GÜHRING

SAP-No.: 400156079

ADJUSTING GUIDELINE GM300 – MODULE ADAPTER 4x90° / 6x60°

1. ASSEMBLY AND ALIGNMENT OF HOLDER MODULE WITH RADIAL ADJUSTMENT

1.1 CLEAN TAPER AND PLANE SURFACES OF HOLDER MODULE AND HOLDER ADAPTER.

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FIG. 1:
Holder module

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FIG. 2:
Holder adapter

ATTENTION

This assembly step is only necessary when Gühring module holders are applied. Why? Because only with Gühring module holders coolant leak tightness between holder module and holder adapter can be achieved via an intermediate sleeve.

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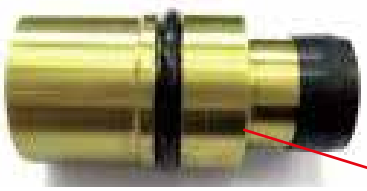
Insert intermediate sleeve in holder module to limit stop of insertion hole.



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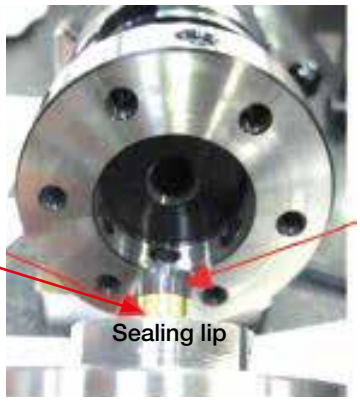
Intermediate sleeve
incl. O-ring + sealing lip
TiN-coated



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1) Initially lightly oil the sealing lip.
2) Carefully* insert sealing lip in central holder bore, then fit module in adapter.

*to avoid damage

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1.2 FIT HOLDER MODULE. TIGHTEN FASTENING SCREWS TO 50% OF THE SPECIFIED TORQUE (SEE TABLE PAGE 3).

1.3 POSITION DIAL GAUGE ON THE CONCENTRIC SETTING COLLAR (GROUND COLLAR ON THE MODULE DIAMETER). TAKE THE HIGHEST MEASURING POINT AND “ZERO” THE DIAL GAUGE.

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1.4 ROUGHLY ALIGN THE HOLDER MODULE (APPROX. 0.01 MM). LOOSEN ADJUSTING SCREWS AGAIN FOLLOWING ACTUATION.

1.5 TIGHTEN THE FASTENING SCREWS TO THE SPECIFIED TORQUE.

Module diameter [cm]	Fastening screw	Tightening torque [Nm]
60	DIN 912-M5x16-12.9	8.7
70	DIN 912-M6x20-12.9	15
80	DIN 912-M6x20-12.9	15
100	DIN 912-M8x25-12.9	36
117	DIN 912-M8x25-12.9	36
140	DIN 912-M10x30-12.9	72

Then adjust concentricity with the adjusting screws. Loosen adjusting screws again following actuation. Repeat the process until the concentricity error is ≤ 3 µm. Once the concentricity has been adjusted lightly tighten the adjusting screws and re-check concentricity.

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2. ALIGNMENT OF HOLDER MODULE TO ADJUST RUN OUT

2.1 To adjust run out the dial gauge is positioned at the front concentricity check point, cutting edge guide pads or at a suitable location. Carry out run out correction via the adjustment screws. Do not loosen the adjustment screws following actuation.

2.2 Once the run out is set to ≤ 3 µm, re-check the concentricity on the module collar and correct if necessary. Should the concentricity require correction the run out must subsequently be checked again.