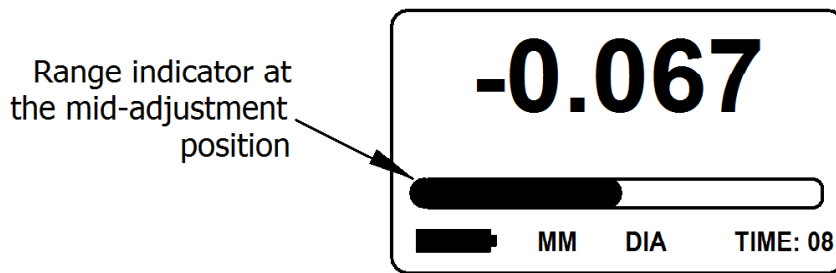
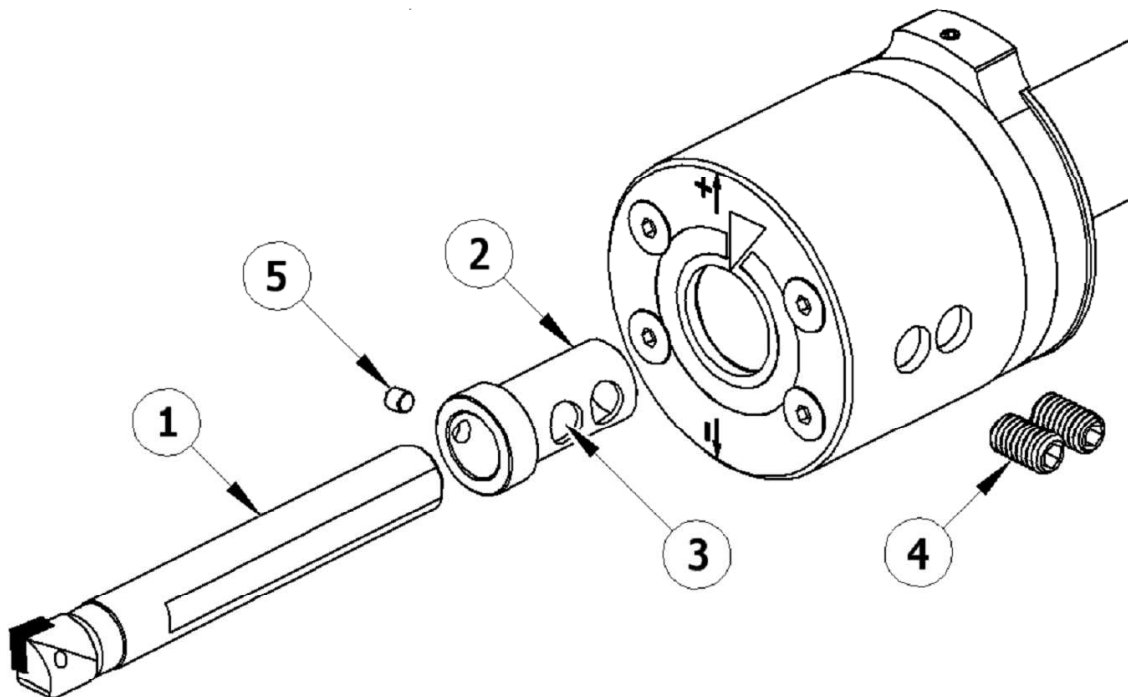


SB010 – Smartbore Nano tool setup instructions

1. Use the Smartbore Adjuster range indicator to set the Nano fine adjustment carriage to its approximate mid-adjustment position. (Ignore the digital position readout).

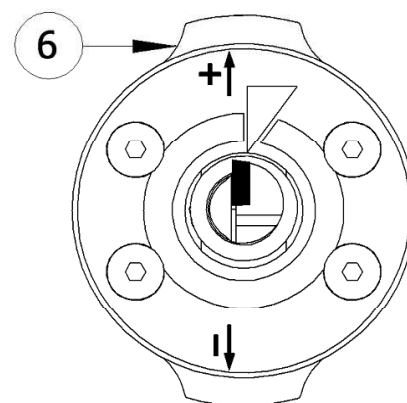


2. Select the required boring tool **(1)** and sleeve **(2)**. Drop the sleeve into the carriage, ensuring that the thru holes **(3)** line up with the 2 No. M6 tool clamping screws **(4)**.



3. Fit and tighten the tool clamping screws to 3 Nm, making sure that they are tightened onto the boring tool flat. Doing this will also correctly align the cutting edge. On boring tools with a flat on the opposite side of the bar, a short M4 set screw **(5)** can be used to align the tool before tightening the M6 screws.

The top view shows the correct alignment of the cutting edge with the '+' indicator arrow.



4. Finally, use the Smartbore Adjuster to precisely set the tool to the required cutting diameter. The Adjuster should be used from then onwards to adjust the tool when in use. Note that there is approximately +/- 0.25 mm (on diameter) of fine adjustment available from the mid-adjustment position. The head should not be adjusted beyond this range.

There are 2 No. balancing rings **(6)** integrated into the tool body. These are used to balance the head prior to shipping, but can be modified by the user on suitable balancing equipment if high speed machining is to be performed. Each ring is locked into place by means of an M3 screw.