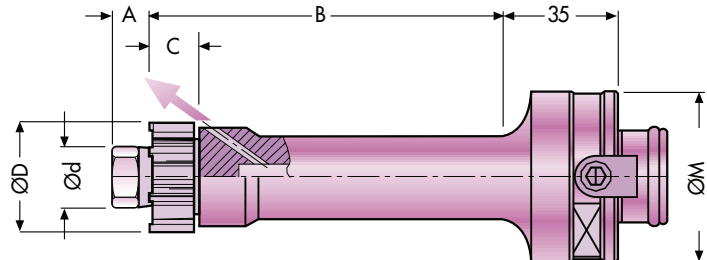


Modular Composit shank — SHORT SERIES

Brazed carbide (from diam. 17,60 to 200,59 mm)

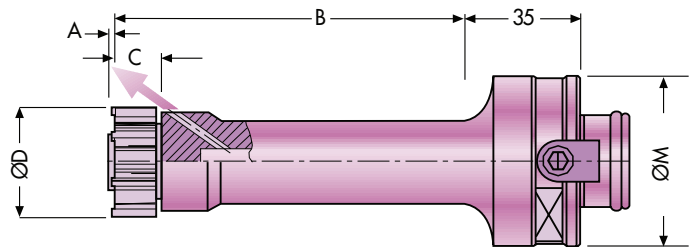
Series 4350

- through holes with
radial through tool coolant
Ø 17,60 ÷ 200,59 mm



Series 4355

- blind holes with
radial through tool coolant
Ø 17,60 ÷ 100,59 mm

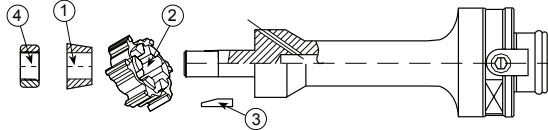


Expanding reamers
with adjustment
in front of the cutting ring

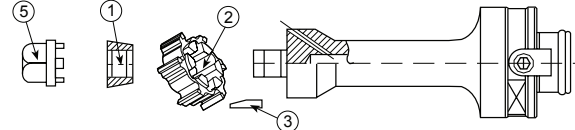
ØD mm	Series 4355		Series 4350		B mm	C mm	Modular shank ØM	Number of teeth
	A mm	Ød mm	A mm	A mm				
17,60 - 21,59	1	12	11	81	11	50	6	
21,60 - 25,59	1	12	11	81	12	50	6	
25,60 - 32,59	1	15,6	11	102	14	50	6	
32,60 - 40,59	1	22	14	102	16	50	6	
40,60 - 45,59	1	25,4	15	102	16	50	6	
45,60 - 60,59	1,5	30	20,5	105	18,5	50	6	
60,60 - 79,59	1,5	40	24,5	105	18,5	63	6	
79,60 - 100,59	1,5	56	28,5	105	18,5	63	8	
100,60 - 110,59	-	73,8	35,5	105	18,5	80	10	
110,60 - 115,59	-	80,8	35,5	105	18,5	80	12	
115,60 - 125,59	-	86,8	35,5	105	18,5	80	12	
125,60 - 139,59	-	90,8	35,5	105	18,5	80	12	
139,60 - 145,59	-	102,8	35,5	105	18,5	80	12	
145,60 - 155,59	-	107,8	35,5	105	18,5	80	12	
155,60 - 165,59	-	107,8	48,5	105	18,5	80	12	
165,60 - 175,59	-	117,8	48,5	105	18,5	80	12	
175,60 - 185,59	-	127,8	48,5	105	18,5	80	12	
185,60 - 195,59	-	137,8	48,5	105	18,5	80	12	
195,60 - 200,59	-	145,8	48,5	105	18,5	80	12	

SPARE PARTS

Series 4350 - Ø 17,60 ÷ 200,59



Series 4355 - Ø 17,60 ÷ 100,59



ØD mm	Series 4350			Series 4355					Series 4350 4355	
	Complete mandrel without cutting ring	Conical ring 1	Ring nut or nut 4	Complete mandrel without cutting ring	key 5	Conical ring 1	Conical ring second expansion	Conical ring third expansion	Drive pin 2000 - CO 3	
17,60 - 21,59	4350-MC-010	2010-AC-010	2000-DA-010	4355-MC-010	4001-CH-015	4001-AC-115	4001-AC-215	-	010	010
21,60 - 25,59	4350-MC-020	2010-AC-010	2000-DA-010	4355-MC-020	4001-CH-015	4001-AC-115	4001-AC-215	-	020	020
25,60 - 29,59	4350-MC-030	2010-AC-020	2000-DA-020	4355-MC-030	4001-CH-025	4001-AC-125	4001-AC-225	4001-AC-325	030	030
29,60 - 32,59	4350-MC-030	2010-AC-020	2000-DA-020	4355-MC-035	4001-CH-025	4001-AC-125	4001-AC-225	4001-AC-325	030	040
32,60 - 36,59	4350-MC-040	2010-AC-030	2000-DA-060	4355-MC-040	4001-CH-035	4001-AC-135	4001-AC-235	4001-AC-335	040	040
36,60 - 40,59	4350-MC-040	2010-AC-030	2000-DA-060	4355-MC-045	4001-CH-035	4001-AC-135	4001-AC-235	4001-AC-335	040	050
40,60 - 45,59	4350-MC-050	2010-AC-040	2000-DA-090	4355-MC-050	4001-CH-045	4001-AC-145	4001-AC-245	4001-AC-345	060	060
45,60 - 49,59	4350-MC-060	2010-AC-050	2000-GH-880	4355-MC-060	4001-CH-055	4001-AC-155	4001-AC-255	4001-AC-355	060	060
49,60 - 55,59	4350-MC-070	2010-AC-050	2000-GH-880	4355-MC-070	4001-CH-055	4001-AC-155	4001-AC-255	4001-AC-355	070	070
55,60 - 60,59	4350-MC-070	2010-AC-050	2000-GH-880	4355-MC-075	4001-CH-055	4001-AC-155	4001-AC-255	4001-AC-355	070	080
60,60 - 65,59	4350-MC-080	2010-AC-060	2000-GH-900	4355-MC-080	4001-CH-065	4001-AC-165	4001-AC-265	4001-AC-365	080	080
65,60 - 70,59	4350-MC-080	2010-AC-060	2000-GH-900	4355-MC-085	4001-CH-065	4001-AC-165	4001-AC-265	4001-AC-365	080	090
70,60 - 79,59	4350-MC-090	2010-AC-060	2000-GH-900	4355-MC-090	4001-CH-065	4001-AC-165	4001-AC-265	4001-AC-365	090	090
79,60 - 90,59	4350-MC-100	2010-AC-070	2000-GH-920	4355-MC-100	4001-CH-085	4001-AC-185	4001-AC-285	4001-AC-385	090	090
90,60 - 100,59	4350-MC-110	2010-AC-070	2000-GH-920	4355-MC-110	4001-CH-085	4001-AC-185	4001-AC-285	4001-AC-385	090	090
100,60 - 110,59	4350-MC-120	2060-BU-010	2000-GH-095	-	-	-	-	-	090	-
110,60 - 115,59	4350-MC-130	2060-BU-020	2000-GH-095	-	-	-	-	-	090	-
115,60 - 120,59	4350-MC-140	2060-BU-030	2000-GH-095	-	-	-	-	-	090	-
120,60 - 125,59	4350-MC-150	2060-BU-030	2000-GH-095	-	-	-	-	-	090	-
125,60 - 132,59	4350-MC-160	2060-BU-040	2000-GH-095	-	-	-	-	-	100	-
132,60 - 139,59	4350-MC-170	2060-BU-040	2000-GH-095	-	-	-	-	-	100	-
139,60 - 145,59	4350-MC-180	2060-BU-050	2000-GH-095	-	-	-	-	-	100	-
145,60 - 155,59	4350-MC-190	2060-BU-060	2000-GH-095	-	-	-	-	-	110	-
155,60 - 165,59	4350-MC-200	2060-BU-070	2000-GH-120	-	-	-	-	-	110	-
165,60 - 175,59	4350-MC-210	2060-BU-080	2000-GH-120	-	-	-	-	-	110	-
175,60 - 185,59	4350-MC-220	2060-BU-090	2000-GH-120	-	-	-	-	-	120	-
185,60 - 195,59	4350-MC-230	2060-BU-100	2000-GH-120	-	-	-	-	-	120	-
195,60 - 200,59	4350-MC-240	2060-BU-110	2000-GH-120	-	-	-	-	-	120	-

② Cutting ring

Hard metal brazed carbide (our ref. H.M.)

MATERIAL TO WORK	N / mm ²	Reamer Ø mm	STOCK ALLOWANCE Ø mm	SURFACE SPEED m / min	FEED mm / rev	LUBRICANT
Mild Steel Unalloyed Low alloyed	Up to 600	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,25 0,20 - 0,40 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	7 - 15	0,15 - 0,30 0,25 - 0,50 0,30 - 0,80 0,60 - 1,00 0,60 - 1,20 0,80 - 1,50	Emulsible oil Cutting oil
Structural steel Fused Metal		Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,25 0,20 - 0,30 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50		6 - 10	
Alloy steel Stainless steel	400 - 1000	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,25 0,20 - 0,30 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	4 - 8		0,10 - 0,30 0,20 - 0,40 0,30 - 0,60 0,40 - 0,80 0,50 - 0,90 0,60 - 1,20
Strongly alloy steel Steel with manganese		800 - 1500	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100		0,10 - 0,20 0,15 - 0,25 0,20 - 0,30 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	3 - 6
Grey cast iron Spheroidal cast iron (pearlitic) Malleable cast iron	Up to 200HB Greater than 200 HB		Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,30 0,30 - 0,40 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	≤ 200 HB 15 - 30 > 200 HB 10 - 20	
Spheroidal cast iron (ferritic)	300 - 700	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,25 0,20 - 0,30 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	8 - 12	0,15 - 0,30 0,40 - 0,60 0,50 - 1,00 0,75 - 1,50 0,80 - 1,60 1,00 - 1,80	Emulsible oil Cutting oil
Copper and alloys Brass	Up to 500	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,25 0,15 - 0,25 0,25 - 0,40 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	10 - 18	0,15 - 0,40 0,20 - 0,60 0,25 - 0,90 0,40 - 1,10 0,50 - 1,20 0,60 - 1,50	Emulsible oil
Bronze Bronze phosphorous		Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,25 0,15 - 0,25 0,25 - 0,40 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50		10 - 20	
Aluminium and light alloys	Up to 500	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,2 0,15 - 0,3 0,20 - 0,4 0,30 - 0,4 0,35 - 0,5 0,40 - 0,5	15 - 30		0,20 - 0,40 0,30 - 0,60 0,40 - 1,00 0,75 - 1,50 0,80 - 1,60 0,90 - 1,80
Titanium and alloys		Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,25 0,20 - 0,30 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50		5 - 8	0,15 - 0,30 0,20 - 0,40 0,30 - 0,50 0,40 - 0,60 0,60 - 0,80 0,80 - 1,20
Syntetic materials	Up to 500	Up to 10 10 - 22 22 - 40 40 - 50 50 - 70 70 - 100	0,10 - 0,20 0,15 - 0,25 0,20 - 0,30 0,30 - 0,40 0,35 - 0,50 0,40 - 0,50	15 - 30		0,20 - 0,50 0,40 - 0,80 0,50 - 1,40 0,80 - 1,50 0,90 - 1,60 1,00 - 1,80

TECHNICAL INFORMATION AND CUTTING PARAMETERS HIGH SPEED & HIGH FEED REAMING

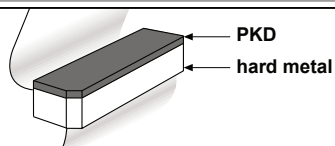
Hard metal brazed carbide coated TiN - TiCN - TiAlN (our ref. TIN - TIC - TIA)
Cermet brazed carbide (our ref. AVC)

*AVC reamers are available coated TiN, TiCN or TiAlN

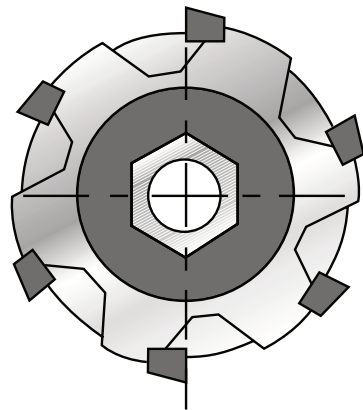
MATERIAL TO WORK	N / mm ²	Reamer Ø mm	STOCK ALLOWANCE Ø mm	H.M. coated TiN - TiCN TiAlN	CERMET AVC *	Lead-in A,G	Lead-in E,N,M
				SURFACE SPEED m / min	SURFACE SPEED m / min	FEED mm / rev	FEED mm / rev
Mild Steel Unalloyed Low alloyed	Up to 600	up to 10	0,08 - 0,15	60 - 80	90 - 300	0,20 - 0,40	0,30 - 0,60
		10 - 18	0,15 - 0,25			0,40 - 0,60	0,40 - 1,00
Structural steel Fused Metal	Greater than 600	18 - 40	0,15 - 0,30	40 - 70	80 - 200	0,50 - 0,80	0,60 - 1,20
		40 - 80	0,20 - 0,40			0,50 - 1,00	0,80 - 1,60
Alloy steel Stainless steel	400 - 1000	over 80	0,25 - 0,50	30 - 50	60 - 150	0,80 - 1,50	1,00 - 2,20
		up to 10	0,08 - 0,15			0,20 - 0,40	0,30 - 0,50
Strongly alloy steel Steel with manganese	800 - 1500	10 - 18	0,15 - 0,25	15 - 30	60 - 120	0,30 - 0,60	0,30 - 0,80
		18 - 40	0,15 - 0,30			0,40 - 0,70	0,40 - 1,00
Grey cast iron Spheroidal cast iron (pearlitic) Malleable cast iron	Up to 200HB Greater than 200 HB	40 - 80	0,20 - 0,40	50 - 70		0,50 - 0,80	0,60 - 1,40
		over 80	0,25 - 0,50			0,80 - 1,20	1,00 - 2,00
Spheroidal cast iron (ferritic)	300 - 700	up to 10	0,08 - 0,15	30 - 50	60 - 120	0,20 - 0,40	0,30 - 0,60
		10 - 18	0,15 - 0,25			0,35 - 0,60	0,50 - 0,80
Copper and alloys Brass	Up to 500	18 - 40	0,15 - 0,30	100 - 200		0,40 - 1,00	0,60 - 1,50
		40 - 80	0,20 - 0,40			0,60 - 1,30	0,80 - 1,60
Bronze Bronze phosphorous	Up to 600	over 80	0,25 - 0,50	80 - 160	100 - 300	0,80 - 1,70	1,00 - 2,25
		up to 10	0,08 - 0,15			0,20 - 0,40	
Alluminium and light alloys	Up to 500	10 - 18	0,15 - 0,25	100 - 200		0,40 - 0,70	
		18 - 40	0,15 - 0,30			0,50 - 0,80	
Titanium and alloys		40 - 80	0,20 - 0,40	20-60		0,60 - 1,00	
		over 80	0,30 - 0,50			0,80 - 1,40	

HIGH SPEED FOR ALUMINIUM REAMING

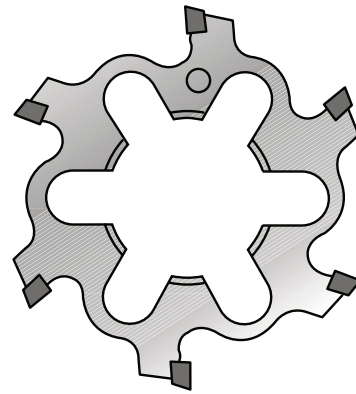
Aluminium with silicon greater than 10% - brazed carbide with PKD



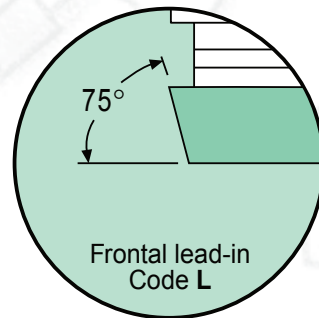
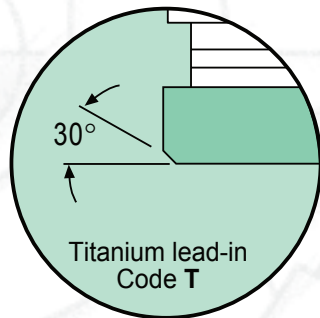
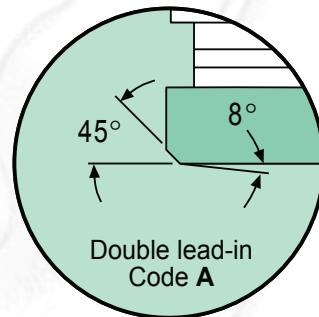
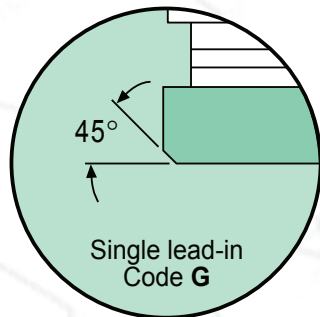
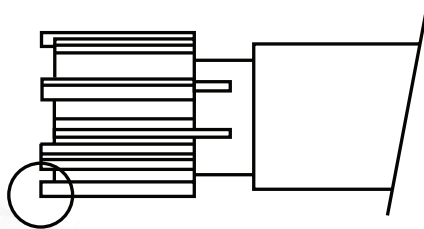
- Surface speed up to 1500 m/min.
- When using PKD reamers a machine tool with high rigidity and absolute precision is a minimum requirement.
- Each application must be assessed by our technical department.



Integral expanding reamer

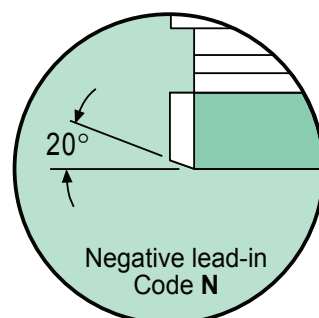
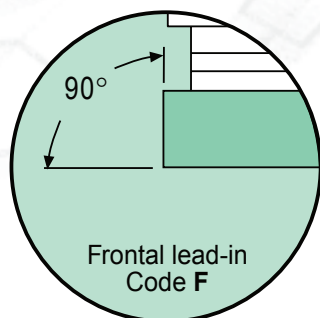


Cutting ring



"L" lead-in to reduce the feed of 40% compared with the values on pages 6-7

"F" lead-in to reduce the feed of 40% compared with the values on pages 6-7



"N" lead-in ideal for through hole. It is possible to increase the feed up to 100% of the values indicated on pages 6-7

Approach angles

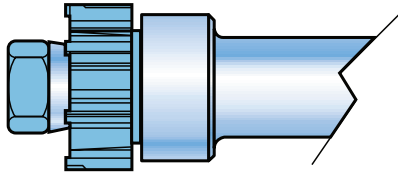
MATERIAL TO WORK	TENSILE STRENGTH	APPROACH ANGLE*
Iron and mild steel (C < 0,2%)	50 Kg / mm ²	G - A - E
Mild steel (C 0,2 < 0,3%)	60 Kg / mm ²	N - A - E
Mild steel (C 0,3 < 0,4%)	70 Kg / mm ²	N - A - E
Mild steel (C 0,4 < 0,5%)	80 Kg / mm ²	N - A - E
Alloy steel	≤ 80 Kg / mm ²	G - N - A - E
Alloy steel	90 Kg / mm ²	G - N - E
Alloy steel	100 Kg / mm ²	G - N - M
Alloy steel	> 100 Kg / mm ²	G - N - M
Stainless and refractory steel	from 50 Kg / mm ² to 90 Kg / mm ²	G - N - M
Grey, spheroidal and malleable cast iron	from 150 HB to 320 HB	G - N - E
Titanium and titanium alloy		T - E
Tempered steel	48 - 64 HRc	G - N - M
Pure copper		G - N - E
Electrolytic copper		G - N - E
Brass / Bronze		G - N - E
Aluminium alloy < 10% Si		G - A - E
Aluminium alloy > 11% Si		G - E
Magnesium alloy		G - A - E
Thermoplastic material		G - E
Thermosetting resins		G - E
Stiffened synthetic material		G - E

* Do not use negative lead-in on blind holes

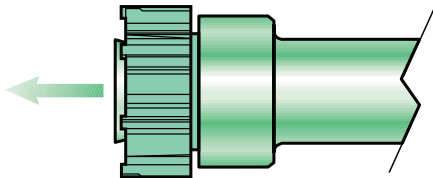
Negative lead-in "N" can be used on large range of materials: please apply to our technical department.

Usually ex-stock: - single lead-in G

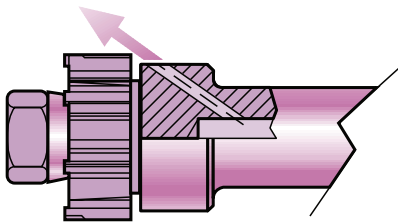
EXPANDING REAMERS WITH CUTTING RING



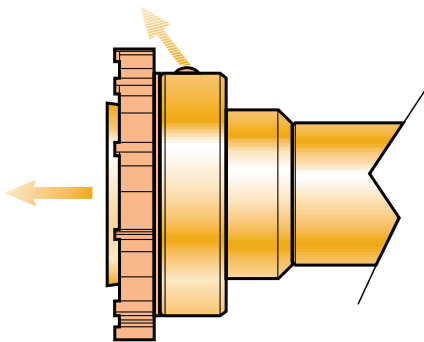
Expanding reamers without coolant



Expanding reamers with central through tool coolant (ideal application for blind holes)

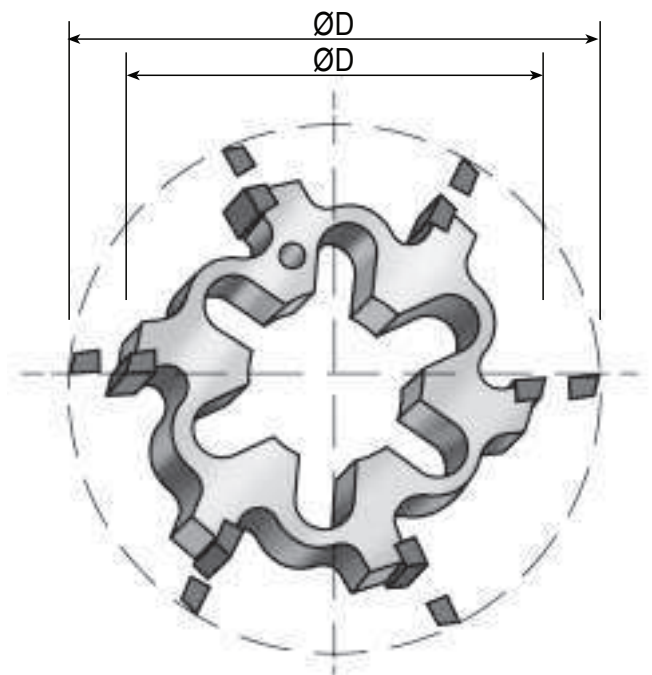
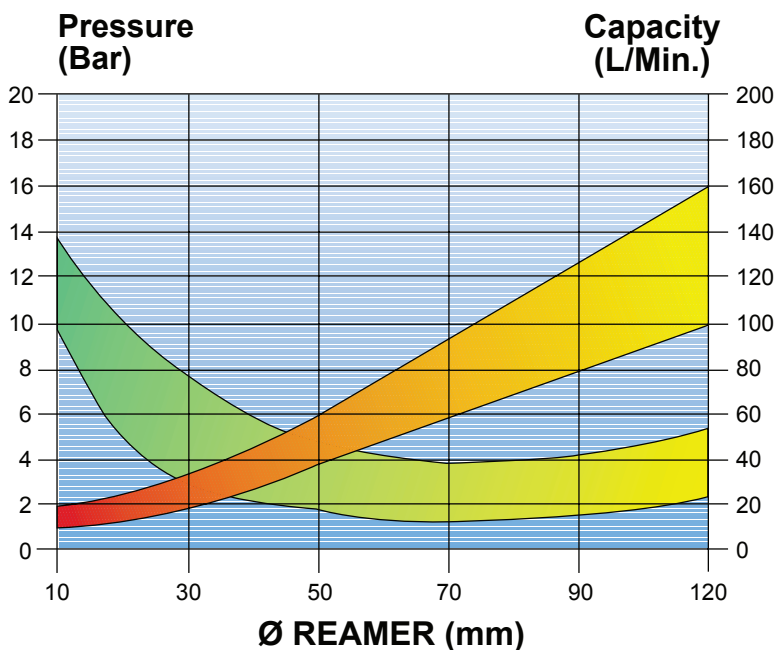


Expanding reamers with radial through tool coolant (ideal application for through holes)



Expanding reamers with central and radial through tool coolant

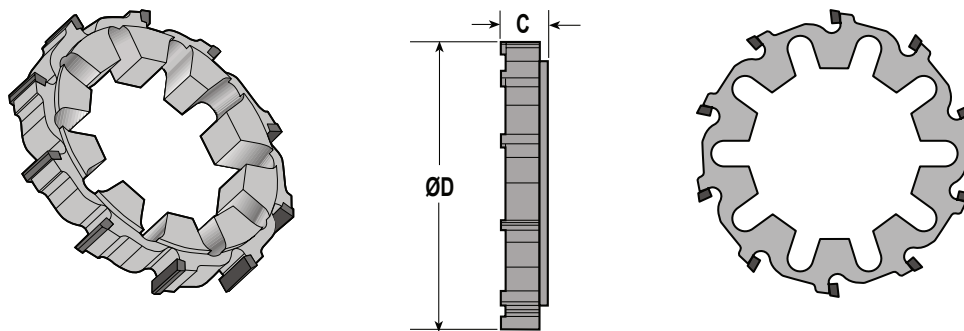
Recommended values for lubricants



The cutting rings can be expanded for recovering the starting diameter.

CUTTING RINGS

from diameter 17,60 to 200,59 mm



Ø D mm	C mm	Number of teeth
17,60 - 21,59	11	6
21,60 - 25,59	12	6
25,60 - 32,59	14	6
32,60 - 45,59	16	6
45,60 - 79,59	18,5	6
79,60 - 100,59	18,5	8
100,60 - 110,59	18,5	10
110,60 - 200,59	18,5	12

- The ALVAN® cutting rings are modular and compatible with all the reamers indicated on page 36 to 58.
- We guarantee a regrinding and re-brazing rapid service of the damaged cutting edges (consult our technical department).
- The cutting edges are in an asymmetric way to assure the best roundness of the hole (see page 74).
- Holes with restricted tolerances (ISO 5 and 6) can be supplied and the expansion assures a perfect holding of the reaming diameter.
- Lead-in: cutting rings with G lead-in are usually available from stock (see page 11-12-13).
- Diameters and tolerances: cutting rings of integer metric diameters with H7 tolerances are usually available from stock.
- The ALVAN® cutting rings are manufactured to the middle of the hole tolerance so they must be assembled and adjusted to the same diameter. It is important to comply with this direction in order to have a good working and life of the tool.
- LEFT HAND HELICAL FLUTES CUTTING RINGS from diameter 32,60 to 200,59 mm. ON REQUEST.

EXPANDING & FIXED REAMERS INSTRUCTIONS

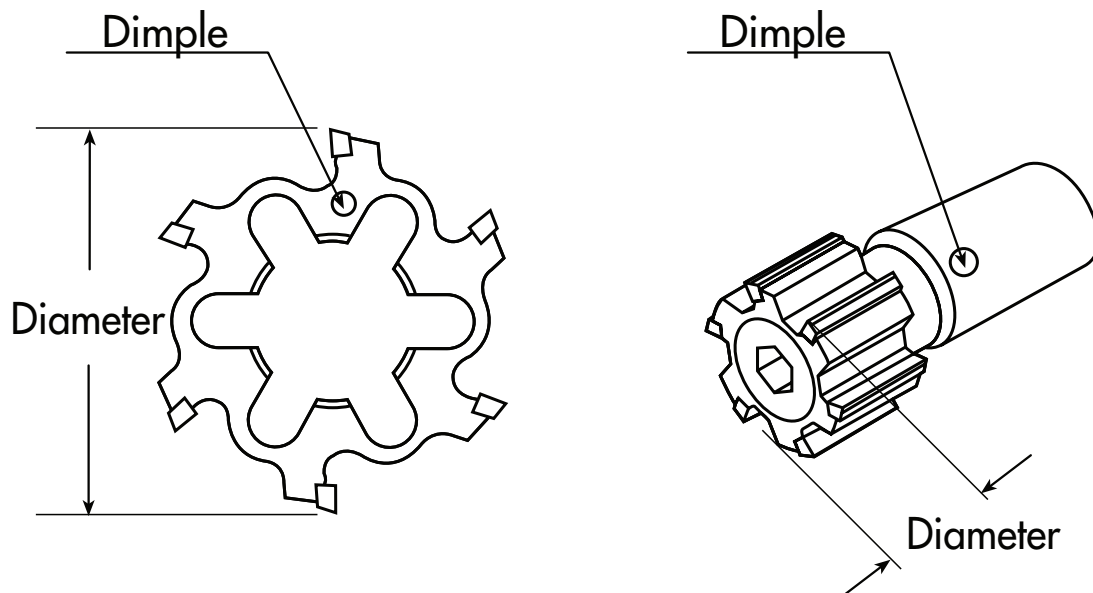
1) Diameter measurement

The diameter of the reamers and of the cutting rings is measured with a micrometer. We recommend the use of a comparator style micrometer with at least a $2\mu\text{m}$ resolution to avoid micro chipping of the cutting edges.

To allow setting of the reamer, two cutting edges are exactly 180° opposed. These are marked with a coloured dimple (see diagram below).

Measurement must be taken from the front of the cutting edges only.

The red dimple indicates that the tool has been ground with a single lead-in angle (code G), the blue dimple indicates a double lead-in angle (code A).



2) Tolerance

All the reamers are ground to the requested diameter and set to nominal tolerance for expanding reamers and $3/4$ of minimum tolerance for fixed reamers.

3) Expanding reamers adjustment

The adjustment must be made to compensate for wear to the cutting edges when the size reaches its lower tolerance.

This operation can be repeated several times until the surface finish of the hole deteriorates to an unacceptable level, then the reamer must be reground. The maximum expansion is about 1% of the diameter for the integral reamers and about 4% of the diameter for the cutting rings.

EXPANDING REAMERS INSTRUCTIONS

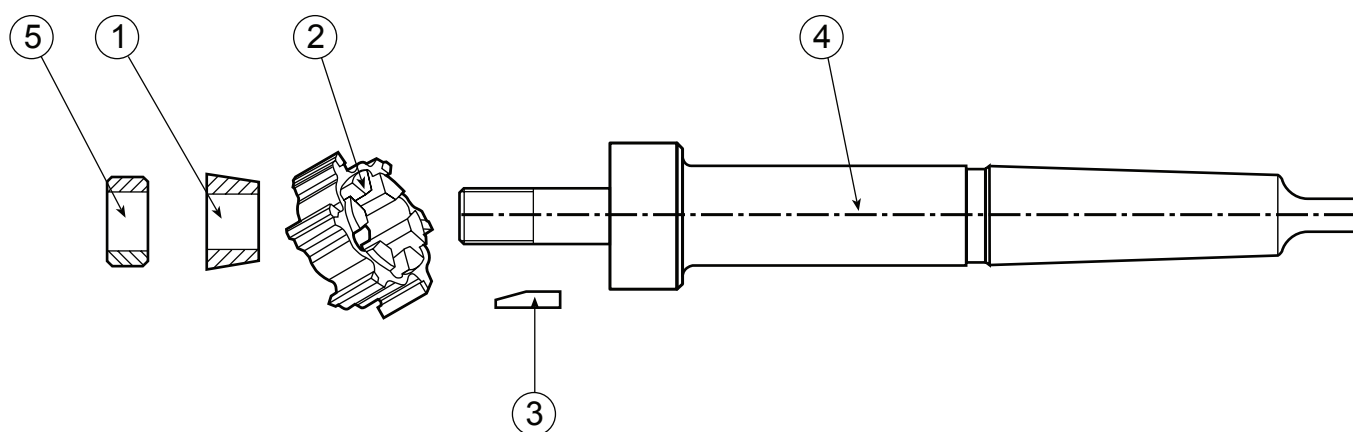
Assembly - Adjustment - Disassembly EXPANDING REAMERS WITH CUTTING RING with assembly and adjustment in the front

Series 2000-2010-2050 from diam. 17,60 to 100,59 mm

Series 4550-4500-4330 from diam. 17,60 to 100,59 mm

Series 4200-4250-4350 from diam. 17,60 to 200,59 mm

Series 4300 from diam. 17,60 to 60,59 mm



1) Assembly

Insert the cutting ring (item 2) on the mandrel (item 4) with the drive pins (item 3) assembled. Insert the conical ring (item 1). Screw the nut (item 5) and lock it manually: **the thread is left handed.**

We recommend lubricating the thread and the conical surface of contact between the cutting ring and the conical ring with antifriction Molycote grease.

2) Adjustment procedure

Turn the nut slowly, checking the diameter setting of the cutting ring with a micrometer, paying attention that the drive pins are in traction in the opposite direction to the cutting action of the reamer.

When the required diameter is achieved, the tool is ready for use.

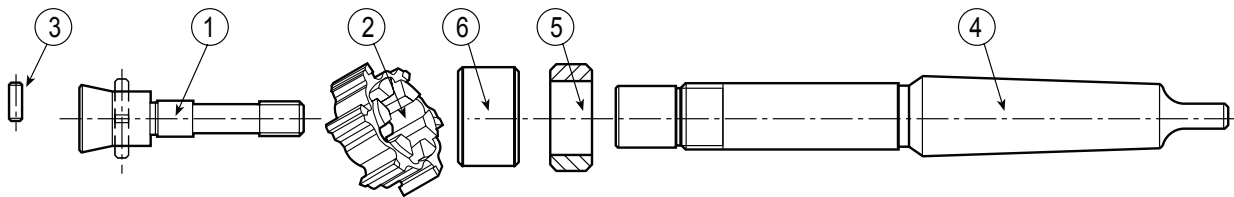
3) Disassembly

Unscrew the nut. Remove the components from the mandrel.

EXPANDING REAMERS INSTRUCTIONS

Assembly - Adjustment - Disassembly EXPANDING REAMERS WITH CUTTING RING with assembly and adjustment on the rear

**Series 2500 - 2505 - 2530 - 2535 - 2550 - 2555
from diam. 17,60 to 45,59 mm**



1) Assembly

Screw the nut (item 5) on the mandrel (item 4): **the thread is right handed**.
Insert the bush (item 6) on the mandrel.

Mount the cutting ring (item 2) onto the conical screw (item 1) and over the drive pins (item 3). Tighten the conical screw onto the mandrel, taking care that the contact surfaces are very clean. Look the screw to the torque setting stated in table 1. We recommend lubricating the thread and the conical surface of contact between the cutting ring and the conical ring with antifriction Molycote grease.

2) Adjustment procedure

Turn the nut slowly, checking the diameter setting of the cutting ring with a micrometer, paying attention that the drive pins are in tranction, in the opposite direction to the cutting action of the reamer. When the required diameter is achived, the tool is ready for use.

3) Disassembly

Loosen the nut and remove the screw. Remove the components from the mandrel.

**Use a dynamometric key to avoid
breaking the conical screw**

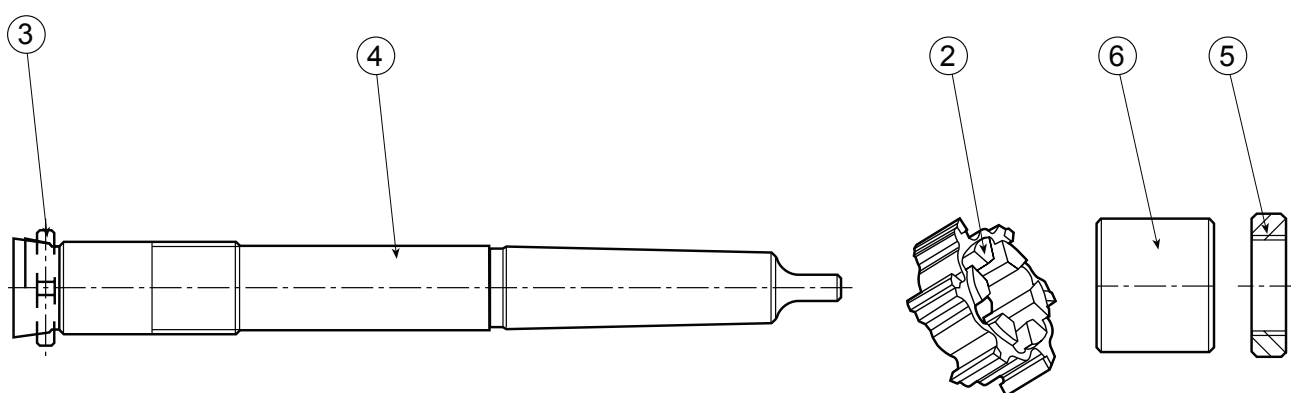
Diameter mm	Torque settings Kgm
18 - 25	1,4 - 1,6
26 - 32	2,2 - 2,5
33 - 40	3,6 - 4
41 - 45	4,6 - 5

table 1

EXPANDING REAMERS INSTRUCTIONS

Assembly - Adjustment - Disassembly EXPANDING REAMERS WITH CUTTING RING with assembly and adjustment on the rear

**Series 2500 - 2505 - 2530 - 2535 - 2550 - 2555
from diam. 45,60 to 100,59 mm**



1) Assembly

Mount the cutting ring (item 2) and the bush (item 6) onto the mandrel (item 4). Screw the ring nut (item 5) onto the mandrel and lock it manually: **the thread is right handed.**

We recommend lubricating the thread and the conical surface of contact between the cutting ring and the mandrel with antifriction Molycote grease.

2) Adjustment procedure

Turn the ring nut slowly, checking the diameter setting of the cutting ring with a micrometer, paying attention that the drive pins (item 3) are in traction in the opposite direction to the cutting action of the reamer.

When the required diameter is achieved, the tool is ready for use.

3) Disassembly

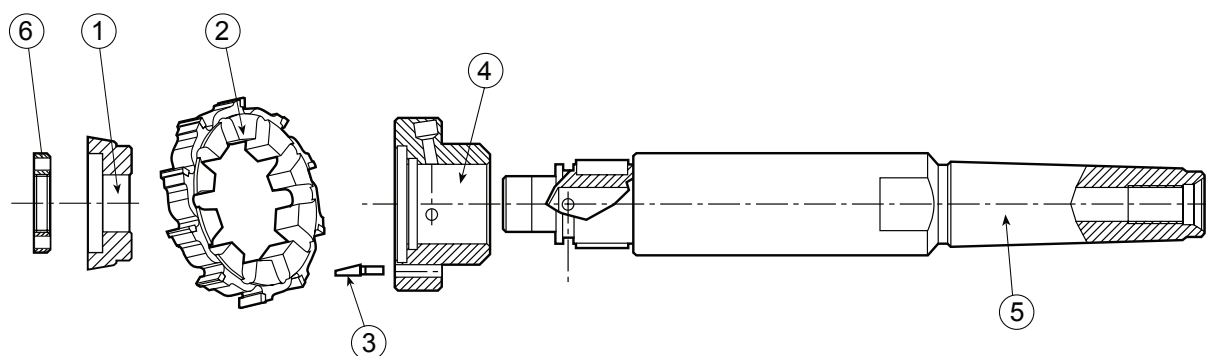
Unscrew the ring nut. Remove the components from the mandrel.

EXPANDING REAMERS INSTRUCTIONS

Assembly - Adjustment - Disassembly EXPANDING REAMERS WITH CUTTING RING with assembly and adjustment in the front

Series 4000 - 4050
from diam. 79,60 to 200,59 mm

Series 4100 - 4150
from diam. 79,60 to 200,59 mm



1) Assembly

With the drive pins (item 3) assembled, mount the flange (item 4) onto the mandrel (item 5). Assemble the cutting ring (item 2) so that the slot on the left side of the dimple is mounted onto the drive pins. Insert the conical ring (item 1). Screw the ring nut (item 6) onto the mandrel and tighten manually, so that the conical ring makes contact with the cutting ring: **the thread is left handed**. We recommend lubricating the thread and the conical surface of contact between the cutting ring and the conical ring with antifriction Molycote grease.

2) Adjustment procedure

Turn the ring nut slowly (using a pin spanner) checking the diameter setting of the cutting ring with a micrometer, paying attention that the drive pins are in traction, in the opposite direction to the cutting action of reamer. When the required diameter is achieved, the tool is ready for use.

3) Disassembly

Unscrew the ring nut. Remove the components from the mandrel.

EXPANDING REAMERS INSTRUCTIONS

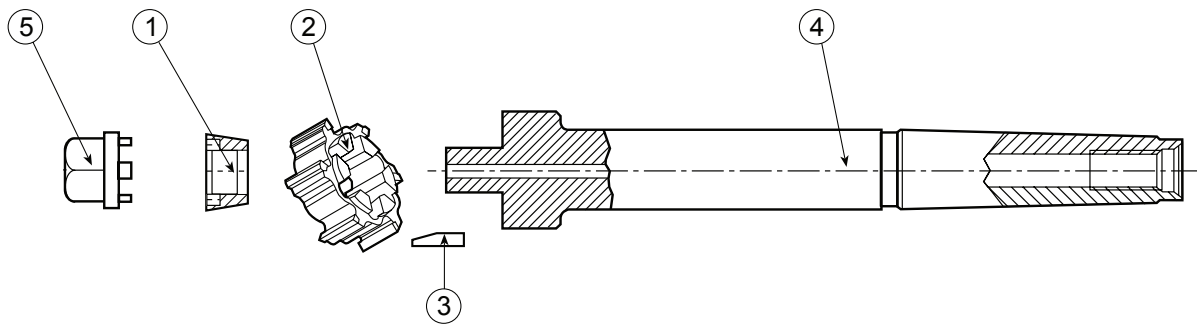
Assembly - Adjustment - Disassembly EXPANDING REAMERS WITH CUTTING RING with assembly and adjustment in the front

Series 2015 from diam. 17,60 to 100,59 mm

Series 4000 - 4050 from diam. 17,60 to 79,59 mm

Series 4355-4505-4555 from diam. 17,60 to 100,59 mm

Series 4305 from diam. 17,60 to 60,59 mm



1) Assembly

Mount the cutting ring (item 2) onto the mandrel (item 4) with the drive pins (item 3) assembled. Screw the conical ring nut onto the mandrel and lock it manually: **the thread is left handed.**

Lubricate the thread and the conical surface of contact between the cutting ring and the conical ring with antifriction Molycote grease.

2) Adjustment procedure

Turn the conical ring nut slowly using a pin spanner (item 5) supplied with reamers from diameter 17,60 to 40,59 mm, checking the diameter setting of the cutting ring with a micrometer. When the required diameter is achieved unscrew the conical ring until there is a click and the drive pins are in traction in the opposite direction to the cutting action of the reamer.

The reamer is ready for use.

3) Disassembly

Unscrew the conical ring nut. Remove the components from the mandrel.