



317.52

Operating instruction Fine boring Ø 150 - 1180

Assembly:

1. Assemble the tool combination appropriate to the desired boring diameter D according to the adjustment table 317.51.
2. Loosen the clamping screws (A) and unscrew the safety screws (B) until the boring head (3) and the counter weight (4) can be put on the extension slide (1), both of them either in position 1 or position 2.
3. To find position 1 or 2, align the respective graduation marks (2) on the tool holder with the one on the extension slide.
4. Tighten the clamping screws (A) with the tightening torque of 20Nm.
5. Tighten the safety screws (B) with the tightening torque of 10Nm (do not over tighten the safety screws (B), otherwise an accurate function cannot be guaranteed).
6. Choose insert holder (5a) or (5b) according to the adjustment table 317.51, screw it into the toolholder (6) and fasten the screw (7) with a torque of 15Nm.
7. Release clamping screw (8). Adjust the desired boring diameter D by turning the scale screw (9) or the bevel gear (10). Tightened the clamping screw (8) with a torque of 15Nm.
8. The counter weight (4) consists of a body

- with slide (14) which is initially set to the innermost position (0 - position) (fig. 4). In this position a balancing quality of G40 at the max. allowed rotation speed, as stated on the extension slide (1), is guaranteed.
9. For better balancing quality, loosen clamping screws (11) and adjust the slide (14) to the required scale setting. (fig. 4 and fig. 5). Tighten the clamping screws (11) with a torque of 70Nm.
 10. To find the correct scale setting, refer to the adjustment table 317.51. From the bore diameter, the correction value, which corresponds to the min. diameter (Dmin), has to be deducted.
Example: Extension slide 317.223, Dmin = 270, Bore diameter D = 335; scale setting = 335-270 = 65.
 11. The scale on one side of the counter weight (4) applies when the insert holder 626.161 (5a) is used. If the counter weight is located in position 1, the scale (13) applies. If the counter weight is located in position 2, scale (14) applies (fig. 4).
 12. The scale on the other side of the counter weight (4) is used when insert holder 626.162 (5b) is used (fig. 5).

General information:

Take note that the adjustment range of the toolcarrier (1) is limited. Do not use force when adjusting. Periodic lubrication via the lube nipple (12) ensures high precision combined with long life. A light machine oil is recommended e.g. Mobil Vactra Oil No. 2, BP Energol HLP-32, Klueber Isoflex PDP 94.

Attention:

Do not exceed max. RPM as marked on the extension slide. For back boring (fig. 3) counter clockwise spindle rotation is required.

Finish boring head (3) and counter weight (4) can also be used on the former extension slides without bores for the safety screws (B). Therefore, remove the safety screws (B) and align the respective graduation mark (2) on the tool holder with the one on the extension slide.

