BIG DAISHOWA KAISER BORING SYSTEM

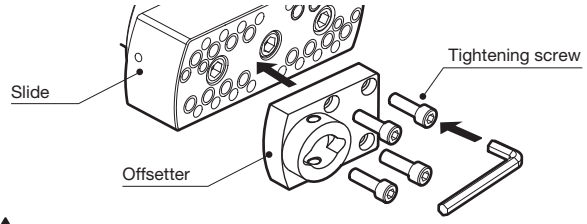
PIN TURNING SERIES *L-type*

OPERATION MANUAL

Please read these instructions before use and keep them where the operator may refer to them whenever necessary.

MOUNTING METHOD

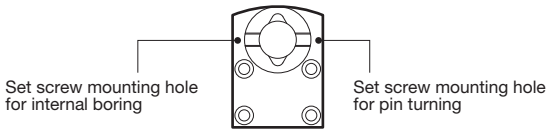
① Check that the slide and offsetter mounting surfaces are free of debris and scratches, and fix the slide with 4 screws so that the offsetter outer periphery curve faces outward. (Tightening torque 17N・m (12.5 lbf・Ft))



CAUTION

When mounting the offsetter on the slide, pay attention to the mounting position. The diameter range will change depending on the mounting position. (Use the same mounting position for both the EWN HEAD and the balance weight.) Also, as the diameter differs from the one engraved on the slide, refer to the table below and check with a presetter, etc.

② Mount the EWN HEAD and the balance weight on the offsetter and clamp securely with a set screw.



Offsetter (EWN HEAD insertion surface)

CAUTION

The offsetter has two set screw mounting hole locations to enable use for internal machining as well. When mounting the EWN HEAD, use the set screw mounting hole suited to the machining direction. One set screw, for both pin turning and internal boring, is included.

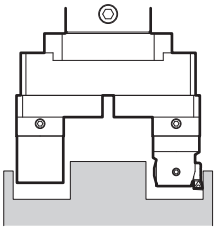
③ Using the EWN HEAD graduations, adjust the diameter. For EWN HEAD operation, refer to the EWN HEAD operation manual.

CAUTION

Reverse is used for pin turning. Pay careful attention to the rotation direction during machining.

<Internal boring>

Internal boring can be done by changing the EWN HEAD mounting orientation.



DIAMETER RANGE

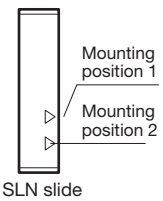
Diameter øD	Slide model	Mounting position	Insert holder			Max. spindle speed (RPM)
			ENH5-3	ENH5-2	ENH5-1	
1.929-4.961	SLN200-270	1	1.929- 2.598	2.441- 3.110	2.913- 3.583	1,600
		2	3.307- 3.976	3.819- 4.488	4.291- 4.961	
4.685-7.717	SLN270-340	1	4.685- 5.354	5.197- 5.866	5.669- 6.339	1,200
		2	6.063- 6.732	6.575- 7.244	7.047- 7.717	
7.441-10.472	SLN340-410	1	7.441- 8.110	7.953- 8.622	8.425- 9.094	900
		2	8.819- 9.488	9.331-10.000	9.803-10.472	
10.197-13.228	SLN410-480	1	10.197-10.866	10.709-11.378	11.181-11.850	750
		2	11.575-12.244	12.087-12.756	12.559-13.228	
12.953-15.984	SLN480-550	1	12.953-13.622	13.465-14.134	13.937-14.606	650
		2	14.331-15.000	14.843-15.512	15.315-15.984	
15.709-18.740	SLN550-620	1	15.709-16.378	16.220-16.890	16.693-17.362	600
		2	17.087-17.756	17.598-18.268	18.071-18.740	
18.465-21.496	SLN620-690	1	18.465-19.134	18.976-19.646	19.449-20.118	500
		2	19.843-20.512	20.354-21.024	20.827-21.496	
21.220-24.252	SLN690-760	1	21.220-21.890	21.732-22.402	22.205-22.874	450
		2	22.598-23.268	23.110-23.780	23.583-24.252	
23.976-27.008	SLN760-830	1	23.976-24.646	24.488-25.157	24.961-25.630	400
		2	25.354-26.024	25.866-26.535	26.339-27.008	

***The maximum spindle speed is the value with balance weight mounted.**

CAUTION

- **NEVER exceed the maximum allowable spindle speed.**
- The maximum allowable spindle speed is the limit value in terms of safety based on the tool structure; machining at this maximum spindle speed is not guaranteed.
- The rigidity of the machine spindle and workpiece, as well as the length of the boring tool,etc., influence the cutting conditions. Therefore, when setting the actual cutting conditions, please increase the rotation speed gradually starting from the general cutting conditions, while confirming safety.
- Check before actual rotation that all the screws are securely tightened.

CAUTION



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