



ADJUSTING GUIDELINE EXPANSION JOINT TOOLS

IN GENERAL

All expansion joint tools are delivered without presetting (this means both screws can be moved easily in both directions).

Before each new adjustment both screws also must be set in position without prestress force, only adjusting screw 2 should be moved counterclockwise for backlash compensation. The adjustment of the cutting edge shall principally be carried out clockwise at the setscrews 1 and 2 (the releasing then counterclockwise).

NOMINAL VALUE IN DIRECTION OF PLUS

- first move adjusting screw 1 clockwise (see fig. 1)
- then lock adjusting screw 2 clockwise (see fig. 2)

FUNCTIONAL PRINCIPLE OF EXPANSION JOINT TOOLS/COMPENSATOR

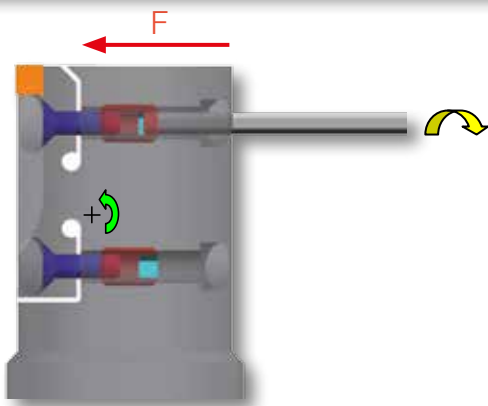


FIG. 1
to adjust/lock torque clockwise/
release locking counterclockwise

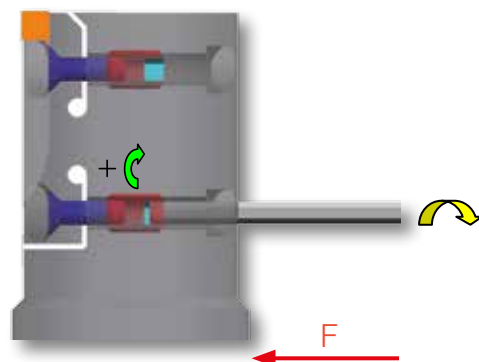


FIG. 2
to lock/adjust clockwise/
release locking counterclockwise

In order to reach an exactly nominal value which have to be adjusted $< 2\mu\text{m}$ in the diameter and in the run out, the desired adjusting measurement has to be exceeded, and therefore through the correspondingly dosed locking pressed back to the desired value.

In every case, both adjusting screws must be clamped with at least one half torque (see table page 2), that a stable position of the cutting edge is ensured during a long use. If the half torque is not reached after the adjusting, both adjusting screws must be stronger tightened (adjust, lock). At two-edged cutting tools the first adjusted cutting edge must be checked and if necessary be corrected with adjusting screw 2 of this cutting edge. At multi-stepped tools which are carried out with two or more cutting edges and expansion joints you have to pay attention to the adjusting order:

First adjust all cutting edges starting from the tool shank until to the front. When all cutting edges are adjusted and locked, the desired adjusting measurement must be once more checked and if necessary corrected.



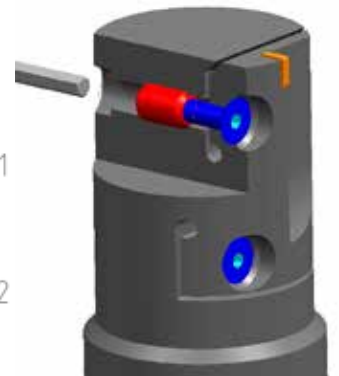
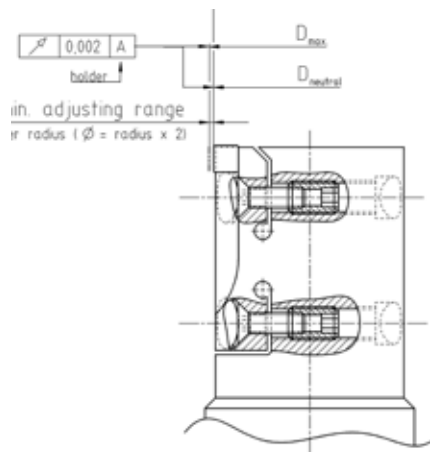
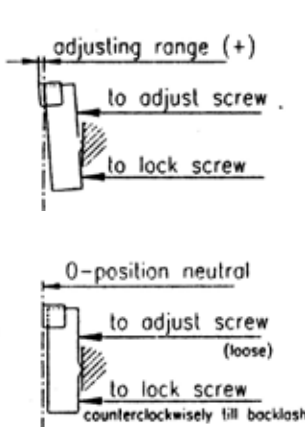
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TORQUE:

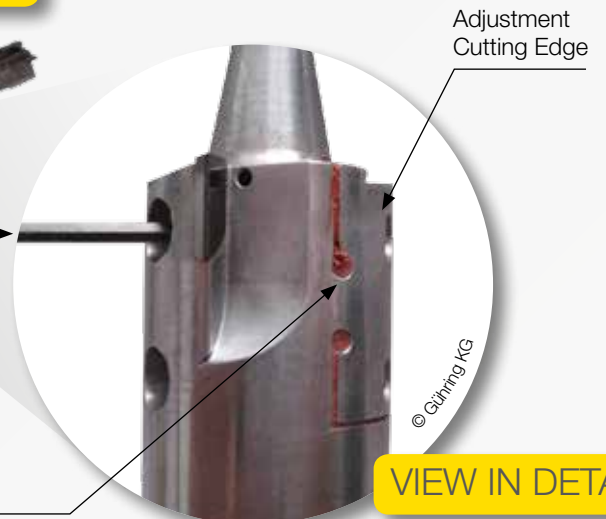
| Ø Diameter Range [mm] | adj. range per radius [µm] | Max. torque [Nm] | SW [mm] |
|-----------------------|----------------------------|------------------|---------|
| 18 – 24 | 30 | 0.8 | 2 |
| 24 – 30 | 50 | 0.8 | 2 |
| 30 – 38 | 70 | 1.5 | 2.5 |
| 38 – 50 | 80 | 4 | 3 |
| > 50 | 150 | 6 | 4 |

ATTENTION

The indicated maximum torques per nominal size may **not** be exceeded (due to damages), when adjusting the expansion joint tool. The possible adjusting ranges and max. torques are contained in the table beside.



APPLICATION AT A PCD STEP REAMER (FOR EXAMPLE)



VIEW IN DETAIL

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