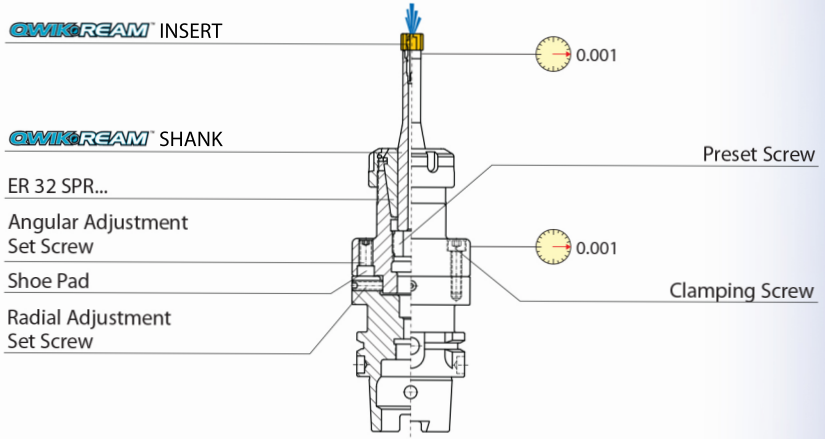
Radial and Angular Alignment Toolholder

# ADJ Operation Instructions

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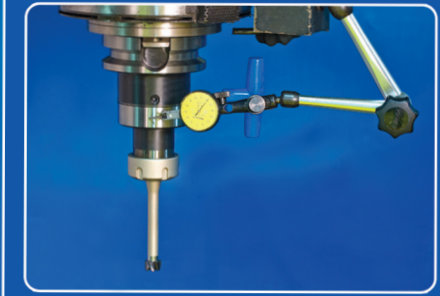

Member IMC Group
Ingersoll Cutting Tools

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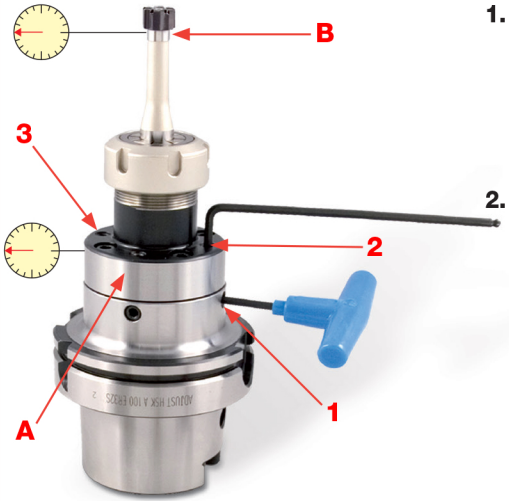


1. **Tighten the Cutting Tool:**
   Clamp the cutting tool into the chuck and make sure that screws no. 1 & 3 are tightened until giving slight resistance.

2. **Radial Adjustment:**
   Place the dial indicator (with a resolution of 0.001 mm) on the ground area A and adjust the runout to ≤ 0.001 mm. The adjustment should be made with the 4 screws (no. 1) located on the outer diameter of the toolholder.

3. **Angular Adjustment:**
   Place the dial indicator on the ground area B. Adjust the axial runout to ≤ 0.001 mm with 4 adjustment screws (no. 2) located on the face of the chuck.

4. **Final Clamping:**
   Slightly tighten the 4 clamping screws (no. 3) located on the face of the chuck, and then the 4 screws on the outer diameter.

5. **Final Runout Check:**
   After adjusting and tightening, recheck the axial and radial runout to make sure that runout of ≤ 0.001 is maintained. If necessary, do fine tuning.