

# Product note

## Presetting Adapter

for grooving slide

## **Note on applicability**

Illustrations in this publication may deviate from the product supplied. Errors and omissions due to technical progress expected.

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**Presetting adapter for grooving slide**

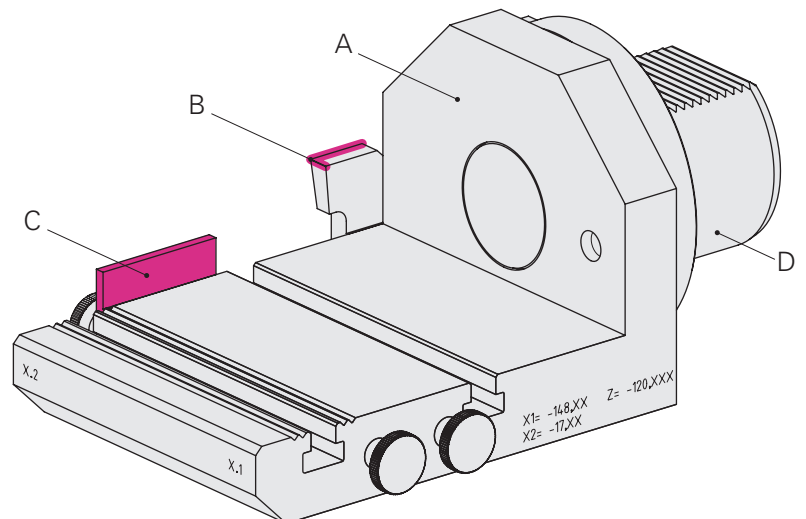
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## Presetting adapter for grooving slide

### Presetting adapter – design

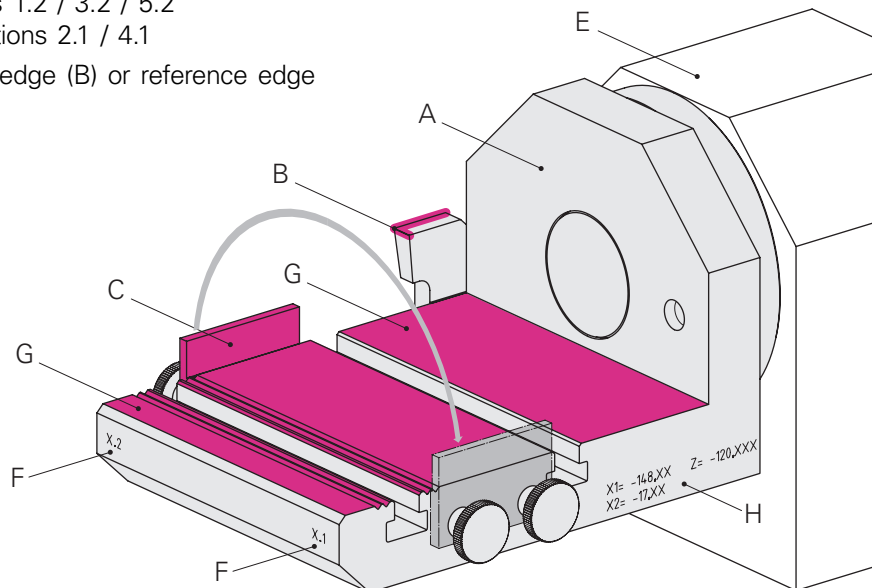
- Presetting adapter with mounting VDI 80 (D) is shown, instructions applicable also to presetting adapter with mounting SK50
- Presetting adapter (A) with W-serration and T-grooves for mounting the tool holders
- Calibration edge (B) and reference edge (to reset the presetting adapter to zero)
- Stop (C) must be modified according to the required position



## Presetting adapter for grooving slide

### Preparation – measuring

- Set up presetting adapter (A) on the measuring machine (E)
- Stop (C) must be mounted on the correct side, see engraving (F)  
Engraving X.2 for positions 1.2 / 3.2 / 5.2 (shown stop shown)  
Engraving X.1 for positions 2.1 / 4.1 (convert stop)
- Clean support surface and W-serration (G)
- Enter the engraved dimensions (H) into the control of the measuring machine (E)  
Reference value X2 and Z for positions 1.2 / 3.2 / 5.2  
Reference value X1 and Z for the positions 2.1 / 4.1
- Calibrate the adapter at the calibration edge (B) or reference edge

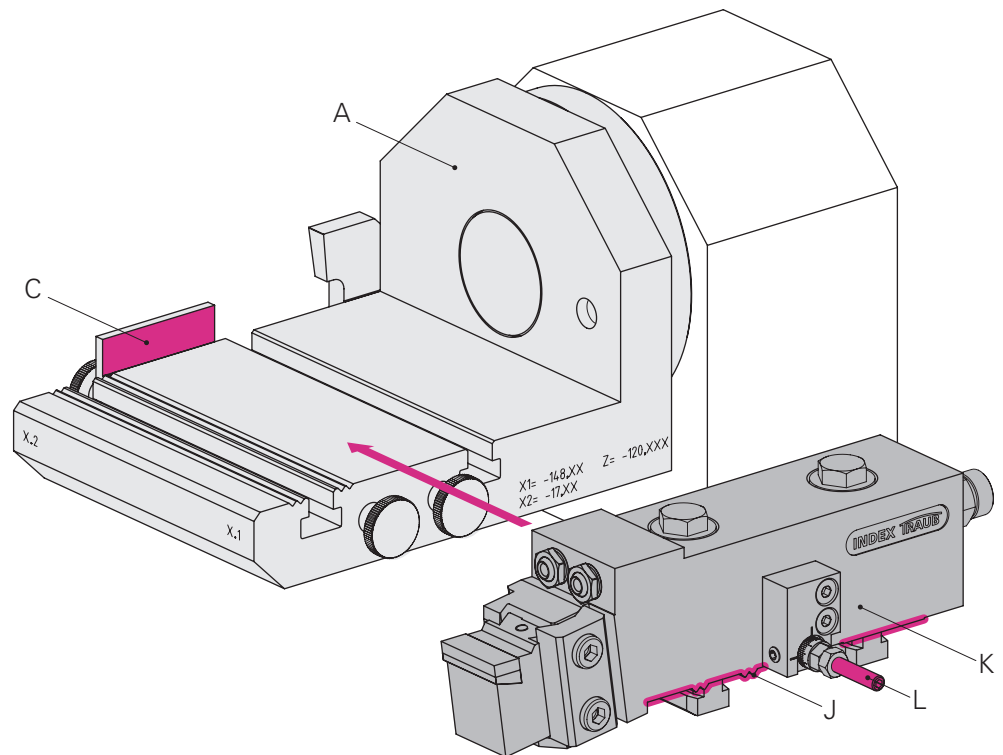


## Presetting adapter for grooving slide

The setup is shown in positions 1.2, 3.2, 5.2

### Installation - Grooving slide

- Clean support surface and W-serration (J)
- Slide tool holder (K) with the threaded rod (L) against the stop (C)



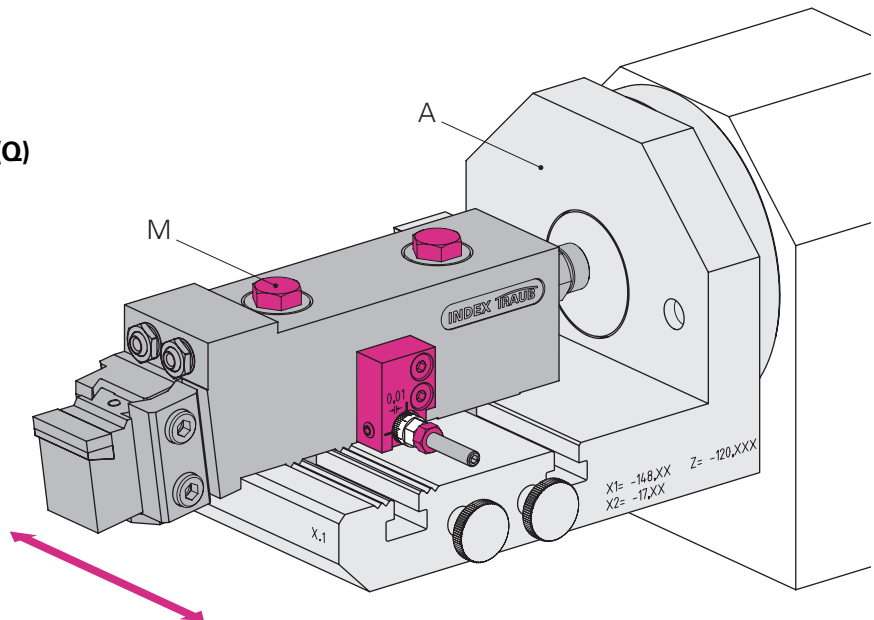
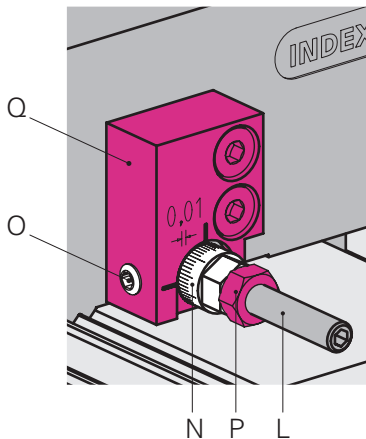
## Presetting adapter for grooving slide

The setup is shown in positions 1.2, 3.2, 5.2

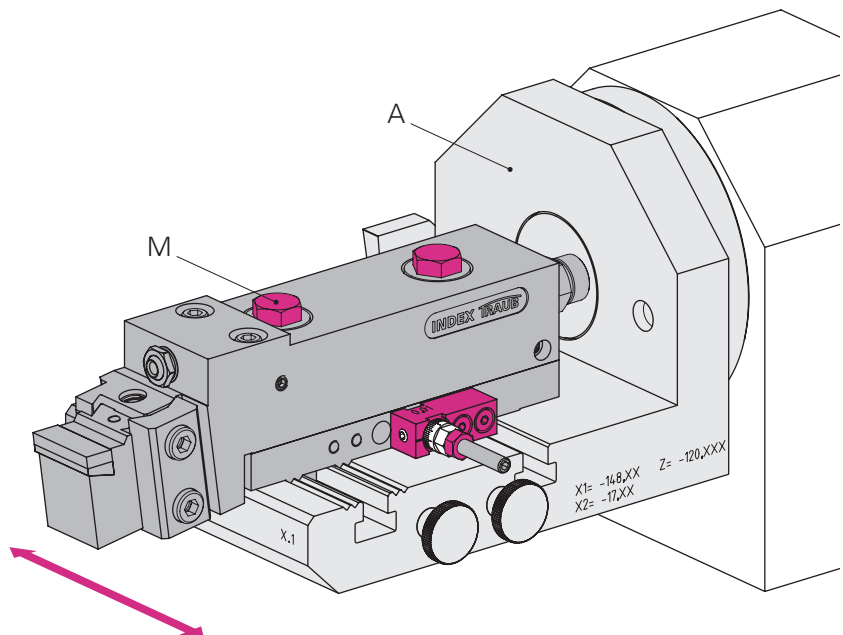
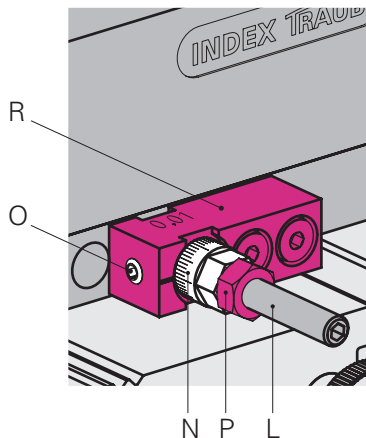
### Coarse adjustment of tool holder

- Install hexagon head screws (M) lightly (moving by hand should still be possible)
- Fix the vernier screw (N) with the clamping screw (O)
- Loosen the lock nut (P)
- Use the threaded rod (L) to coarsely adjust the Z value
- Tighten the lock nut (P) against the vernier screw (N)

### Tool holder with clamp, large version (Q)



### Tool holder with clamp, small version (R)



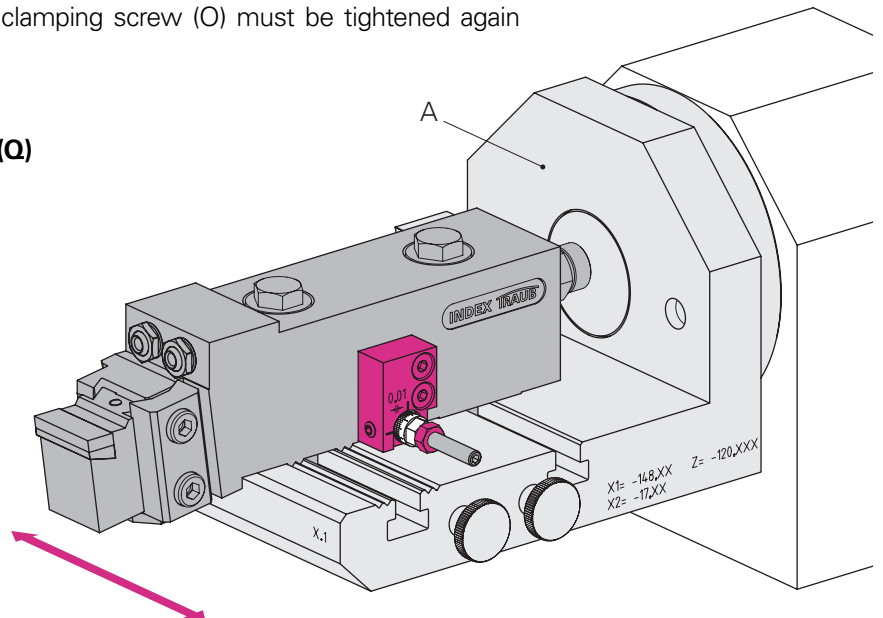
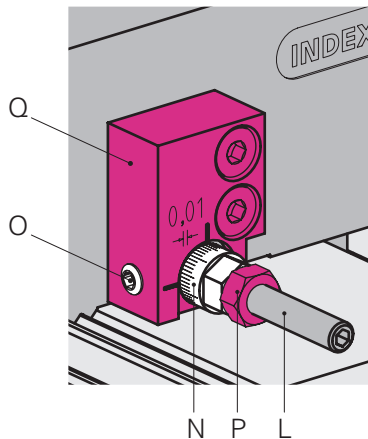
## Presetting adapter for grooving slide

The setup is shown in positions 1.2, 3.2, 5.2

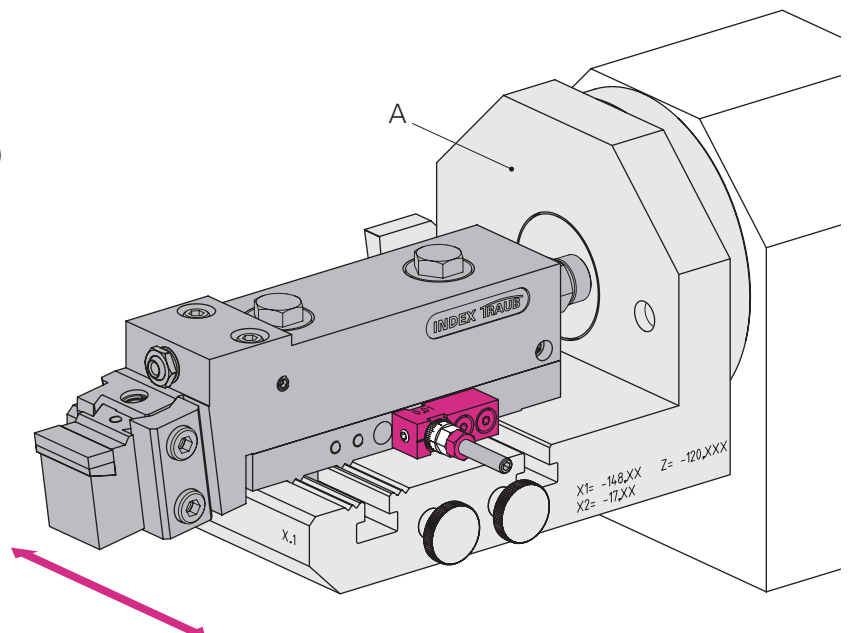
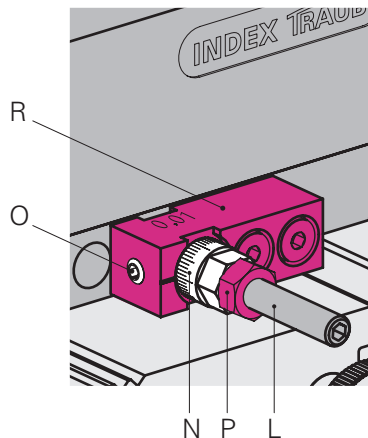
### Fine adjustment of tool holder

- Depending on the precision and application, the fine adjustment can be made in the machine or, as described here, on the presetting adapter (A). The coarse adjustment should already be done
- Loosen clamping screw (O)
- The fine adjustment is made by turning the vernier screw (N)
- The lock nut (P) of the threaded rod (L) must be tightened during this procedure
- One turn corresponds to 0.5 mm
- After the fine adjustment is done, the clamping screw (O) must be tightened again

### Tool holder with clamp, large version (Q)



### Tool holder with clamp, small version (R)



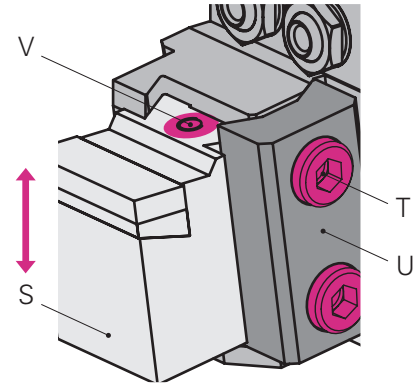
## Presetting adapter for grooving slide

The setup is shown in positions 1.2, 3.2, 5.2

### Center height adjustment of tool holder

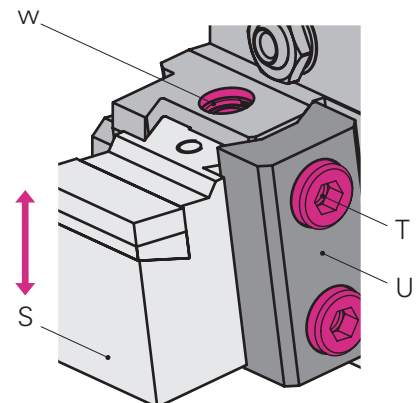
#### Tool holders 10667537, 10897521, 11049283, 10399363

- Grooving insert (S) with integrated center height adjustment
- Slightly tighten the cylinder head screw (T) of the clamp (U) (moving the grooving insert should still be possible by hand)
- The center height is adjusted by turning the set screw (V)
- Tighten cylinder head screws (T)



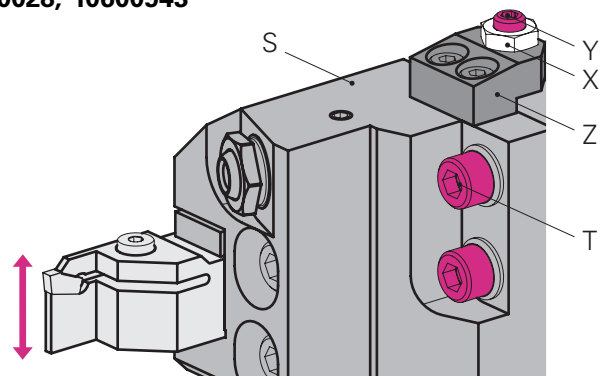
#### Tool holders 10649905, 11071590, 10807171, 10145099

- Grooving insert (S)
- Slightly tighten the cylinder head screw (T) of the clamp (U) (moving the grooving insert should still be possible by hand)
- The center height is adjusted by turning the cylinder head screw (W)
- Tighten cylinder head screws (T)



#### Tool holder 10759672 with grooving tool holder blocks 10320028, 10600943

- Grooving insert (S) with integrated center height adjustment
- Slightly tighten the cylinder head screws (T) (moving the grooving insert should still be possible by hand)
- Loosen the lock nut (X)
- The center height is adjusted by turning the set screw (Y)
- Tighten the lock nut (X) against the clamp (Z)
- Tighten cylinder head screws (T)

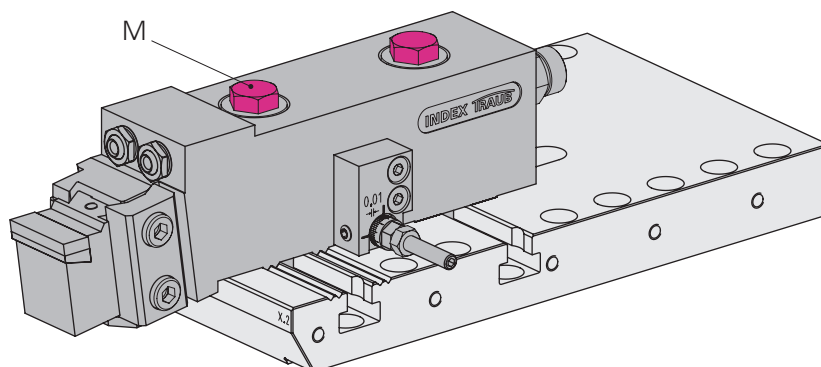


## Presetting adapter for grooving slide

The setup is shown in positions 1.2, 3.2, 5.2

### Installation in INDEX MS16

- The values determined for the presetting unit can be transferred 1:1 to the machine
- The tool holder can now be mounted on the machine
- The setup is shown in positions 1.2, 3.2, 5.2
- Tighten hexagon head screws (M)





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