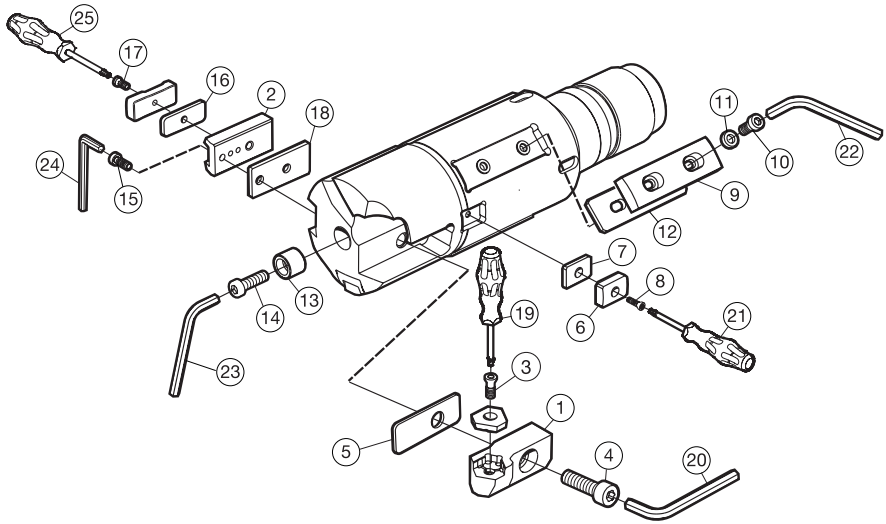


# How to adjust CoroDrill® 818



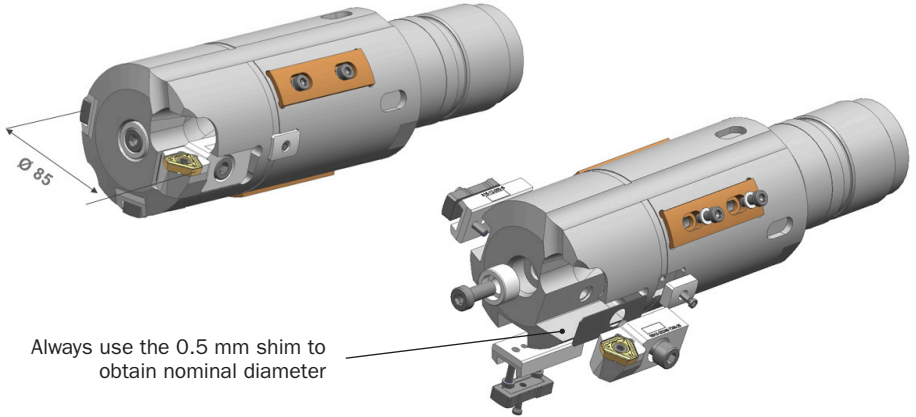
# Spare parts for CoroDrill® 818



- |                         |                |
|-------------------------|----------------|
| ① Peripheral cartridge  | ⑭ Screw        |
| ② Pad shoes             | ⑮ Screw        |
| ③ Insert screw          | ⑯ Pad shim set |
| ④ Screw                 | ⑰ Screw        |
| ⑤ Cartridge shim set    | ⑱ Shim         |
| ⑥ Pad                   | ⑲ Screwdriver  |
| ⑦ Safety pad shim set   | ⑳ Key          |
| ⑧ Screw                 | ㉑ Screwdriver  |
| ⑨ Fibre pad blank       | ㉒ Key          |
| ⑩ Screw                 | ㉓ Key          |
| ⑪ Washer                | ㉔ Key          |
| ⑫ Shim                  | ㉕ Screwdriver  |
| ⑬ Seat protection plate |                |

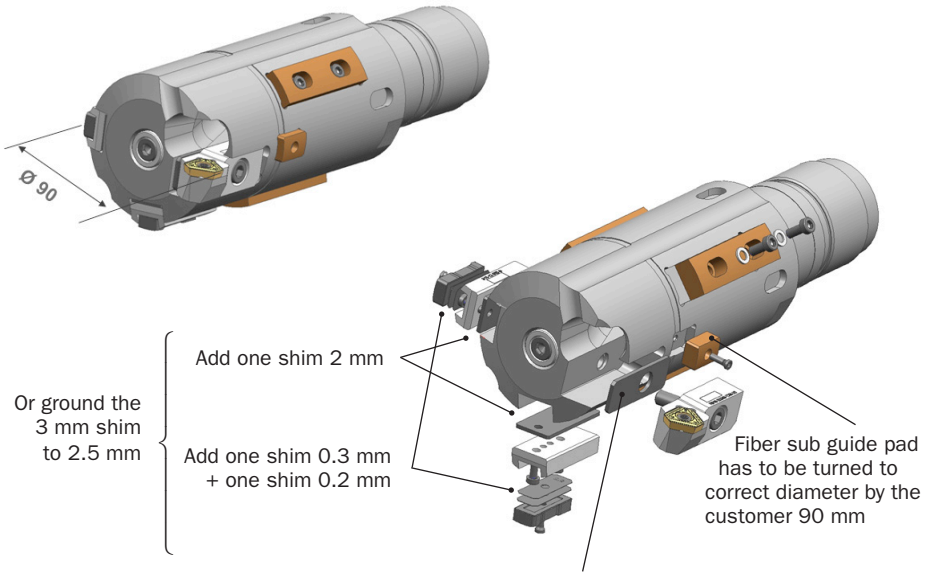
<b>How to adjust CoroDrill® 818</b>	<b>ENG</b> 4 - 5
如何调整 CoroDrill® 818	<b>CHI</b> 6 - 7
<b>Instructions de réglage CoroDrill® 818</b>	<b>FRE</b> 8 - 9
<b>Einstellung von CoroDrill® 818</b>	<b>GER</b> 10 - 11
<b>Istruzioni per la regolazione CoroDrill® 818</b>	<b>ITA</b> 12 - 13
コロドリル818 調整方法	<b>JPN</b> 14- 15
<b>Como ajustar a CoroDrill® 818</b>	<b>POR</b> 16 - 17
<b>Настройка CoroDrill® 818</b>	<b>RUS</b> 18 - 19
<b>Cómo ajustar CoroDrill® 818</b>	<b>SPA</b> 20 - 21

## Counterbore set at nominal diameter 85 mm



Always use the 0.5 mm shim to obtain nominal diameter

## Counterbore set at diameter 90 mm



Or ground the 3 mm shim to 2.5 mm

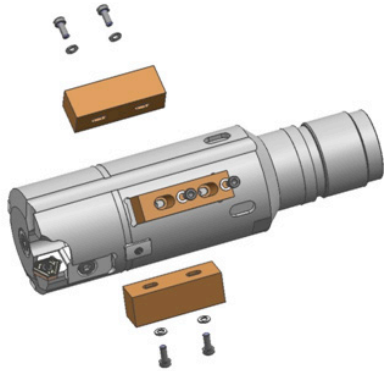
Add one shim 2 mm  
Add one shim 0.3 mm + one shim 0.2 mm

Fiber sub guide pad has to be turned to correct diameter by the customer 90 mm

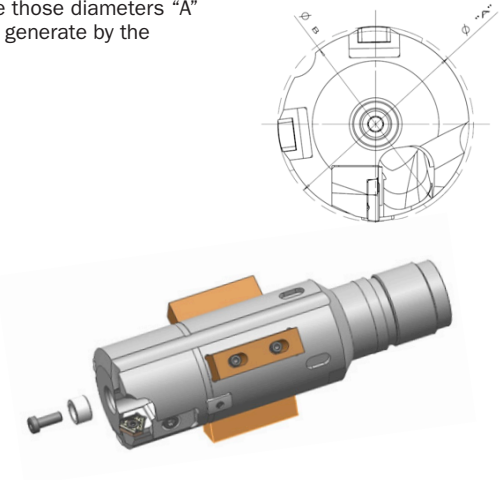
Use one 3 mm shim alternatively one 2 mm shim and one 1 mm shim

## Fiber pads turning instruction

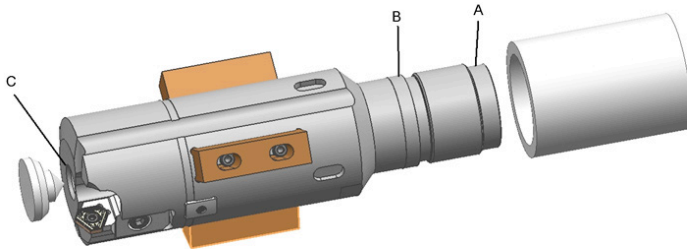
Set the tool to preferred diameter, and ensure those diameters “A” generated by the insert and the diameter “B” generate by the support/guide pads are concentric.



Add the fiber pads blank on the head



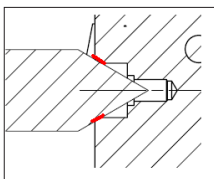
Remove the seat protection plate



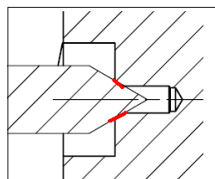
Add tailstock and clamp the head in a fixture (to be able to clamp the tool in turning machine without deforming the coupling).

To be able to turn the fiber pads concentric use point A-B-C as a reference.

Different center point:

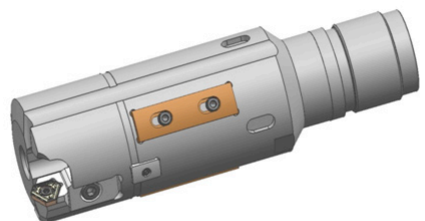


Small size

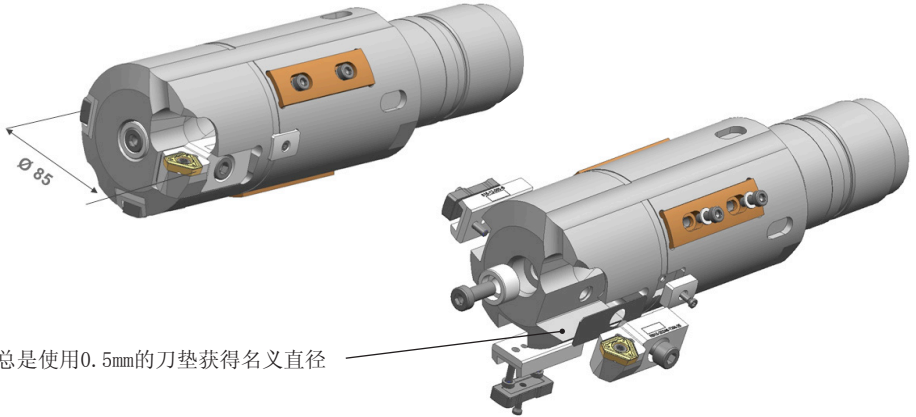


Big size

— Contact area

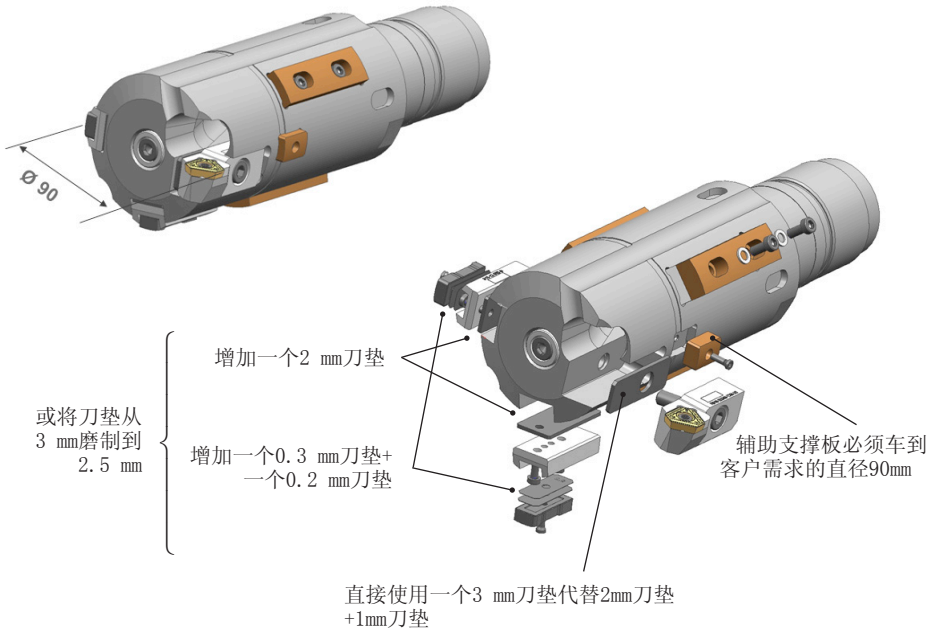


## 扩孔钻名义直径设置为85 mm



总是使用0.5mm的刀垫获得名义直径

## 扩孔钻直径设置为90 mm



或将刀垫从  
3 mm磨制到  
2.5 mm

增加一个2 mm刀垫

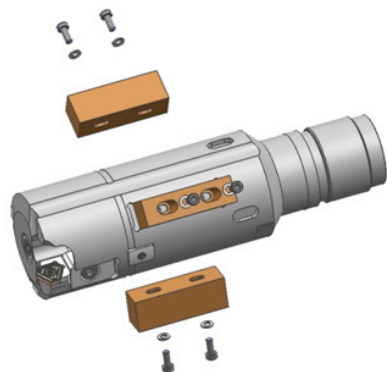
增加一个0.3 mm刀垫+  
一个0.2 mm刀垫

直接将一个3 mm刀垫代替2mm刀垫  
+1mm刀垫

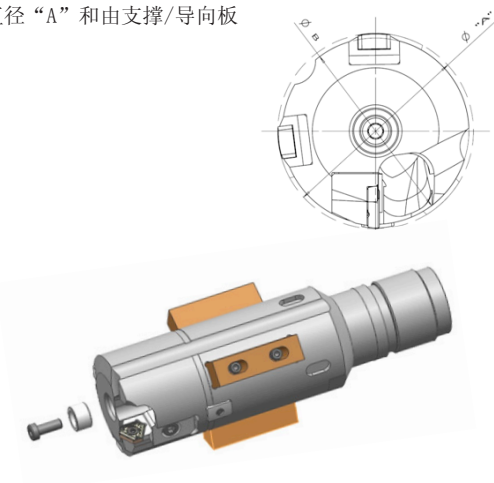
辅助支撑板必须车到  
客户需求的直径90mm

## 辅助支撑板车削细则

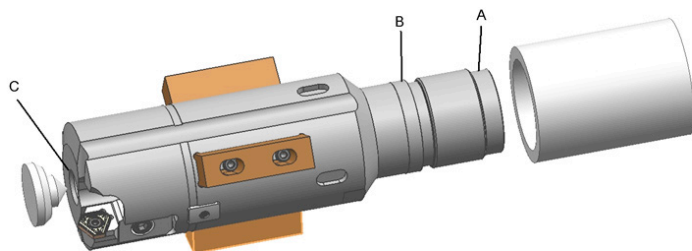
将刀具设置为首选直径，确保由刀片形成的直径“A”和由支撑/导向板形成的直径“B”同心



将纤维板坯装到钻头上

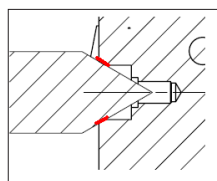


拆下刀座保护板

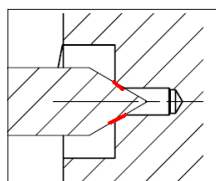


加装尾架夹紧钻头（为了避免接口变形，最好有保护套）。  
使用A-B-C三点作为参考点将纤维板转至同心。

不同的中心点：

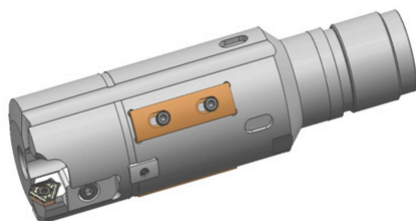


小尺寸

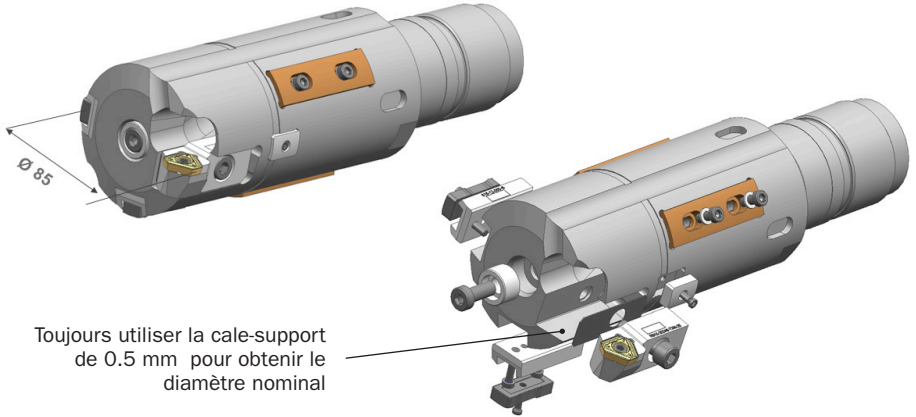


大尺寸

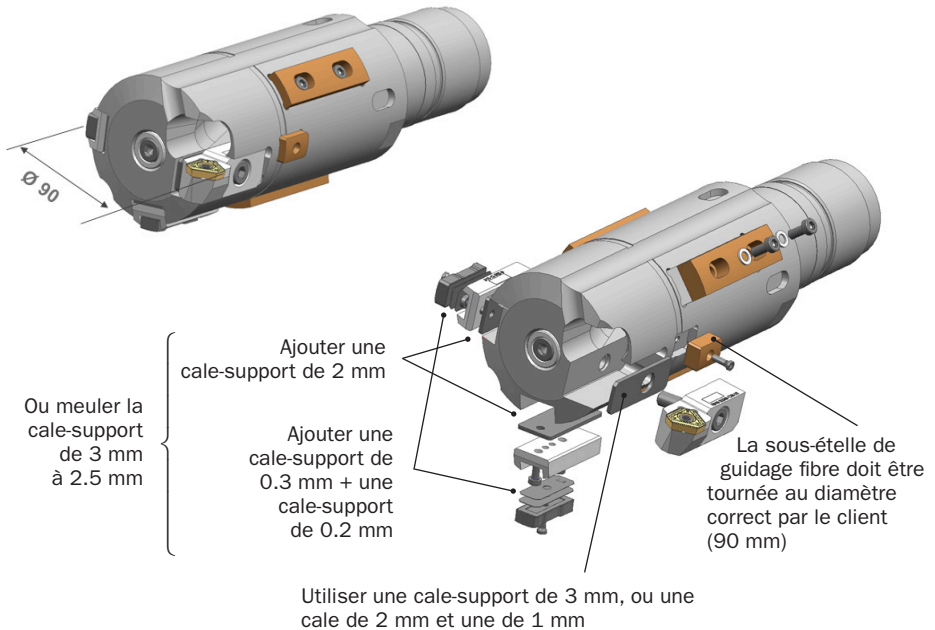
— 接触面



## Diamètre nominal de réalésage réglé à 85 mm



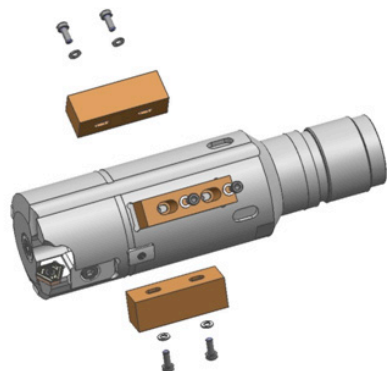
## Diamètre de réalésage réglé à 90 mm



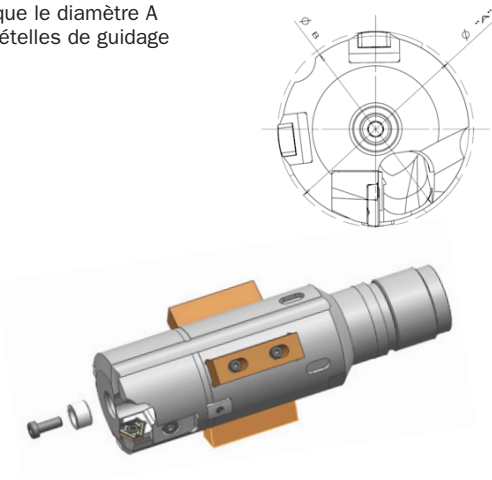


## Instructions pour le tournage des ételles fibre

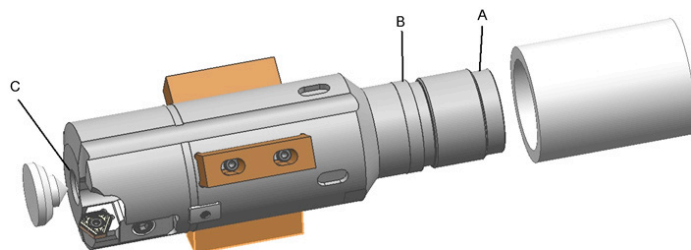
Régler l'outil au diamètre voulu et s'assurer que le diamètre A produit par la plaquette et le diamètre B des ételles de guidage sont concentriques.



Fixer les ébauches d'ételles fibre sur la tête



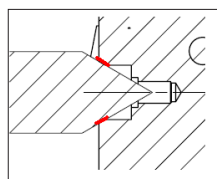
Retirer la plaque de protection du logement



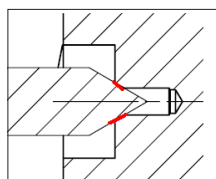
Positionner une contre-broche et serrer la tête dans un dispositif de serrage (pour pouvoir tourner l'outil sans déformer l'accouplement).

Pour tourner les ételles fibre de manière concentrique, utiliser les points A-B-C comme référence.

Différents centres :

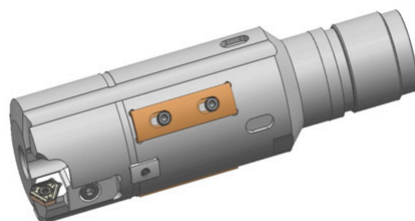


Petite taille

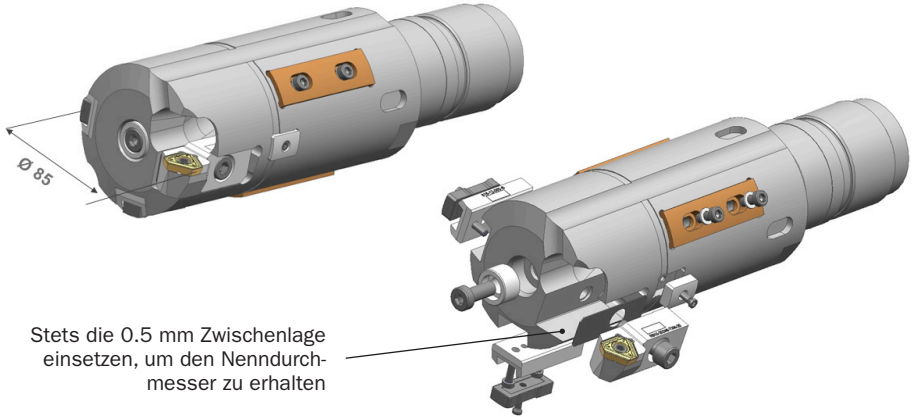


Grande taille

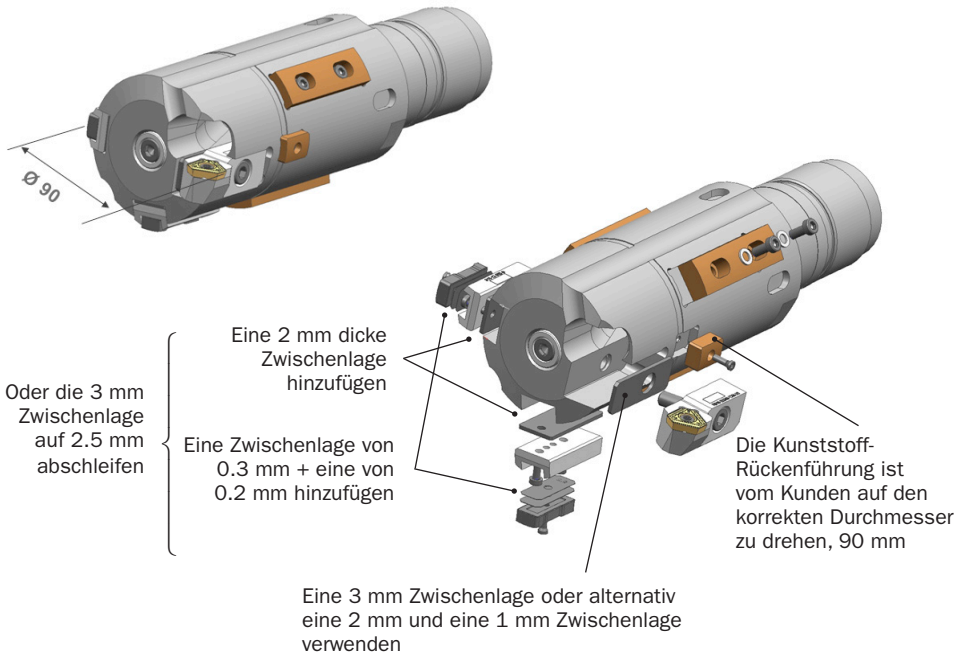
— Zone de contact



## Aufbohrwerkzeug/Senkwerkzeug auf 85 mm Nenndurchmesser einstellen

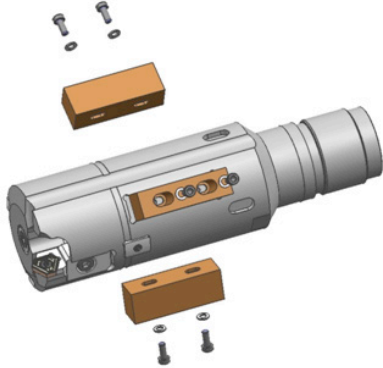


## Aufbohrwerkzeug/Senkwerkzeug auf 90 mm Nenndurchmesser einstellen

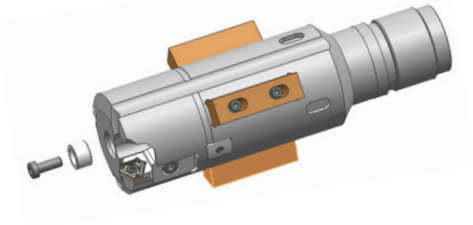
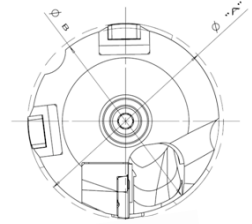


## Anleitung zum Drehen der Kunststoff-Rückenführung

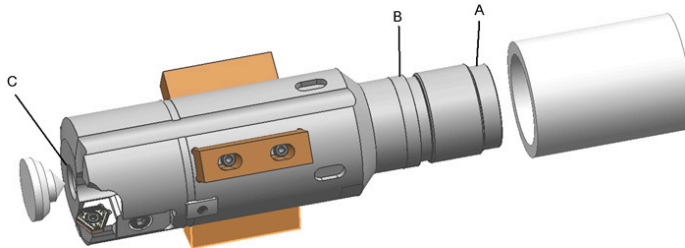
Das Werkzeug auf den gewünschten Durchmesser einstellen und sicherstellen, dass diese Durchmesser "A", die durch die Wendeschneidplatte erzeugt werden, und der Durchmesser "B", welcher durch die Führungsleisten erzeugt wird, konzentrisch sind.



Die Kunststoff-Rückenführung zusätzlich auf den Bohrkopf montieren



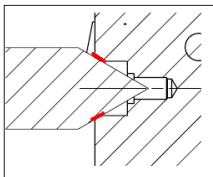
Zentriersitzschutz entfernen



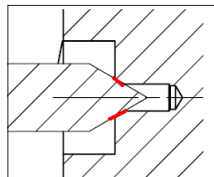
Reitstock zustellen und den Bohrkopf in eine Vorrichtung klemmen (zur Spannung des Werkzeugs in die Drehmaschine, ohne die Kupplung zu deformieren).

Für konzentrisches Drehen der Kunststoff-Rückenführungen sind die Punkte A-B-C als Bezugspunkte zu verwenden.

Unterschiedlicher Mittelpunkt

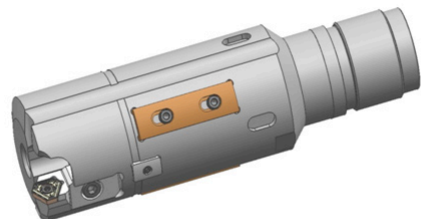


Kleiner

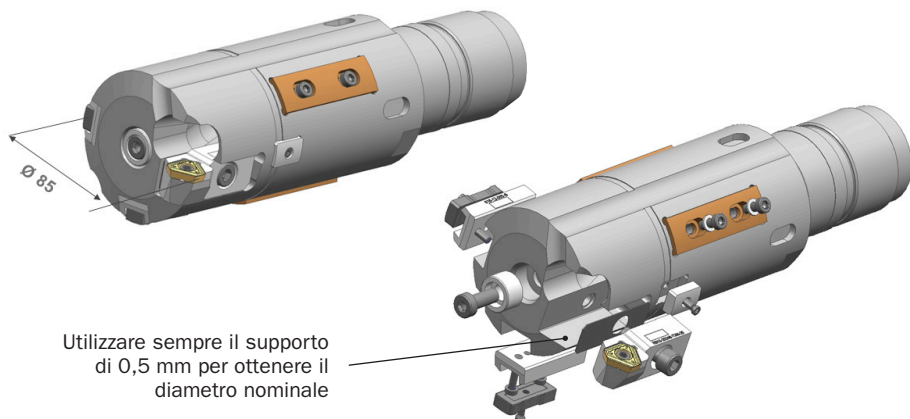


Größer

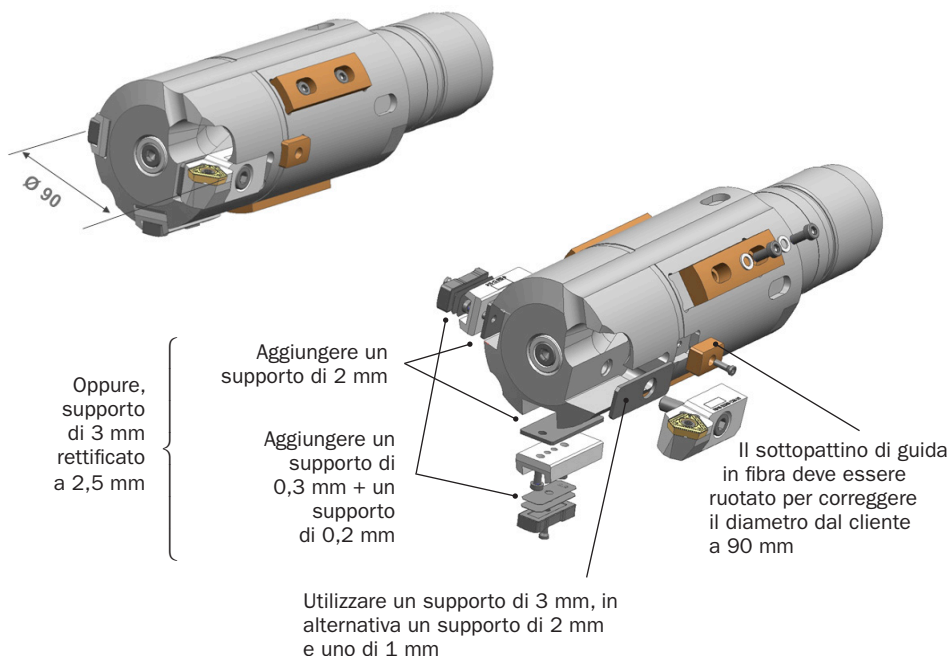
— Kontaktzone



## Allargatore regolato al diametro nominale di 85 mm

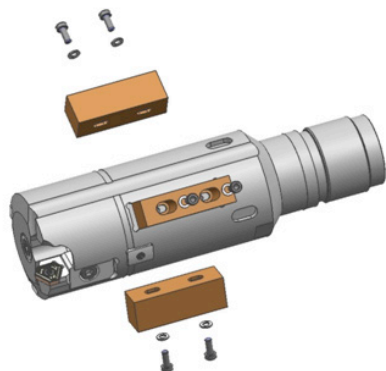
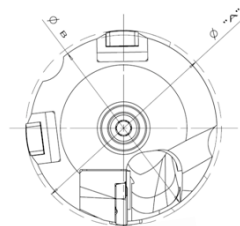


## Allargatore regolato al diametro di 90 mm

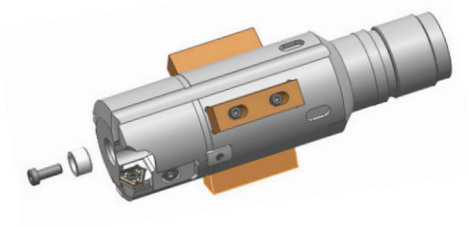


## Istruzioni per la rotazione dei pattini in fibra

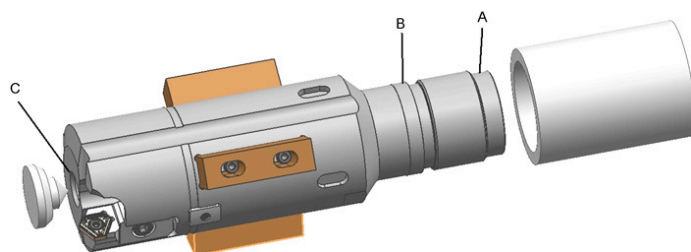
Impostare l'utensile al diametro desiderato e garantire che il diametro "A", generato dall'inserto, e il diametro "B", generato dal supporto/pattino di guida, siano concentrici.



Aggiungere i pattini in fibra semilavorati sulla testa



Rimuovere la bussola di protezione della sede

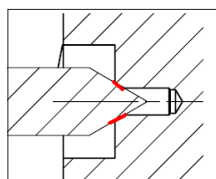
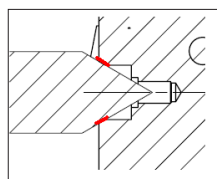


12.

Aggiungere la contropunta e bloccare la testa in un'attrezzatura (per poter serrare l'utensile nel tornio senza deformare l'accoppiamento).

Per poter rendere concentrici i pattini in fibra, usare i punti A-B-C come riferimento.

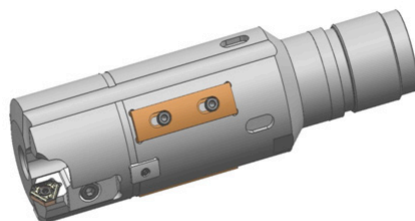
Diverso punto centrale:



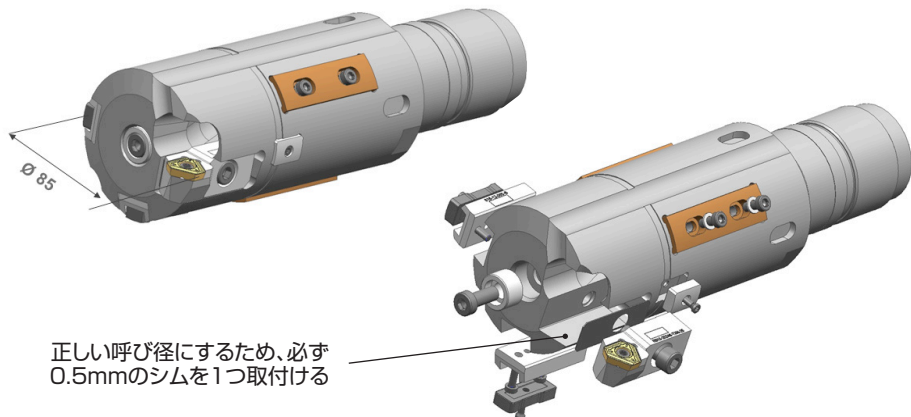
Piccola dimensione

Grande dimensione

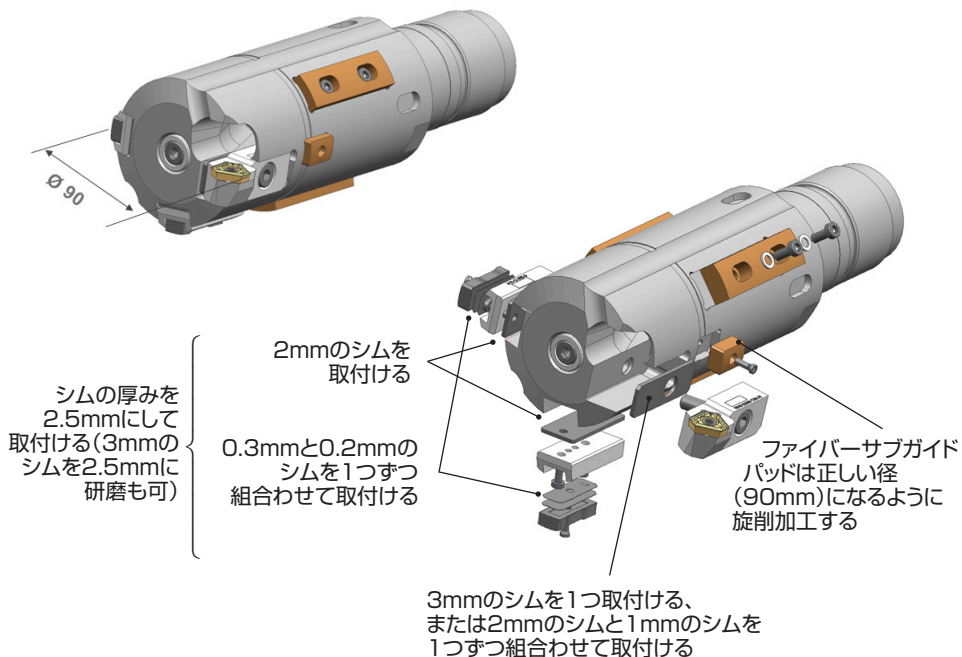
— Area di contatto



## 呼び径85mmのカウンターボア調整方法

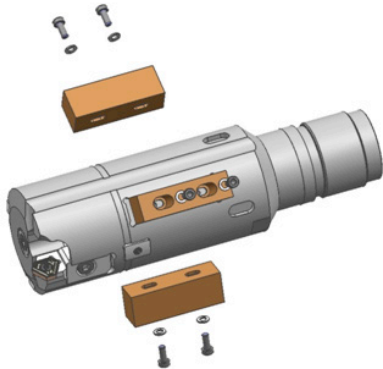
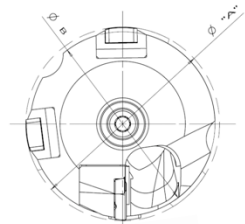


## 径90mmのカウンターボア調整方法

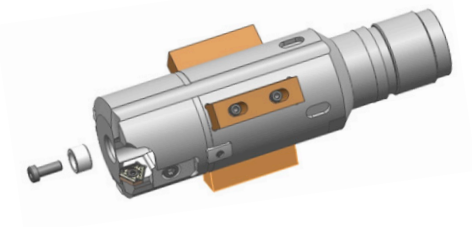


# ファイバーパッド旋削加工手順

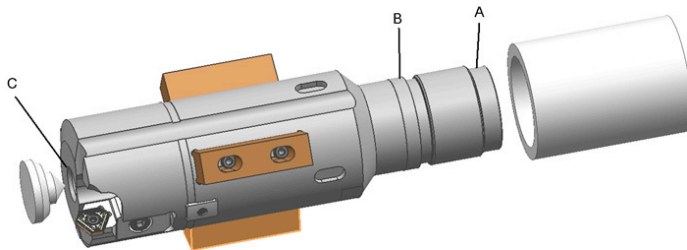
工具を任意の径にセットし、チップ軌跡径“A”とサポート/ガイドパッド軌跡径“B”が同心円になるようにする



ファイバーパッドブランクをヘッドに追加する



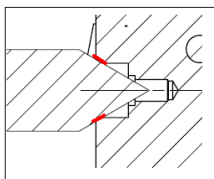
シートプロテクションプレートを取り外す



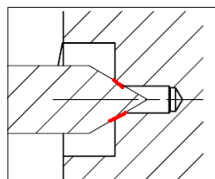
テールストックで、工具のヘッドをクランプする(カップリングが変形することなく旋盤に工具をクランプできるように)

ファイバーパッドを旋削加工して同心円になるようにする。ポイントA、B、Cをクランプやおさえとして使用する

センター用穴:

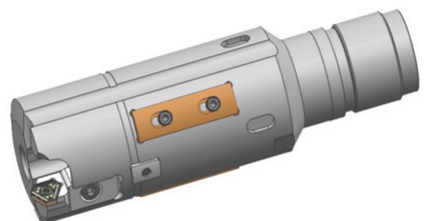


工具径が小さい場合

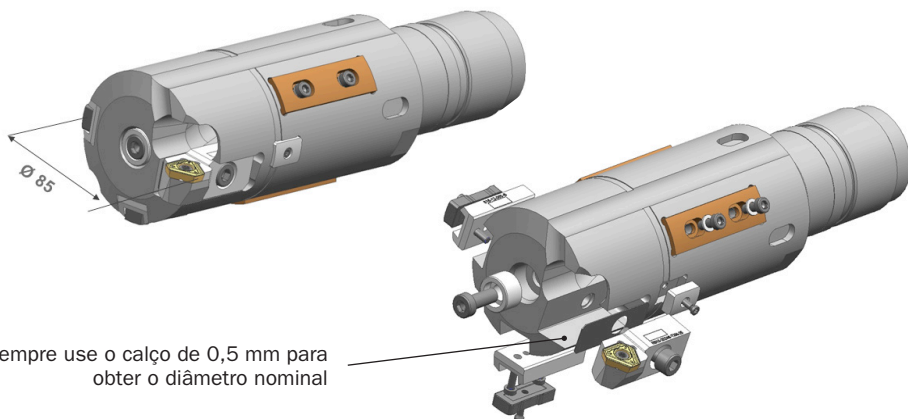


工具径が大きい場合

— 接触面

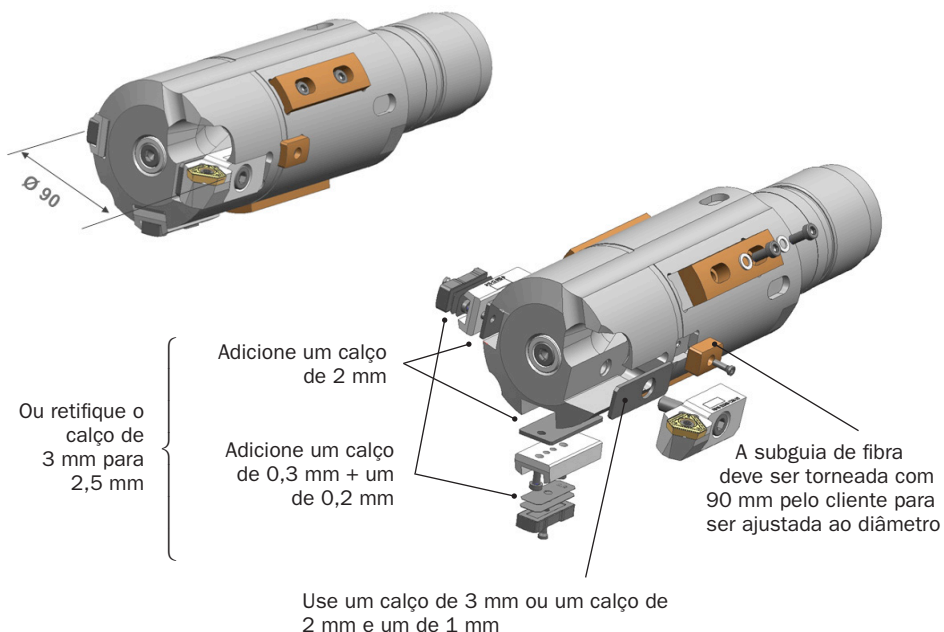


## Ajuste da cabeça alargadora para o diâmetro nominal de 85 mm



Sempre use o calço de 0,5 mm para obter o diâmetro nominal

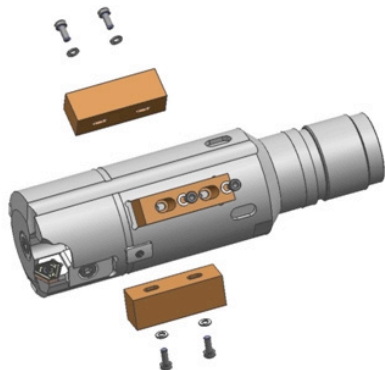
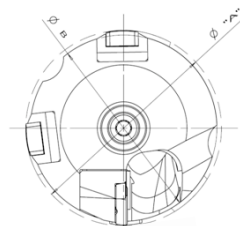
## Ajuste da cabeça alargadora para o diâmetro nominal de 90 mm



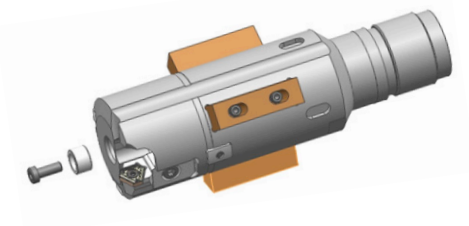


## Instruções para torneiar as guias de fibra

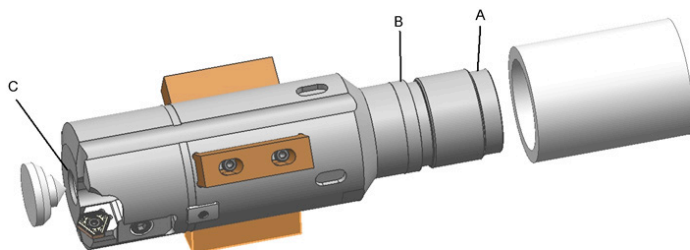
Ajuste a ferramenta para o diâmetro desejado e certifique-se de que os diâmetros "A", gerado pela pastilha, e "B", gerado pelos suporte/guias, estejam concêntricos.



Adicione o blank das guias de fibra à cabeça



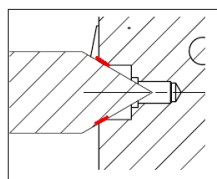
Remova o anel de proteção do furo de centro



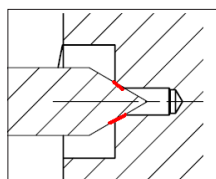
Adicione o contraponta e fixe a cabeça em um dispositivo de fixação (para possibilitar a fixação da ferramenta na máquina de torneamento sem deformar o acoplamento).

Para que seja possível torneiar a guia de fibra concêntrica, utilize os pontos A-B-C como referência.

Diferentes contrapontas:

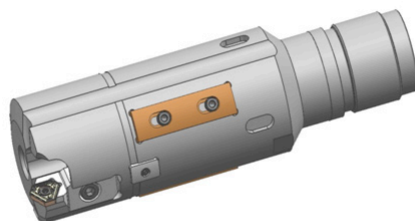


Pequena

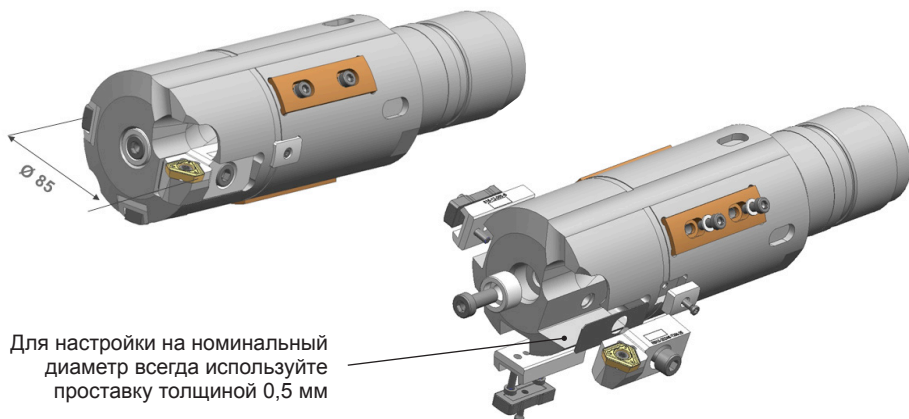


Grande

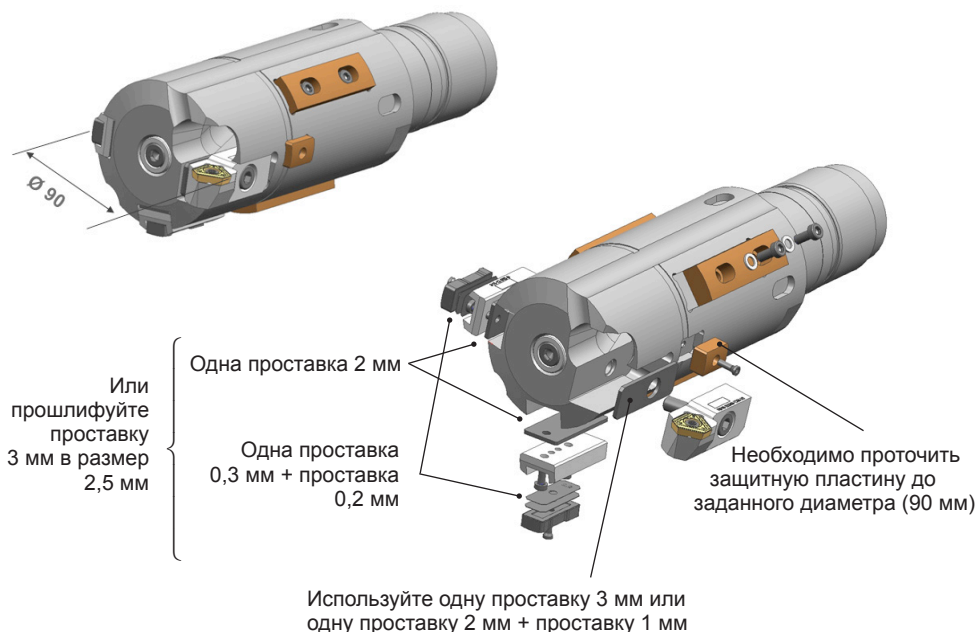
— Área de contato



## Настройка расточной головки на номинальный диаметр 85 мм

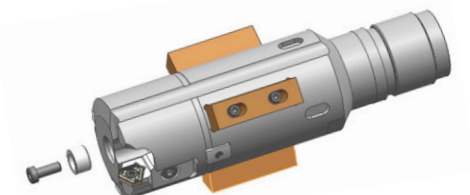
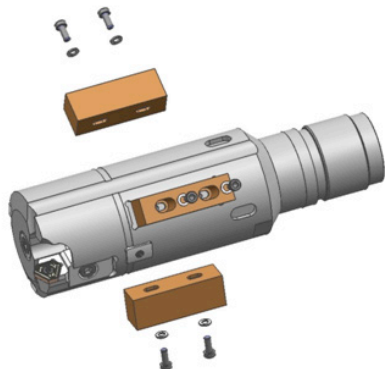
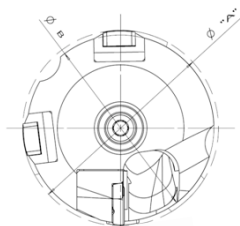


## Настройка расточной головки на диаметр 90 мм



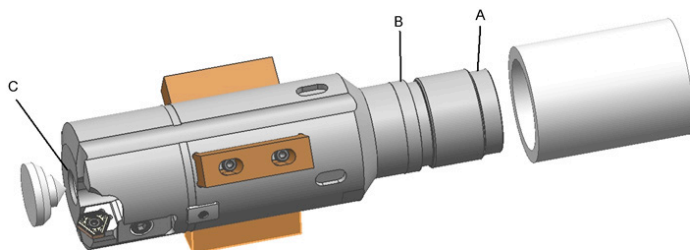
## Инструкции по настройке композитных опорно-направляющих пластин

Настройте инструмент на необходимый диаметр и убедитесь, что окружность диаметром "А", получаемая режущей пластиной, и окружность диаметром "В", получаемая опорно-направляющими пластинами, концентричны.



Закрепите заготовки для опорно-направляющих пластин на расточной головке

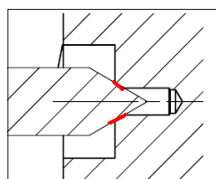
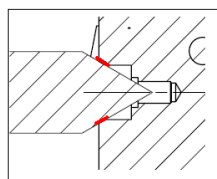
Извлеките защитную шайбу настроечного отверстия



Подведите центр и закрепите головку в приспособлении (для зажима инструмента без деформации соединения).

Используйте точки А-В-С как базу для обеспечения концентричности при точении композитных опорно-направляющих пластин.

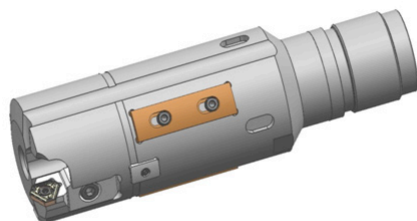
Методы центрирования:



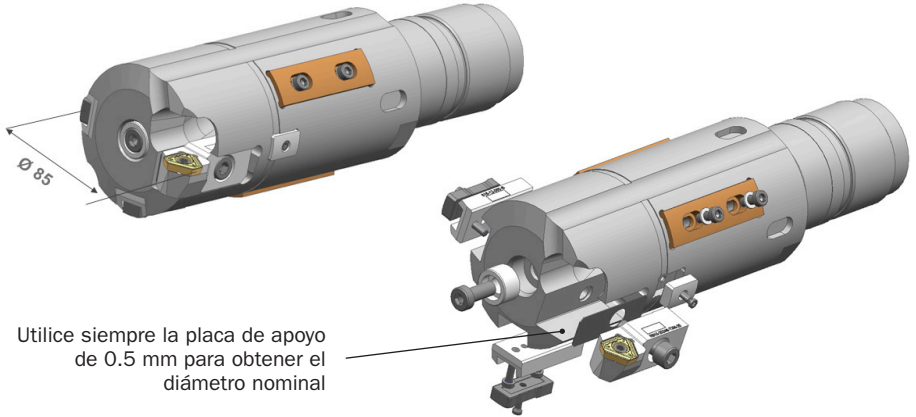
Небольшой диаметр головки

Большой диаметр головки

— Поверхности контакта

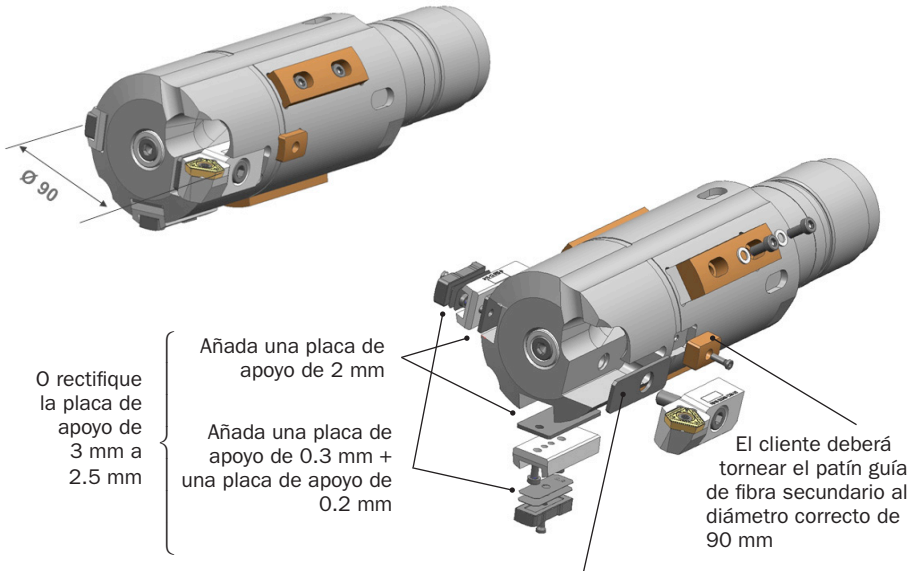


## Herramienta de avellanado reglada al diámetro nominal de 85 mm



Utilice siempre la placa de apoyo de 0.5 mm para obtener el diámetro nominal

## Herramienta de avellanado reglada al diámetro de 90 mm



O rectifique la placa de apoyo de 3 mm a 2.5 mm

Añada una placa de apoyo de 2 mm

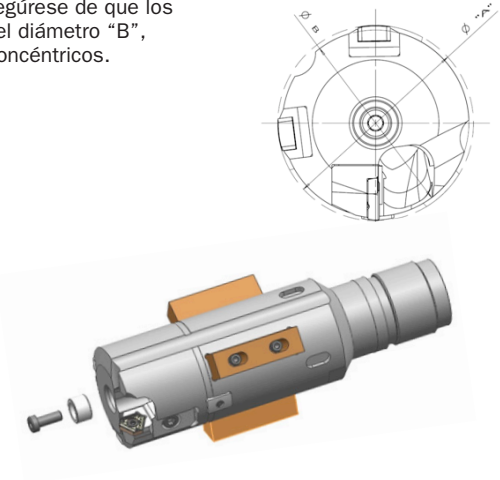
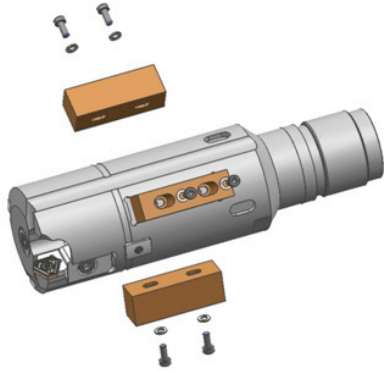
Añada una placa de apoyo de 0.3 mm + una placa de apoyo de 0.2 mm

El cliente deberá tornearse el patín guía de fibra secundario al diámetro correcto de 90 mm

Utilice una placa de apoyo de 3 mm o, como alternativa, una placa de apoyo de 2 mm y una placa de apoyo de 1 mm

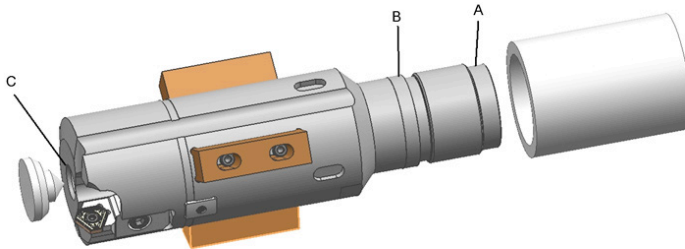
## Instrucciones de torneado de patines guía de fibra

Fije la herramienta al diámetro deseado y asegúrese de que los parámetros "A", generados por la plaquita, y el diámetro "B", generado por el patín de soporte/guía, son concéntricos.



Incorpore la proforma de los patines de fibra en la cabeza

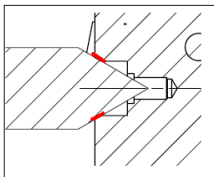
Retire la placa de protección del asiento



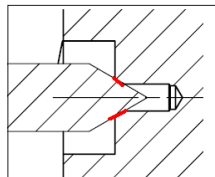
Incorpore el contrapunto y ajuste la cabeza en la fijación (para sujetar la herramienta en la máquina de torneado sin deformar el acoplamiento).

Para torneado los patines de fibra de forma concéntrica utilice los puntos A-B-C como referencia.

Diferentes puntos centrales:

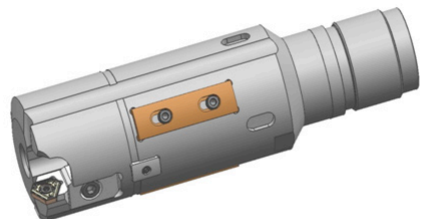


Tamaño pequeño



Tamaño grande

— Área de contacto









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