BIG DAISHOWA KAISER BORING SYSTEM

PIN TURNING SERIES M-type

OPERATION MANUAL

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

MOUNTING METHOD

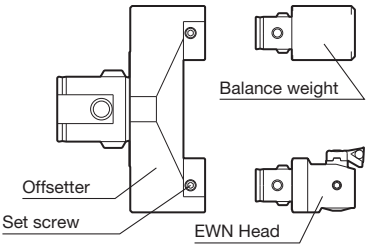
① Insert the EWN HEAD and balance weight into the offsetter. Here, check that each joint part is free of debris or scratches.

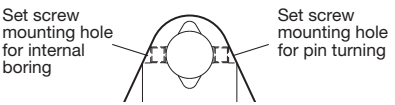
⚠ CAUTION

- **Reverse is used for pin turning. Pay careful attention to the rotation direction during machining.**
- For the EWN HEAD, refer to the operation manual included therewith.

⚠ Precautions for EWN HEAD mounting

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





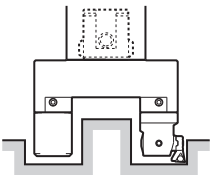
Offsetter (EWN HEAD insertion surface)

② Fully tighten the set screw and clamp firmly.

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

<Internal boring>

Internal boring can be done by changing the EWN HEAD mounting orientation.
See "Precautions for EWN HEAD mounting" in ①.



⚠ CAUTION

Forward is used for internal boring. Pay careful attention to the rotation direction.

MAXIMUM ALLOWABLE SPINDLE SPEED

Offsetter model	Max. spindle speed (RPM)
CKB63-SL2552-42	3,000
CKB63-SL5077-42	2,000
CKB63-SL75102-42	1,500
CKB73-SL100127-47	1,200
CKB73-SL125152-47	1,000

⚠ CAUTION

- **NEVER exceed the maximum allowable spindle speed.**
- The maximum allowable spindle speed is the limit value in terms of safety based on the offsetter 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.

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No.0625