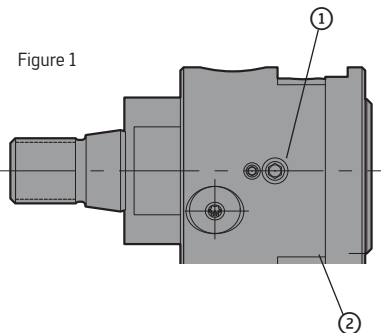


Setting instructions for the Walter Precision^{DIGITAL} B4035

B2

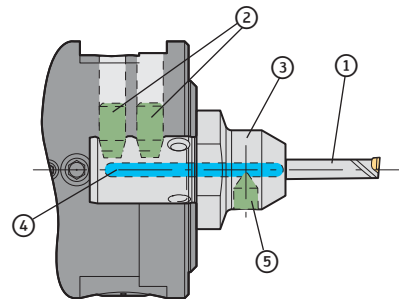
Clamping/diameter adjustment

1. Switch on the digital display by pressing the "ON/Reset" button.
2. Undo the locking screw ①.
3. Adjust the boring range via the adjusting screw ② using an Allen key (SW4), and read off the display at the same time.
Display = actual adjusting distance
+ = diameter increase
- = diameter reduction
4. Tighten the locking screw ①.



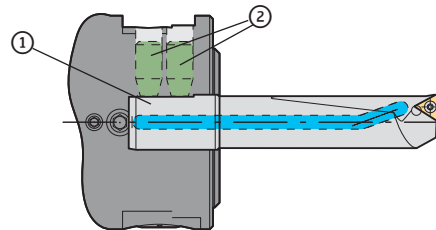
Mini boring tools, dia. 3–10 mm

1. Insert the adaptor ③ into the hole in the slide and secure with the two tapered threaded pins ②.
2. Insert a mini insert holder ① with a diameter of up to 14.7 mm into the adaptor.
3. Align the cutting position via the surface ④ at the end of the shank.
4. Clamp the mini insert holder using the tapered threaded pin ⑤ (4 Nm).
5. Diameter adjustment in accordance with figure 1.



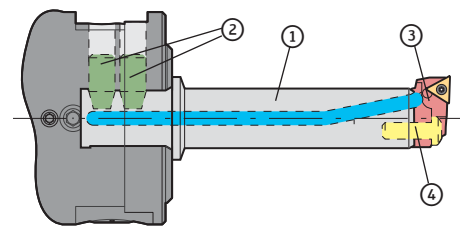
Boring bar dia. 20–32 mm

1. Clamp the boring bar ① in the body with the two fastening screws ②.
2. Diameter adjustment in accordance with figure 1.



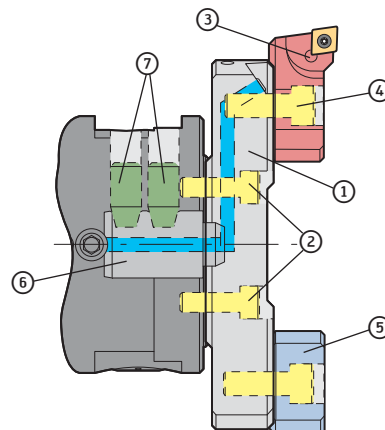
Extension and cartridges dia. 32–68 mm

1. Secure extension ① in the slide with the two tapered threaded pins ②.
2. Place the cartridge ③ in the teeth of the extension and clamp with the screw ④ (8 Nm).
3. Preset the cartridge ③ to diameter on the scale.
4. Diameter adjustment in accordance with figure 1.



Bridges with cooling lubricant transfer piece Cartridges for unscrewing and counterweight dia. 68–124 mm

1. Insert the coolant transfer piece ⑥ into the locating bore in the slide and secure with the two tapered threaded pins ⑦.
2. Secure the bridge ① to the slider (8 Nm) with four fastening screws ②.
3. Place the cartridge ③ on the bridge (near the coolant outlet).
4. Roughly preset the cartridge to the required diameter using the scale. Tighten with the clamping screw ④ (8 Nm).
5. Fit the counterweight ⑤ on the opposite side, align to diameter using the scale, and secure.
6. Diameter adjustment in accordance with figure 1.



Detailed operating instructions including notes on balancing compensation are included with the tool set.