



## 319.01

### Operating instruction Rough boring heads SW20 - 148

**Fig. 1**

The insert holders ① are fixed with clamp screws ② on the tool body ③. A special mechanism with adjust screw ④ mounted on the tool body ③, serves for diameter setting in both directions. On the insert holders ①, opposite of the cutting edge ⑤, a small hole ⑥ allows access for an Allen wrench ⑨ to the adjust screw ④.

The rough boring heads SW53 (319.501) and bigger are equipped with an adjustable coolant nozzle ⑦. By means of a small bar, the nozzle ⑦ can be adjusted to the cutting edge ⑤.

**Fig. 2**

The tool body ③ is marked with "RSS" and "DVS" ⑩. On the insert holders ① there is a reference line marking ⑪. The shorter of the two insert holders ① is marked with "S" ⑫ and the longer one with "L" ⑬.

**Make sure that the boring head is always used with a short insert holder "S" ① and a long insert holder "L" ①.**

**Fig. 3**

#### Rotationally-symmetrical-roughing (RSS)

Mount the insert holders ① on the tool body ③ in such a way that on both insert holders ①, the reference line marking ⑪ is aligned to the RSS markings ⑭ on the tool body ③. Adjust both cutting edges ⑤ to the same diameter by means of an Allen wrench ⑨. The scale ⑫ on the insert holder ① serves for the rough diameter setting. Tighten both clamp screws ② with the given torque.

**Fig. 4**

#### Double-offset-roughing (DVS)

Mount the insert holders ① on the tool body ③ in such a way that the reference line marking

⑪ on both insert holders ① is aligned to the DVS markings ⑮ on the tool body ③. Adjust the cutting edge ⑤ on insert holder "L" ① to half of the stock allowance and the cutting edge ⑤ on insert holder "S" ① to the final diameter. Tighten both clamp screws ② with the given torque.

#### Remark

If the reference line marking ⑪ on one of the insert holders ① is aligned to the RSS marking ⑭ on the tool body ③ and on the other one to DVS ⑮, then there is a wrong pair of insert holders ① mounted. In this configuration the boring head may not be used.

			M [Nm]						
	②	⑮	M [Nm]	⑮	⑦	⑰	④	⑨	⑱
SW20	690.188	693.175	4	690.803		319.150	690.191	690.819	690.184
SW25	690.157	693.176	7	690.804		319.250	690.192	690.819	690.186
SW32	690.108	693.177	12	690.805		319.350	690.193	690.811	690.145
SW41	690.163	693.178	20	690.806		319.450	690.194	690.812	690.189
SW53	690.105	693.179	35	690.807	692.409	319.550	690.195	690.812	690.189
SW68	690.106	693.179	35	690.807	692.406	319.650	690.196	690.813	690.101
SW98 x CKN6	690.970	693.187	40	690.810	692.406	319.750	690.197	690.814	690.108
SW98 x CKN7	690.970	693.187	40	690.810	692.406	319.750	690.197	690.814	690.173
SW148 x CKN6	690.970	693.187	40	690.810	692.406	319.750	690.197	690.814	609.108
SW148 x CKN7	690.970	693.187	40	690.810	692.406	319.750	690.197	690.814	690.173

