

318.08

Operating instruction Face grooving Serie 318

The table below determines the components such as extension slide 1, clamp bases 2 and face grooving holders 3 for each diameter range and shows in which position the clamp bases 2 have to be mounted on the extension slide 1. Furthermore, this table also serves for the coarse face grooving diameter setting of the cutting edges by means of the scale on the clamp base 2 and the marking 4 on the insert holder 3. The required scale value is calculated from the difference between the face grooving diameter and the correction value α . The face grooving holder is adjusted to the scale value. See example below.

Assembly and adjustment of the cutters

- Mount the clamp base ② on to the extension slide ① at a fixed position according to the table and fasten the socket screws ⑤ with 25 Nm.
- Remove screws with washers (amp bases and mount the face grooving holder and to the clamp bases . Position screws with washers but do not tighten them.
- An opening ® at the face grooving holder
 ③ allows access for an Allen wrench ⑦ to the adjustment screw ⑨. Adjust the desired diameter according to the scale ⑩ with the

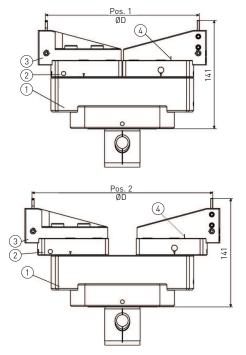
Allen wrench ①. The corresponding scale value is calculated according to the table.

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- Fasten screws 6 with 40 Nm.
- Adjust both cutters [®] to the same height by means of an Allen wrench [®] and an adjustment bolt [®]. Then tighten the adjustment bolt to 2.5 Nm with the clamp screw [®] and, as a last step, tighten the cutters to 2.5 Nm with the clamp screws [®].

Example correction value

ØD:	Ø335
Extension slide:	318.223
Position:	2
Correction value:	305
Scale:	D - α = 335 - 305 = 30



Range	Extension	Fixed position / Range		Clamping bases	Correction α	
ØD	slide	Pos.1/ØD	Pos.2/ØD		Pos. 1	Pos. 2
200 - 270	318.205N	199 - 236			200	
	318.222		234 - 271			235
270 - 340	318.206N	269 - 306		318.240	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

