BIG KAISER

112.10

**Operating instruction
Fine boring heads
with fine adjustment EWN**

For EWN 2-152; EWN 2-32; EWN 04-22;
EWN 04-15; EWN 04-12; EWN 04-7

Centric Accessories Fig A+D

- Screw the insertholder ① on the tool holder ② and tighten it.
- Put the cutting tool (①+②), if necessary by using a reduction sleeve ③ , into the tool hole of the carrier ④ at least as far as the two clamping screws ⑤ are engaged.
- Align the cutting edge by the mark on the face of the fine boring head and tighten the two screws ⑤ and ⑥.
- Locate the carrier ④ in the desired position by rotating the set screw ⑦ with the released clamping screw (⑧, fig C). The scale disc ⑨ enables the change in diameter to read off accurately (1 DIV = 0,01 mm in diameter, EWN 2-50XL: 1 DIV = 0,005 mm in diameter), whereby the change in diameter is possible between 2 scale marks in an accuracy of Micrometers.
- Tighten the clamping screw ⑧.

EWN 2-152, peripheral Accessories Fig B

- Screw coolant nozzle 615.392 ⑳ on tool holder 615.226 ㉑ and tighten it.
- Put the coolant nozzle (⑳+㉑) into the hole of the carrier ④ and align it to the cutting edge ㉒.
- Tighten the clamping screw ⑤.
- Fix the insertholder ㉓ - and if necessary distance disc ㉔ - on the carrier ④.
- Tighten the clamping screw ㉕.

General Information

- Max. Coolant pressure: 20 bar (290 psi)
- Note that carrier travel is limited. Do NOT use force when adjusting.
- Periodic lubrication (every 20 operating hours approx.) via the lube nipple ㉘ ensures high precision combined with long life. A light machine oil is recommended, e.g. Mobil Vactra Oil No. 2, BP Energol HLP-D32, Klueber Isoflex PDP 94.
- The minimum unbalance of the tool is in center position.

- EWN 2-152: The minimum unbalance of the tool is in centre position without insertholder ㉓, distance disc ㉔ and clamping screw ㉕.
- Combined application with central and peripheral cutting tool is possible by using an adjustable insertholder.
- Diameter setting only with clamped tool holder

Maximum cutting speed

- For central cutting tools is the cutting data table valid.
- For peripheral cutting tools is the maximum cutting speed valid with $v_c$max = 1'200 m/min.

EWN 2-152
Take care of outside diameter 75
at e= +5.5

Fig. A   Fig. B   Fig. C   Fig. D
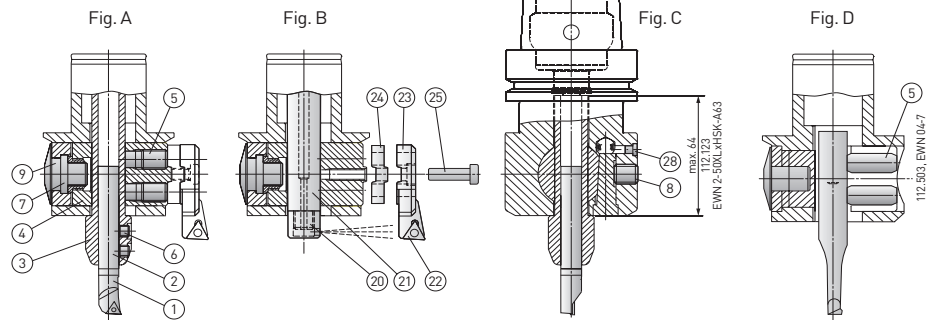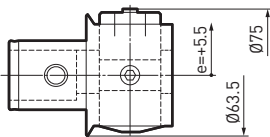
Pos.	EWN 2-152			EWN 2-32			EWN 04-22			EWN 04-15			EWN 04-07		
	M	**SW**	**M$_A$ [Nm]**	**M**	**SW**	**M$_A$ [Nm]**	**M**	**SW**	**M$_A$ [Nm]**	**M**	**SW**	**M$_A$ [Nm]**	**M**	**SW**	**M$_A$ [Nm]**
5	M10	5	10	M8	4	5	M6	3	2.5	M5	2.5	1.5	M3	1.5	0.8
6	M4	2	0,5	M4	2	0,5									
7	M6	3	2,5												
8	M10	5	10	M8	4	5	M6	3	2.5	M5	2.5	1.5	M3	1.5	0.8
25	M6	5	12												