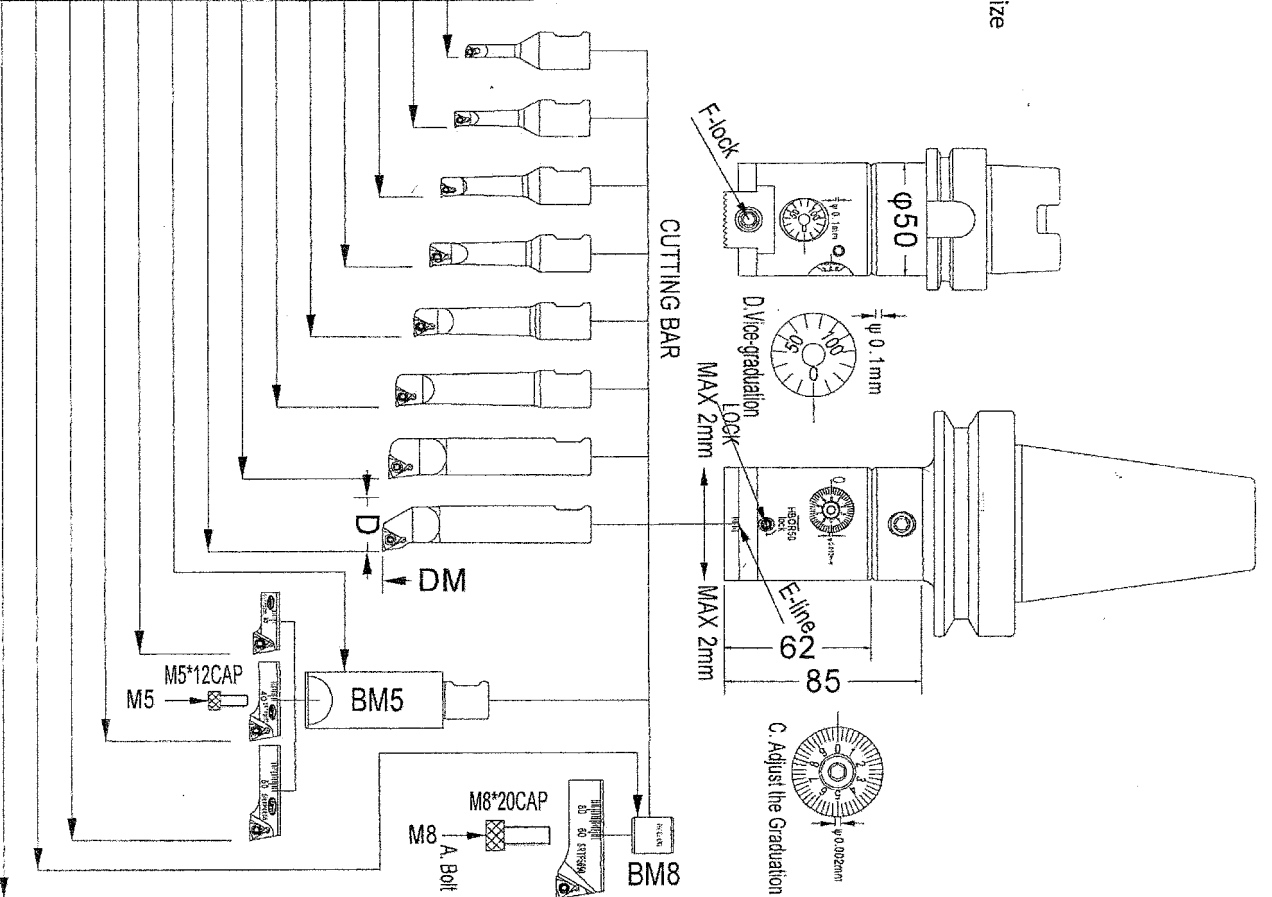
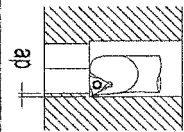


PHBOR Micron Precision Boring Head Set

1. H- System combines each kind of demands, machinery, and depth to processing.
2. According to boring diameter choose cutting bar BR1616-60 put into $\phi 16$ hole, then tighten (F) bolt. Or choose cutting bar BM5 and cutting insert holder SRTTP3652, then tighten (M5) bolt. Or choose cutting insert holder SRTTP5790 should use with connector BM8, then tighten (M8) bolt.
3. HBOR63 boring range from $\phi 6$ to $\phi 90$ as figure(E). (C) adjustable graduation of the size is equivalent $\phi 0.002\text{mm}$. every rotate reference vice graduation, which equal to $\phi 0.1\text{mm}$. After adjust tighten LOCK bolt, when you want to adjust loosen LOCK bolt.
4. Choose appropriate boring bar in order to maximize operation.
5. Select the appropriate insert for the work of boring cutting parameters.
6. Please refer to the machine's fine boring cycle function.
7. If vibration occurs during process, please reduce the rpm. If boring surface is not fine, please reduce the feed rate or increase the spindle speed. If taper occurs, please adjust cutting depth to achieve good result.

Order No.	Cutting Bar	D		DM	Insert	ap	Feed mm/rev	Vc m/min	BOLT NO/Wrench
		MIN	MAX						
50160621	BR1606-21	6-9		21	WBGT060102L	0.05-0.20	0.05-0.10	Carbon steel	
50160828	BR1608-28	8-11		28	TBGT080102L	0.05-0.20	0.05-0.10	Carbon steel	SB-3TR-M2
50161035	BR1610-35	10-13		35	TBGT080104L	0.10-0.25	0.07-0.15	Carbon steel	SB-3TR-M2
50161242	BR1612-42	12-15		42	TPGH090202L	0.05-0.20	0.05-0.10	Stainless steel	SB-2TR-M2.5
50161450	BR1614-50	14-17		50	TPGH090204L	0.10-0.25	0.07-0.15	Stainless steel	SB-2TR-M2.5
50161660	BR1616-60	16-20		60	TPGH10302L	0.05-0.20	0.05-0.10	Cast Iron	SB-3TR-M3
50162065	BR1620-65	20-24		65	TPGH10304L	0.10-0.25	0.07-0.15	Cast Iron	SB-3TR-M3
50162468	BR1624-68	24-28		68	TPGH10304L	0.10-0.25	0.07-0.15	Cast Iron	SB-3TR-M3
50162505	BM5			60+ SRTTP2938 or SRTTP3652 or SRTTP4468					M5*12CAP
50252938	SRTTP2938	28-38		+10	TPGH090202L	0.05-0.20	0.05-0.10	Aluminum	SB-2TR-M2.5
50323652	SRTTP3652	36-52		+12	TPGH090204L	0.10-0.25	0.07-0.15	Aluminum	SB-2TR-M2.5
50404468	SRTTP4468	44-68		+12				Aluminum	SB-2TR-M2.5
50501608	BM8								M8*20CAP
50505790	SRTTP5790	57-90		+20	TPGH10302L	0.05-0.20	0.05-0.10		SB-3TR-M3

mm



PHBOR Micron Precision Boring Head Set

1. Adjustment

- 1.1 Use wrench T6 or T8 lock the insert.
- 1.2 Loosen Bolt M10*18, put BR16 series cutting bar into the $\phi 16$ hole.
- 1.3 Before adjustment, loosen (G)-lock bolt, turn counterwise (C)-adjust the graduation of the size 0.001mm of each, diameter $\phi 0.002\text{mm}$, after tighten the (G)-lock bolt.
- 1.4 If oversize, loosen (G)-lock bolt, turn clockwise (C)-adjust the graduation. It need turn back over -0.02mm , then turn to the size you need. After that tighten the (G)-lock bolt.

2. Follow below instruction, to avoid damage the inside components.

- 2.1 Before adjustment, loosen (G)-lock bolt.
- 2.2 Tighten lock bolt, it is prohibit to rotate (C)-adjust the graduation.
- 2.3 (D)-Vice-graduation for the size reference, it can't adjust.
- 2.4 Prohibit to move (F)-apron.

