



318.08

Operating instruction Face grooving Serie 318

The table below determines the components such as extension slide ①, clamp bases ② and face grooving holders ③ for each diameter range and shows in which position the clamp bases ② have to be mounted on the extension slide ①. Furthermore, this table also serves for the coarse face grooving diameter setting of the cutting edges by means of the scale on the clamp base ② and the marking ④ on the insert holder ③. The required scale value is calculated from the difference between the face grooving diameter and the correction value α . The face grooving holder is adjusted to the scale value. See example below.

Assembly and adjustment of the cutters

- Mount the clamp base ② on to the extension slide ① at a fixed position according to the table and fasten the socket screws ⑤ with 25 Nm.
- Remove screws with washers ⑥ from the clamp bases ② and mount the face grooving holder ③ on to the clamp bases ②. Position screws with washers ⑥ but do not tighten them.
- An opening ⑧ at the face grooving holder ③ allows access for an Allen wrench ⑦ to the adjustment screw ⑨. Adjust the desired diameter according to the scale ⑩ with the

- Allen wrench ⑦. The corresponding scale value is calculated according to the table.
- Fasten screws ⑥ with 40 Nm.
- Adjust both cutters ⑬ to the same height by means of an Allen wrench ⑭ and an adjustment bolt ⑮. Then tighten the adjustment bolt to 2.5 Nm with the clamp screw ⑯ and, as a last step, tighten the cutters to 2.5 Nm with the clamp screws ⑰.

Example correction value

ØD:	Ø335
Extension slide:	318.223
Position:	2
Correction value:	305
Scale:	$D - \alpha = 335 - 305 = 30$

Range ØD	Extension slide	Fixed position / Range		Clamping bases	Correction α	
		Pos.1 / ØD	Pos.2 / ØD		Pos. 1	Pos. 2
200 - 270	318.205N	199 - 236		318.240	200	
	318.222		234 - 271			235
270 - 340	318.206N	269 - 306			270	
	318.223		304 - 341			305
340 - 410	318.224	339 - 376	374 - 411		340	375
410 - 480	318.225	409 - 446	444 - 481		410	445
480 - 550	318.226	479 - 516	514 - 551		480	515
550 - 620	318.227	549 - 586	584 - 621		550	585

