

## Setting instructions for Walter Precision B3230/B4030 precision boring tools

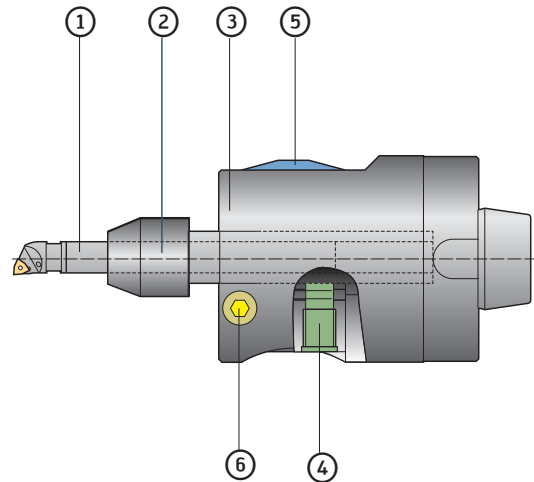
These tools have a highly precise adjustment mechanism.

The scale graduation permits effortless adjustment of the cutting edge in the  $\mu$  range.

B 2

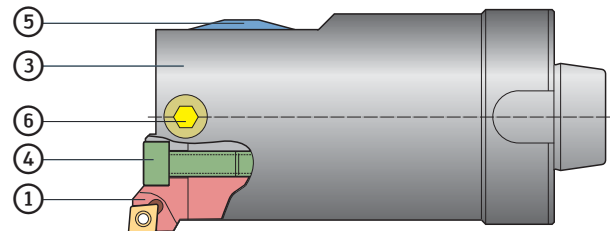
### Walter Precision<sup>MINI</sup>

1. Slide the insert holder ①, using a reducing sleeve ② if necessary, into the locating bore of the base body ③ until both clamping screws ④ are engaged.
  2. Align the cutting edge with the marking provided on the face of the boring head and tighten the two clamping screws ④.
  3. Move the base body ③ to the required diameter by turning the adjusting screw ⑤ with the locking screw ⑥ undone.
- The scale disc with vernier scale allows for a precise reading of the diameter change (1 DIV = 0.01 mm in diameter, with vernier scale 1 DIV = 0.002 mm in diameter).
4. Now tighten the locking screw ⑥.



### Walter Precision<sup>MEDIUM</sup>

1. Position the cartridge ① in the cartridge guide of the base body ③ and secure with clamping screws ④.
  2. Undo the locking screw ⑥.
  3. Move the cartridge holder into the required diameter by turning the adjusting screw ⑤ with the locking screw ⑥ undone.
- The scale disc with vernier scale allows for a precise reading of the diameter change (1 DIV = 0.01 mm in diameter, with vernier scale 1 DIV = 0.002 mm in diameter).
4. Tighten the locking screw ⑥.



**One full rotation of the scale ① = 1 mm.**

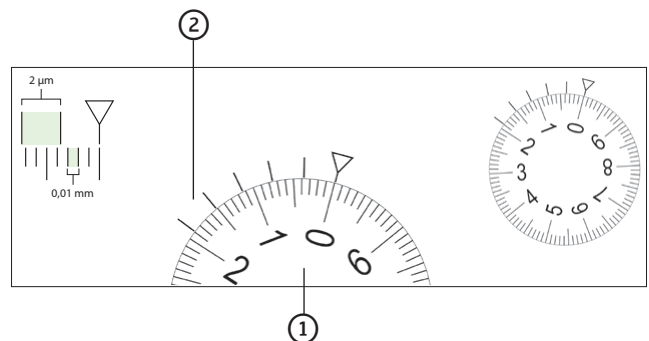
The disc is divided into ten equal sections.

This means that turning the disc from 0 to 1 = 0.1 mm.

▽ is the "zero position".

The vernier scale ② is divided into five equal sections.

The distance between **one scale line on the vernier scale corresponds to 0.002 mm** in terms of the diameter



### General information

Note the path restriction of the base body. Never use force when performing adjustments. Periodical lubrication (approx. every 20 operating hours) via the lubricating nipple (face of base body) guarantees extremely high precision coupled with a long service life.

We recommend using a light machine oil such as Mobil Vactra Oil No. 2, BP Energol HLP-32, Klueber Isoflex PDP 94.