



318.01

Operating instruction Fine boring Series 318

The table below determines the components such as extension slide ①, boring head ②, insert holder ③ and counterweight ④ for each diameter range and shows in which position the boring head ② and the counterweight ④ have to be mounted on the extension slide ①.

Balancing of the tool combination takes place by adjusting the slide ⑤ on the counterweight ④ according to the scale. The correction value α is shown on the table. See example below.

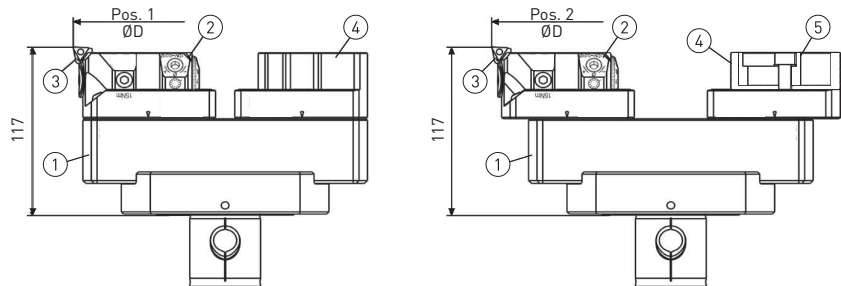
Assembly and adjustment of the fine boring head

- Mount boring head ② and counterweight ④ on to the extension slide ① at a fixed position, according to the table and fasten socket screws ⑥ with 20Nm
- Select the appropriate insert holder ③ (Type TC or CC) and mount it either for forward or back boring, on to the boring head ②. Fasten screw ⑦ with 12Nm
- Unclamp tool carrier locking screw ⑧.

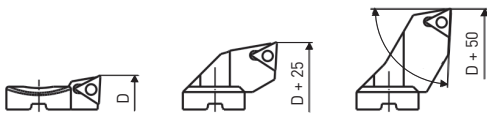
- On a presetter, set the cutting edge to the desired diameter by means of the scale screw ⑨ or the lateral adjust screw ⑩ and clamp tool carrier locking screw ⑧ with 10Nm
- Loosen screw ⑪ on the counterweight ④ and set the slide ⑫ to the scale value, previously calculated according to the table. Fasten screw ⑪ with 15Nm

Balancing example

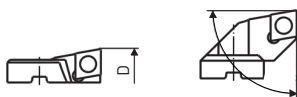
ØD:	Ø335 H7
Extension slide:	318.223
Position:	2
Counterweight:	318.105
Correction value:	305
Scale:	$D - \alpha = 335 - 305 = 30$



Range ØD	Extension slide ①	Fixed position / Range		Boring head ②	Insert holder ③	Counterweight ④	Correction α			
		Pos.1 / ØD	Pos.2 / ØD				Pos. 1	Pos. 2		
200 - 270	318.205N	199 - 236		318.101	626.271	318.105	200			
	318.222		234 - 271					235		
270 - 340	318.206N	269 - 306					318.107 not adjustable	318.107 not adjustable	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



Order No	626.271* D= Ø200-620	626.272	626.273	TC.. 1102
-----------------	-------------------------	---------	---------	-----------



Order No	626.371 1 D= Ø200-620	626.372		CC.. 09T3
-----------------	--------------------------	---------	--	-----------

* Reduced boring range for back boring operations (Ø212-620)

