



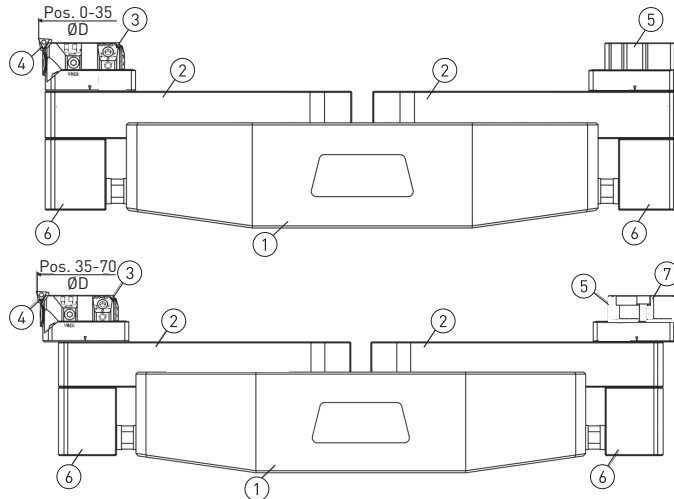
318.07

Operating instruction Ø620-3'000, Series 318

The table on the last page determines the components such as bridge ①, extension slide ②, boring head ③, insert holder ④ and counterweight ⑤ for each diameter range and shows in which position extension slide ②, boring head ③ and the counterweight ⑤ have to be mounted on the bridge ①. Über die Kühlmittelzuführung ⑥ gelangt das Kühlmittel bis an die Schneide.

Balancing of the tool combination takes place by adjusting the slide ⑦ on the counterweight ⑤ according to the scale. The correction value α is shown on the table.

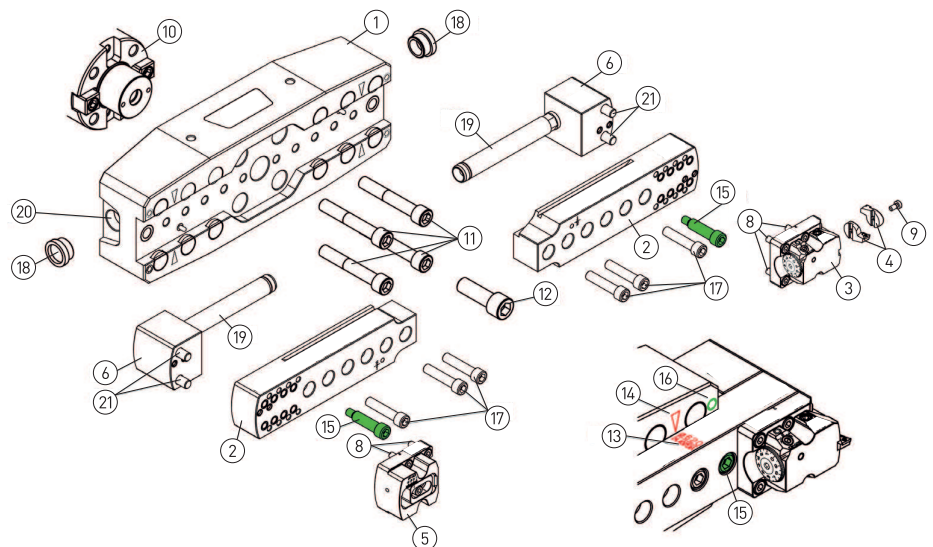
Rough boring operations possible up to Ø830.



Assembly and adjustment of the fine boring head

- Mount boring head ③ and counterweight ⑤ on to the extension slide ② at a fixed position, according to the table on the last page and fasten socket screws ⑧ with 20Nm
- Select the appropriate insert holder ④ (Type TC or CC) and mount it either for forward or back boring, on to the boring head ③. Fasten screw ⑦ with 12Nm
- Insert the bridge ① on the spindle or direct on the spindle. Fasten screw ⑩ with 50Nm and screw ⑫ with 80Nm
- Fit the extension slide ② together with the bridge ①. Align the arrow ⑭ of the bridge ① with the line with the correction value α ⑮ on the extension slide ②
- Screw the position-screw ⑬ with 20Nm in the outside thread with the mark ⑯ on the bridge ①
- Fasten screw ⑰ with 25Nm
- Remove the blank plug ⑱ only if the coolant supply ④ is used
- Insert the coolant supply ④ (optional)

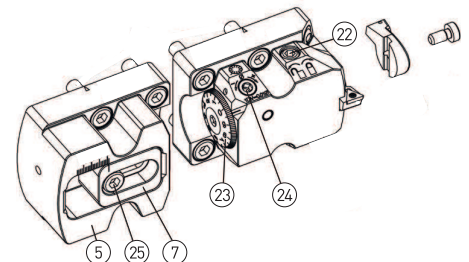
including the coolant pipe ⑰ in the bore ⑲ on the side of the bridge. Fasten screw ⑰ with 25Nm



Adjustment of the boring head and counterweight

- Unclamp tool carrier locking screw ⑳
- On a presetter, set the cutting edge to the desired diameter by means of the scale screw ㉓ or the lateral adjust screw ㉔ and clamp tool carrier locking screw ㉔ with 10Nm

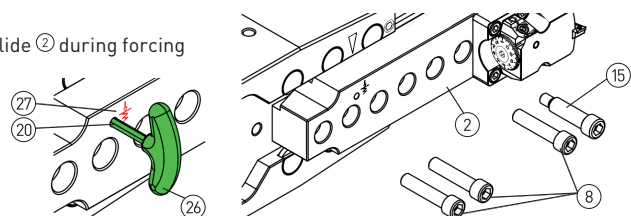
- Loosen screw ㉕ on the counterweight ⑤ and set the slide ⑦ to the scale value, previously calculated according to the table. Fasten screw ㉕ with 25Nm



Release extension slider

- Loosening and remove the position-screw ⑮ and the mounting-screw ⑧
- Remove the Extension slide ② until the body stop.
- Press the key ㉖ (max. SW5) in the bore near the spring symbol ㉗ until the body stop

- Remove the extension slide ② during forcing the key ㉖



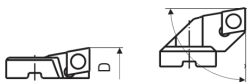
318.07

| Bereich Plage Range Intervallo ØD | Brücke Pont Bridge Ponte | Zwischensohle Semelle Extension slide Slitte | Rasterposition / Bereich Position fixe / Plage Fixed position / Range Posizione fissa / intervallo | | Korrektur α Correction α Correccion α Correzione α | Feinbohrkopf Tête à aléser Boring head Testa per alesare | Wendeplattenhalter Porte-plaquette Insert holder Porta-inserti | Ausgleichsgewicht Contrepoids Counter weight Contrappeso |
|---|-----------------------------------|---|---|-----------|---|---|---|---|
| | | | 0-35 | 35-70 | | | | |
| 620-690 | 318.421 | 318.431 | 619-656 | 654-691 | 620 | 318.101 318.103 | 626.271 | 318.105 318.107 nicht einstellbar / pas réglable / not adjustable / non regolabile |
| 690-760 | | | 689-726 | 724-761 | 690 | | | |
| 760-830 | | | 759-796 | 794-831 | 760 | | | |
| 830-900 | 318.422 | 318.432 | 829-866 | 864-901 | 830 | | | |
| 900-970 | | | 899-936 | 934-971 | 900 | | | |
| 970-1040 | | | 969-1006 | 1004-1041 | 970 | | | |
| 1040-1110 | | | 1039-1076 | 1074-1111 | 1040 | | | |
| 1110-1180 | 318.423 | 318.433 | 1109-1146 | 1144-1181 | 1110 | | | |
| 1180-1250 | | | 1179-1216 | 1214-1251 | 1180 | | | |
| 1250-1320 | | | 1249-1286 | 1284-1321 | 1250 | | | |
| 1320-1390 | | | 1319-1356 | 1354-1391 | 1320 | | | |
| 1390-1460 | | | 1389-1426 | 1424-1461 | 1390 | | | |
| 1460-1530 | | | 1459-1496 | 1494-1531 | 1460 | | | |
| 1530-1600 | 318.424 | 318.434 | 1529-1566 | 1564-1601 | 1530 | | | |
| 1600-1670 | | | 1599-1636 | 1634-1671 | 1600 | | | |
| 1670-1740 | | | 1669-1706 | 1704-1741 | 1670 | | | |
| 1740-1810 | | | 1739-1776 | 1774-1811 | 1740 | | | |
| 1810-1880 | | | 1809-1846 | 1844-1881 | 1810 | | | |
| 1880-1950 | | | 1879-1916 | 1914-1851 | 1880 | | | |
| 1950-2020 | 318.425 | 318.434 | 1949-1986 | 1984-2021 | 1950 | | | |
| 2020-2090 | | | 2019-2056 | 2054-2091 | 2020 | | | |
| 2090-2160 | | | 2089-2126 | 2124-2161 | 2090 | | | |
| 2160-2230 | | | 2159-2196 | 2194-2231 | 2160 | | | |
| 2230-2300 | | | 2229-2266 | 2264-2301 | 2230 | | | |
| 2300-2370 | | | 2299-2336 | 2334-2371 | 2300 | | | |
| 2370-2440 | 318.425 | 318.435 | 2369-2406 | 2404-2441 | 2370 | | | |
| 2440-2510 | | | 2436-2476 | 2474-2511 | 2440 | | | |
| 2510-2580 | | | 2509-2546 | 2544-2581 | 2510 | | | |
| 2580-2650 | | | 2579-2616 | 2614-2651 | 2580 | | | |
| 2650-2720 | | | 2649-2686 | 2684-2721 | 2650 | | | |
| 2720-2790 | | | 2719-2756 | 2754-2791 | 2720 | | | |
| 2790-2860 | 318.425 | 318.435 | 2789-2826 | 2824-2861 | 2790 | | | |
| 2860-2930 | | | 2859-2896 | 2894-2931 | 2860 | | | |
| 2930-3000 | | | 2896-2966 | 2964-3001 | 2930 | | | |

Wendeplattenhalter / Porte-plaquettes / Insert holders



| | | | | |
|--|------------------------|---------|---------|----------|
| Bestell-Nr. No de réf. Order No Num. articolo | 626.271* D=Ø200-620 | 626.272 | 626.273 | TC..1102 |
|--|------------------------|---------|---------|----------|



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| Bestell-Nr. No de réf. Order No Num. articolo | 626.371* D=Ø200-620 | 626.372 | | CC..09T3 |
|--|------------------------|---------|--|----------|

* Reduzierter Ausdrehbereich D bei der Rückwärtsbearbeitung (Ø212-620)
Plage d'alésage réduite pour l'usinage en tirant (Ø212-620)
Reduced boring range for back boring operations (Ø212-620)
Intervallo di alesatura ridotto nella lavorazione all'indietro (Ø212-620)

Beispiel Auswuchten / Exemple équilibrage / Balancing example / Esempio equilibratura

| | |
|--|---------------------|
| ØD: | Ø630 H7 |
| Brücke / Pont / Bridge / Ponte: | 318.421 |
| Zwischensohle / Semelle / Extension slide / Piano intermedio di estensione: | 318.431 |
| Korrektur α / Correction α / Correccion α / Correzione α: | Ø620 |
| Feinbohrkopf / Tête à aléser / Boring head / Testa per alesare: | |
| Position / Bereich: | |
| Position / Plage: | 0-35, (Ø619-656) |
| Position / Range: | |
| Posizione / intervallo: | |
| Ausgleichsgewicht / Contre poids / Counter weight / Contrappeso: | |
| Position / Bereich: | |
| Position / Plage: | 0-35, (Ø619-656) |
| Position / Range: | |
| Posizione / intervallo: | |