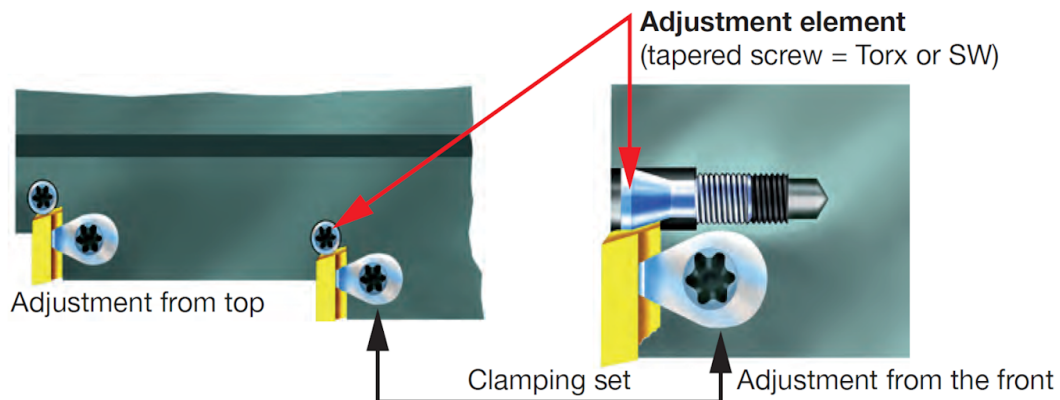




Fineboring Tools

Tapered screw adjustment μm -accurate adjustable

Adjustment instructions



1. Changing the insert

Disassembly

- Loosen clamp set (1 to 2 turns) and remove the worn insert
- Clean the insert pocket
- Turn out the adjustment element 1 to 2 turns

Assembly

- Put a new insert in the pocket seat
- Press insert into the pocket seat, keep under pressure and slightly tighten the clamp set:
Torx 5 with 40 Ncm
Torx 6 with 60 Ncm
Torx 8 with 100 - 120 Ncm
Torx 15 with 250 - 300 Ncm

2. Insert adjustment

- Clamp the holder in the presetting device
- Adjust the insert in diameter up to 0.05 mm smaller than target measure
- Tighten the clamp set
- Adjust insert to the required machining diameter. It is not necessary to retighten the clamping set!

We reserve the right to make technical changes.



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Adjustment instructions

Torque for clamping sets

Tool type	Clamp set	Torque (Ncm)	Torx size	Torque wrench fixed DSF	
				Part nr.	Code
H 1035 / H 1730	E 1100 / E 3441	45	Tx 5	20063	0.450
H 2850	E 1085 / E 1112	70	Tx 6	20063	0.700
H 3570	E 1060	140	Tx 8	20063	1.400
H 4090	E 1040	345	Tx 15	20063	3.450
Torque wrench adjustable DS		20 - 120		20063	1.200
		100 - 600		20063	6.000

Security Advice:

For security reasons the tool must be returned to the manufacturer for inspection if the holder is damaged! The clamp sets must be replaced on a regular basis or in case that they show any sign of damage. Only original spare parts may be used!

We reserve the right to make technical changes.