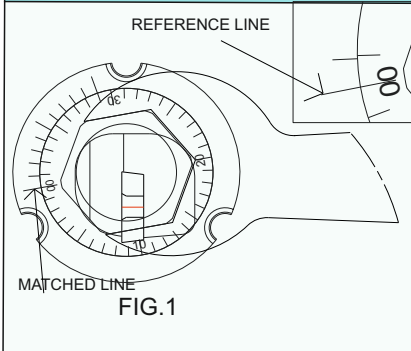
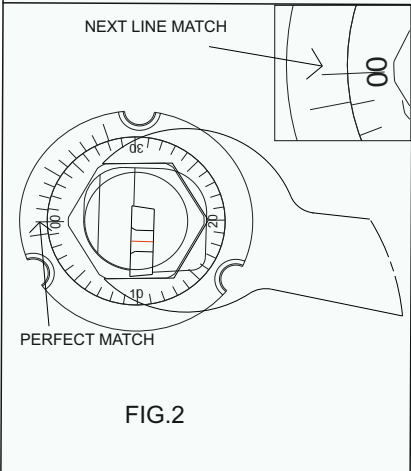


ADJUSTMENT OF SIGMA MICRO BORING UNIT



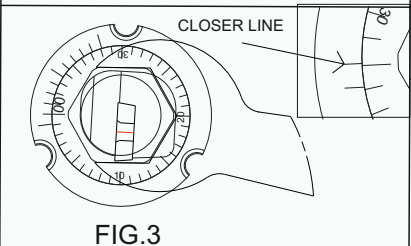
SETTING OF PRE BORE DIAMETER

- Set the required diameter of MBU on tool inspection machine or with the help of dial by using spanner.
- Set the cutting diameter of micro boring unit at lower side of tolerance.
- Example : if required cutting diameter is $\varnothing 30.02\text{mm}/\varnothing 29.99\text{mm}$ then set the micro bore at $\varnothing 29.99\text{mm}$.
- Load the tool into machine spindle and start manufacturing operation.
- After completing operation , check output cutting diameter of workpiece.
- In the case of deviation of measured output diameter , please follow below instructions for setting of microbore :



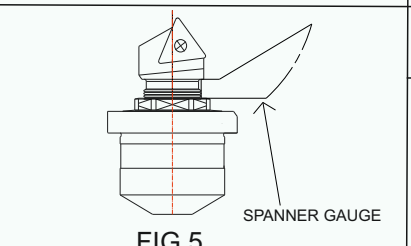
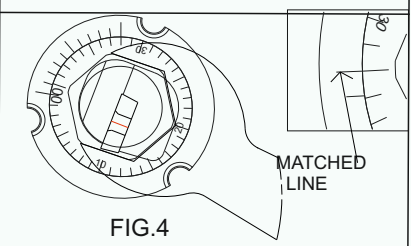
SETTING OF 0.02MM ADJUSTMENT

- If the output diameter is $\varnothing 29.99\text{mm}$.If we want to increase cutting diameter by 0.02mm follow below mention steps :
- Find the line on the vernier scale which do exactly match with the line on the main scale as shown in FIG.1.
- Rotate the nut of MBU in clockwise direction still next line on the vernier scale exactly match with the reference line on main scale of micro bore as shown in FIG.2...
- If the output diameter is $\varnothing 30.03\text{mm}$. If we want to decrease cutting diameter by 0.02 mm follow below mention steps :
- Find the line on the vernier scale which do exactly match with the line on the main scale as shown in FIG.1..
- Rotate the nut of MBU in anticlockwise direction still next line on the vernier scale exactly match with the reference line on main scale of micro bore .



SETTING OF 0.002MM ADJUSTMENT

- Now to increase diameter again by 0.002mm follow below steps:
- check the line on the vernier scale which is very closer with line on the main scale as shown in FIG.3..
- After checking closer line on the vernier scale rotate nut of the MBU match closer line with reference line on the main scale as shown in FIG.4



- Maximum adjustment of MBU we can check by using spanner gauge as shown in a FIG.5...
- Do not exceed the given adjustment limit to avoid damage to MBU.

