



317.62

Operating instruction Rough boring with Series 317 Ø 150 - 1180

Assembly:

1. Assemble the tool combination appropriate to the desired boring diameter D according to the overview 317.61.
2. Loosen the clamping screws (A) and unscrew the safety screws (B) until both clamping bases (3) can be put on the extension slide (1), both of them either to position 1 or 2.
3. To find position 1 or 2, align the respective graduation marks (2) on the clamping base 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 the accurate function cannot be guaranteed).
6. Mount insert holder (4) on the clamping base (3). To adjust the desired diameter, loosen clamp screws (5) and adjust insert holder (4) by means of the adjusting screw (7).

7. Fasten clamp screws (5) with a tightening torque of 100 Nm. Make sure that there are always washers (6) used with the clamp screws (5).
8. Scale Ø 150 – 200: The scale according to fig. 2 serves for a coarse adjustment of the boring diameter. Scale (11) serves for position 1 (Ø 150 - 188), scale (12) for position 2 (Ø 186 - 200). The scale value plus 100 corresponds to the boring diameter.
Example: Boring diameter D = 190mm, Scale (12, for position 2) = 90.
9. Scale Ø 200 – 1180: The scale according to fig. 2 serves for a coarse adjustment of the boring diameter. Scale (13) serves for position 1 of the clamping base on the extension slide, scale (14) serves for position 2. The scale value corresponds to the boring diameter minus the minimum diameter range marked on the extension slide (1).
Example: Boring diameter D = 380mm,

extension slide 317.224 (with diameter range marked Ø340 – 410).

Scale (14, for position 2): = 380 – 340 = 40.

10. For double offset rough boring DVS remove one insert holder (4), put in the spacer (8) and repeat step 6 to 9.
11. The coolant nozzle (9) cannot be used for the boring range of Ø 186 -190
12. For Ø 150 – 188, the stop pin (10) has to be removed. This stop pin is required when tools without safety screws (B) are used.

Attention: do not exceed maximum RPM as marked on the extension slide!

The rough boring tools can also be used on former extension slides without bores for the safety screws. Remove the safety screws (B) and align the respective graduation marks (2) on the clamp bases with the one on the extension slide.

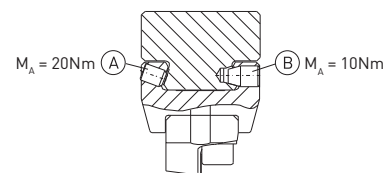
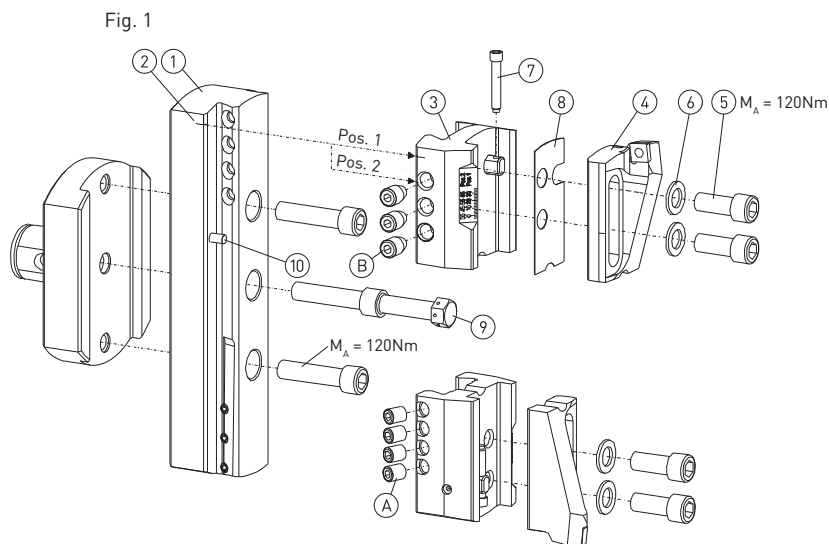


Fig. 2 Ø150-200

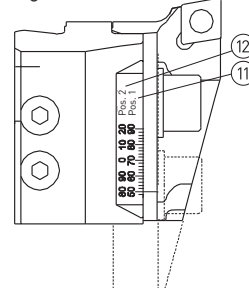


Fig. 3 Ø200-1180

