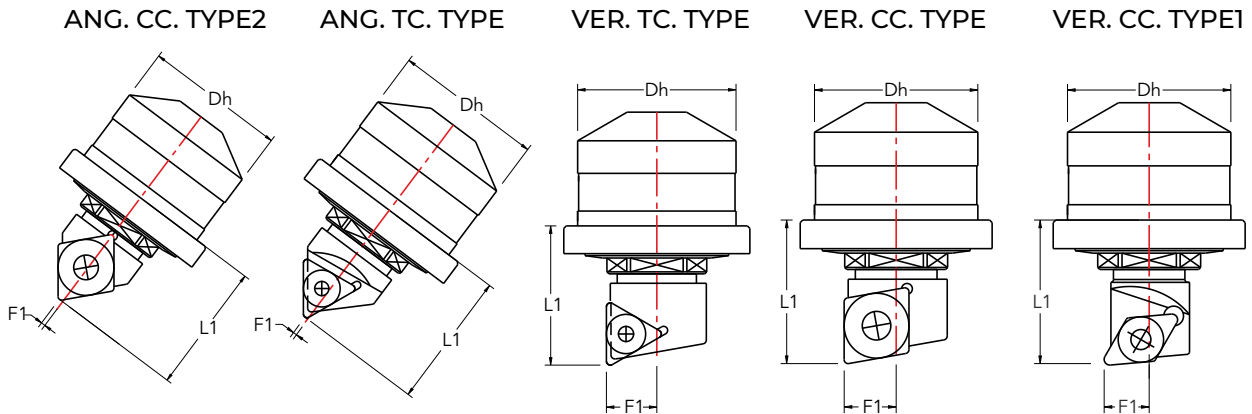


# Fine Boring Units



## Fine Boring Units Provides

- › Least count +/- 0.001 mm radially.
- › Repeatability +/- 0.002 mm.
- › Preloaded sturdy and zero backlash assembly.
- › Easy adjustment from top.
- › No locking / unlocking of any other screw.
- › Very economical and extra stock availability.
- › Precision adjustment in microns in order to achieve closer tolerances. (Finish Boring)
- › Clear indication on top of unit to adjust the size of boring bar in the machine itself.



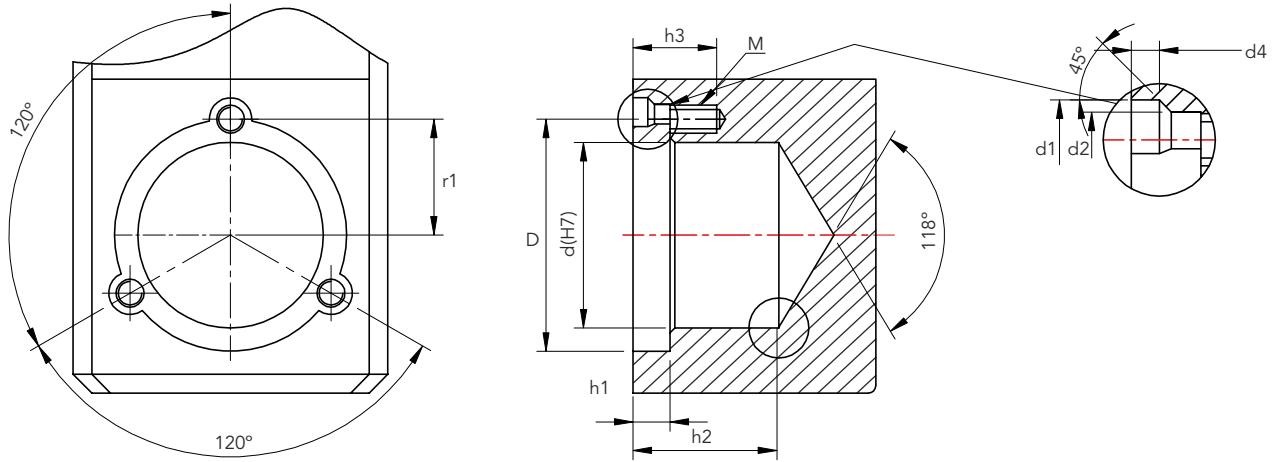
ENTRY VIEW	UNIT CODE & HAND		SUITABLE INSERT	DIMENSION			
	LH	RH		Dh	L1	F1	Dmin
	FLTA 06T1	FRTA 06T1	TC.. 06T1	16	14.3	0.2	25
	FLCA 0602	FRCA 0602	CC.. 0602	16	14.3	0.45	26
	FLTA 0902	FRTA 0902	TC.. 0902	20	19.1	1	33.1
	FLTA 1102	FRTA 1102	TC.. 1102	22	23	1.2	42.6
	FLCA 09T3	FRCA 09T3	CC.. 09T3	22	23	1.2	42.6
	FLCV 0602	FRCV 0602	CC.. 0602	16	13.3	5.1	27.6
	FLTV 0902	FRTV 0902	TC.. 0902	20	18.3	6.3	37.1
	FLTV 1102	FRTV 1102	TC.. 1102	22	22.1	7.2	49.1
	FLCV 09T3	FRCV09T3	CC.. 09T3	22	22.1	7.2	49.1
	FLDV 0702	FRDV 0702	DC.. 0702	20	18.3	6.3	37.1

### Spares List

UNIT CODE & HAND		SUITABLE INSERT	SPARES FOR UNITS				
LH	RH		INSERT SCREW	TROX	MOUNTING SCREW	TROX	SPANNER
FLTA 06T1	FRTA 06T1	TC.. 06T1	SC06T1-27	T6	SC06T1-04	T9	S10
FLCA 0602	FRCA 0602	CC.. 0602	SC0602-03	T7	SC0602-04	T9	S10
FLTA 0902	FRTA 0902	TC.. 0902	SC0902-05	T7	SC0902-04	T9	S13
FLTA 1102	FRTA 1102	TC.. 1102	SC1102-03	T7	SC1102-29	T15	S15
FLCA 09T3	FRCA 09T3	CC.. 09T3	SC09T3-09	T15	SC09T3-29	T15	S15
FLCV 0602	FRCV 0602	CC.. 0602	SC0602-03	T7	SC0602-04	T9	S10
FLTV 0902	FRTV 0902	TC.. 0902	SC0902-05	T7	SC0902-04	T9	S13
FLTV 1102	FRTV 1102	TC.. 1102	SC1102-03	T7	SC1102-29	T15	S15
FLCV 09T3	FRCV09T3	CC.. 09T3	SC09T3-09	T15	SC09T3-29	T15	S15
FLDV 0702	FRDV 0702	DC.. 0702	SC0702-03	T7	SC0702-04	T9	S13

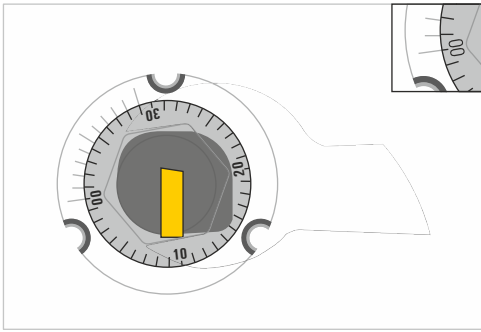
# Fine Boring Units

## Mounting Dimensions For Sigma-Fine Boring Units



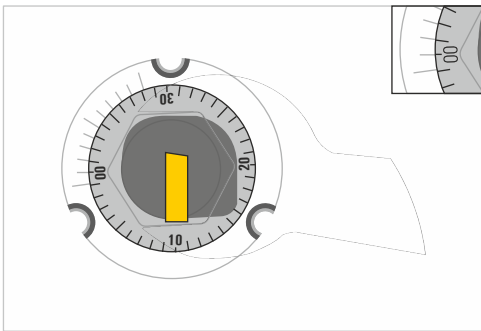
			D	d (H7)	d1	d2	h1	h2	h3	h4	M	r1 ±0.02
06			09	16	4.6	3.2	2.8	11.5	9	1.6	M3	9.65
09			25	20	4.6	3.2	4	15.5	9	1.6	M3	12.5
11			30	22	6.5	4.3	5	24	13	1.8	M4	15.4
	06		19	16	4.6	3.2	2.8	11.5	9	1.6	M3	9.65
	09		30	22	6.5	4.3	5	24	13	1.8	M4	15.4
		07	25	20	4.6	3.2	4	15.5	9	1.6	M3	12.5

## Handling Instructions



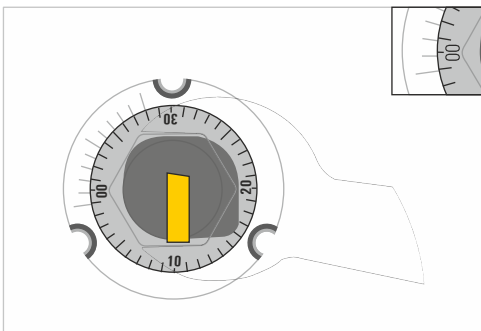
Pic-1

- Set desired diameter on tool pre-setter or with the help of dial outside machine using spanner.
- Load tool in spindle.
- Check that you are getting desired size.
- If not follow below instructions.



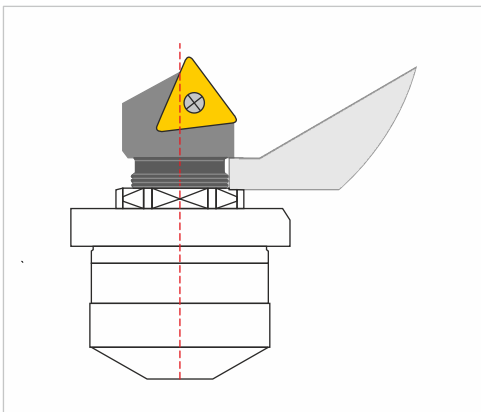
Pic-2

- Find line on the vernier scale that exactly matches with the main scale.
- To increase the diameter by 0.02mm, rotate the spanner clockwise and match the line with next adjacent line.



Pic-3

- Now to increase diameter again by 0.002mm, rotate the spanner slightly until it matches with the very next adjacent line.



Pic-4

- Maximum adjustment can be checked by using spanner end.
- Do not exceed the given adjustment limit to avoid damages.