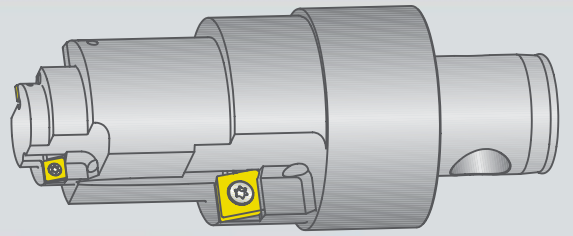


**NEW**

**Inserts  
Fine adjustment**



# KOMET GROUP – THE GROUP FOR SOLUTIONS.

## Inserts with fine adjustment by adjusting pin for special tools for precision machining

With the new adjustment facility for inserts, KOMET offers another solution in the precision machining area.

### Function:

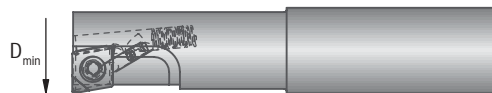
Using an adjusting pin on the tool, the insert can be easily set for the individual application.

### Features:

- Setting facility for insert in an adjustment range of 0.2 mm with reference to the diameter
- Adjustment accuracy: one revolution of the adjusting screw  $\triangleq 40 \mu\text{m}$  radial adjustment; this allows a setting accuracy of 2 to 5  $\mu\text{m}$  to be achieved.
- Bores possible in H7 quality
- Also suitable for step tools
- Single insert tools from 10 mm  $\varnothing$  with insert size C...04
- Double insert tools from 20 mm  $\varnothing$  with insert size C...04
- Single insert tools from 16 mm  $\varnothing$  with insert size C...06



### Machining with single insert - fine adjustment by adjusting pin:



$D_{\min}$	Insert	Adjustment/R	Adjusting pin Order No.	Spring Order No.
10	CC 04	0,1	L02 31100	5271001042
	CP 04		L02 31120	
16	CC 06	0,1	L02 31200	5677505032
	CP 06		L02 31220	
20	CC 09	0,1	L02 31300	5271001112
	CP 09		L02 31320	
28	CC 12	0,1	L02 31400	5271001112
	CP 12		L02 31420	

- Adjusting pins for other clearance angles available on request
- For double insert machining  $D_{\min \text{ double insert}} = 2 \times D_{\min \text{ single insert}}$

### Insert forms:

- Insert adjustment also for square inserts (S) and triangular inserts (T)
- Fine adjustment for other inserts types available on request.



## KOMET GROUP – THE GROUP FOR SOLUTIONS.

### Inserts with fine adjustment by adjusting wedge for special tools for precision machining

The adjusting wedge is moved by means of an adjusting spindle and the boring cartridge pushed in the radial direction.

#### Function:

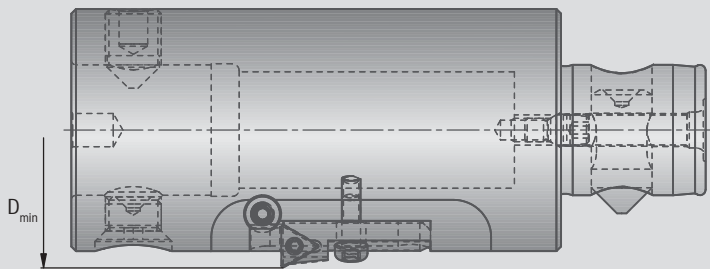
To set the diameter by radially adjusting the boring cartridge

#### Features:

- Setting facility for short clamping holder in an adjustment range of 0.2 mm with reference to the diameter
- Adjustment accuracy: one revolution of the adjusting screw  $\triangleq$  20  $\mu$ m radial adjustment; this allows a setting accuracy of 2 to 5  $\mu$ m to be achieved.
- $D_{\min \text{ single insert}}$  for UKS 8 = 30 mm
- $D_{\min \text{ double insert}}$  for UKS 8 = 32 mm
- Various adjustments also possible in combination with axial adjustment
- The arrangement shown (Fig.1) is also used where mounting depth is limited
- Adjusting wedge is located at the rear of the short clamping holder (Fig.2)

### Machining with single insert - fine adjustment by adjusting wedge:

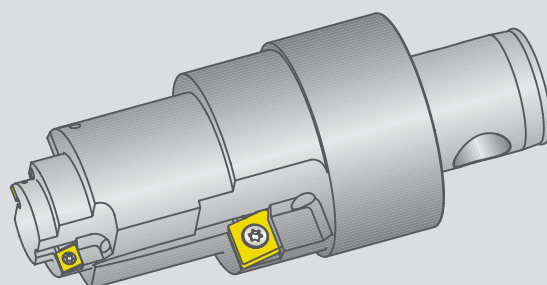
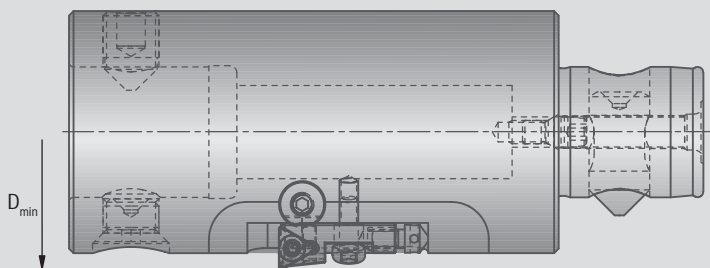
Fig 1



Example of application on standard boring bar for machining cam shaft and crank shaft bearing races



Fig 2



Special tools with multiple inserts with insert adjustment

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