.30	100	75	27.60	140	80	82.60

Hollow bar: product range and theoretical weights

OD (mm)	ID (mm)	Weight (kg/m)	OD (mm)	ID (mm)	Weight (kg/m)
140	90	72.10	212	170	101.04
140	100	60.40	224	132	211.95
140	106	52.80	224	160	155.80
140	112	44.70	224	180	115.60
150	80	100.70	236	140	228.40
150	85	100.77	236	170	169.90
150	95	84.60	236	190	127.50
150	106	70.90	250	150	261.17
150	118	54.40	250	180	190.90
150	125	43.70	250	200	142.80
160	90	109.50	273	173	275.00
160	100	97.80	273	193	230.00
160	112	82.10	273	201	210.40
160	122	67.70	273	213	180
160	132	52.00	273	223	157.00
162.1	79.7	122.80	298	198	306.41
162.1	111.3	85.60	298	218	255.00
170	100	118.40	298	238	199.00
170	118	94.20	298	248	170.00
170	130	75.90	298	258	137.00
170	140	59.20	324	224	337.80
172.3	121.3	92.20	324	244	280.00
180	100	140.10	324	274	186.00
180	112	126.03	356	236	437.00
180	125	105.04	356	256	377.00
180	140	80.90	356	276	311.00
180	150	63.00	406	286	512.00
190	109	156.20	406	306	439.00
190	132	117.50	406	334	324.00
190	150	86.20	457	327	628.00
190	160	67.10	457	357	502.00
200	112	176.85			
200	140	129.62			
200	160	92.25			
212	125	180.99			
212	150	142.3			