EN

BIG KAISER

319.03

Operating instruction
Rough boring heads
SW53 – 148 Face grooving

Fig. 1
The face grooving holders ⑫ are fixed with clamp screws ① on the tool body ⑬. The adjustment mechanism with adjustment screws ⑤ serves for diameter setting in both directions. On the face grooving holders ⑫, opposite of the cutter ⑭, a small hole ⑮ allows access for the Allen wrench ⑥ to the adjustment screw ⑤.

The twin-cutter boring heads SW are equipped with adjustable coolant nozzles ③.

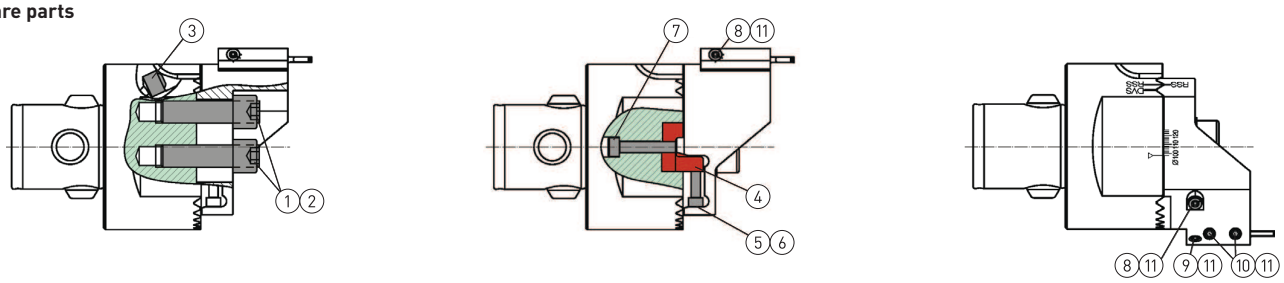
Fig. 2
The tool body ⑬ is marked with "RSS" and "DVS" ⑯. The face grooving holder ⑫ is also marked with "RSS" ⑰. The shorter of the two face grooving holders ⑫ is marked with "S" ⑱ and the longer one is marked with "L" ⑱.

Make sure that the boring head is always used with a short face grooving holder "S" and a long face grooving holder "L". During RSS, the marking must always point to RSS.

Fig. 3
Adjust both cutters ⑭ to the same diameter by means of an Allen wrench ⑥. The scale ⑲ serves for the rough diameter setting. Tighten both clamp screws ① with the specified torque (see table).

Fig. 4
Adjust both cutters ⑭ to the same height by means of an Allen wrench ⑪ and the adjustment bolt ⑧. Then tighten the adjustment bolt to 2.5 Nm with the clamp screw ⑨ and, as a last step, tighten the cutters to 2.5 Nm with the clamp screws ⑩.

Spare parts



	①	M_{max} [Nm]	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	M_{max} [Nm]	⑪
SW53	639.691	16	690.805	692.409	319.550	690.195	690.812	690.189	639.690	690.400	690.511	2.5	690.813
SW68	639.691	16	690.805	692.406	319.650	690.196	690.813	690.101	639.690	690.400	690.622	2.5	690.813
SW98 x CKN6	639.693	20	690.806	692.406	319.750	690.197	690.814	690.108	639.690	690.400	690.912	2.5	690.813
SW98 x CKN7	639.693	20	690.806	692.406	319.750	690.197	690.814	690.173	639.690	690.400	690.912	2.5	690.813
SW148 x CKN6	639.693	20	690.806	692.406	319.750	690.197	690.814	609.108	639.690	690.400	690.913	2.5	690.813
SW148 x CKN7	639.693	20	690.806	692.406	319.750	690.197	690.814	690.173	639.690	690.400	690.913	2.5	690.813

Fig. 1

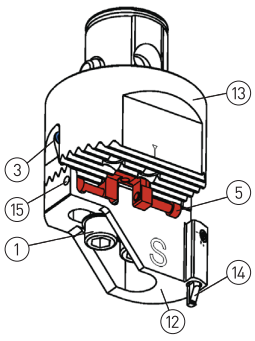


Fig. 2

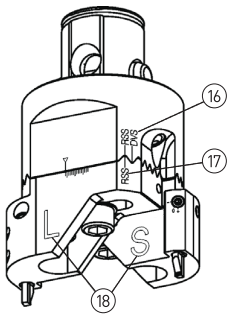


Fig. 3

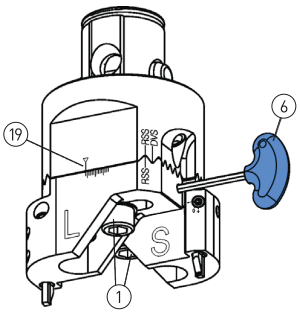
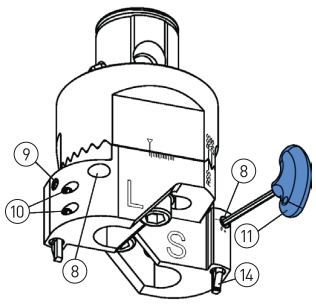


Fig. 4



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