

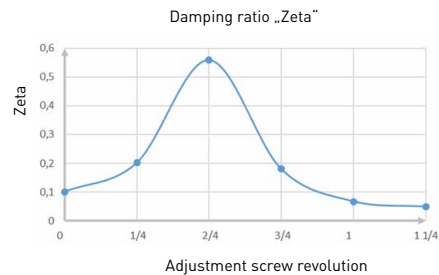
INSTRUCTION MANUAL
ADJUSTABLE DAMPED BORING BAR



Instructions for the optimum use of the vibration-damped boring bar:

1. Check that all screws are tight before use.
2. A clamping length of 4xD of the boring bar must be observed. The maximum overhang must not be exceeded.
3. The centre height must be aligned with the insert.

The vibration-damped boring bar must be adjusted for optimum damping effect for the respective application.



The diagram shown here is representative and cannot be applied to general applications.



The range of optimum damping is very small. To achieve the optimum damping, it may be necessary to carry out several adjustments.

The adjustment must always be made with the boring bar in a vertical position.



Basic setting:

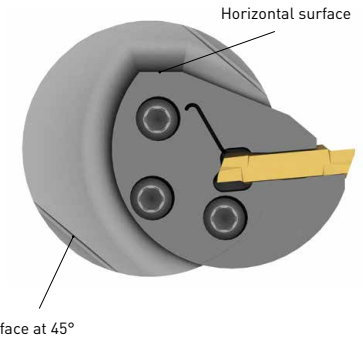
1. Loosen the two radial locking screws.
2. Tighten the adjusting screw fully. Then loosen the screw by 1 turn.
3. Tighten the two radial locking screws to 4 Nm.

Damper adjustment:

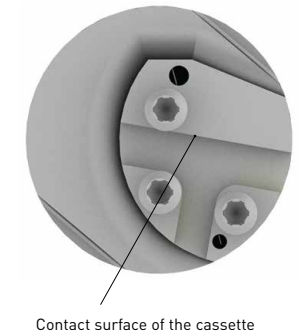
4. Loosen the two radial locking screws
5. Tighten / loosen the adjusting screw in 90° steps.
6. Tighten the two radial locking screws to 4 Nm.

Adjusting screw
Locking screw

Setting the centre height:



When using an RBK224... cassette, the insert is mounted at an angle of 5°.



Possible further adjustment surface:
Cassette contact surface at 10°.

DEUTSCHLAND, STAMMSITZ
GERMANY, HEADQUARTERS

Hartmetall-Werkzeugfabrik
Paul Horn GmbH
Horn-Straße 1
72072 Tübingen

Tel +49 7071 / 7004-0
Fax +49 7071 / 72893

info@de.horn-group.com
horn-group.com

