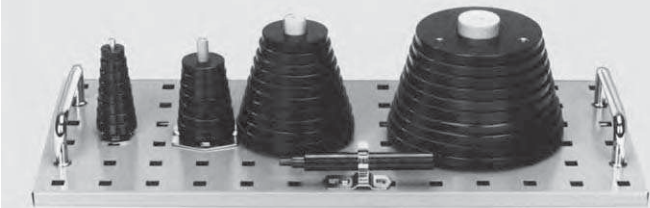


Boring rings ADS

■ to bore jaws on the clamping chuck

ADS Id. No. 082689

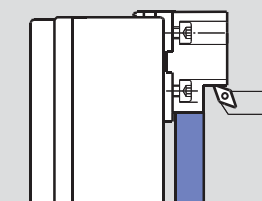


Parts included: Set 36 pieces completely as shown

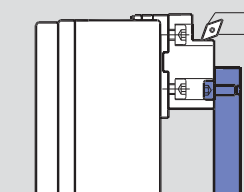
The advantages of the SMW-AUTOBLOK boring rings for jaws:

- Complete set to bore all dia. from 20 to 150 mm.
- Set consisting of 36 rings \varnothing 20 - 50 mm each stepped 2 mm. From \varnothing 50 - 150 mm stepped in 5 mm increments.
- Clearly organized on base plate.
- Rings from \varnothing 105 mm and up have 3 tapped holes for clamping bolts to machine jaws for internal gripping.
- Rigid design. Rings are 10 mm thick, quenched for greater durability.
- Mounting handle is used for the safe insertion of the smaller rings without danger of injuries.

Applications



external clamping



internal clamping

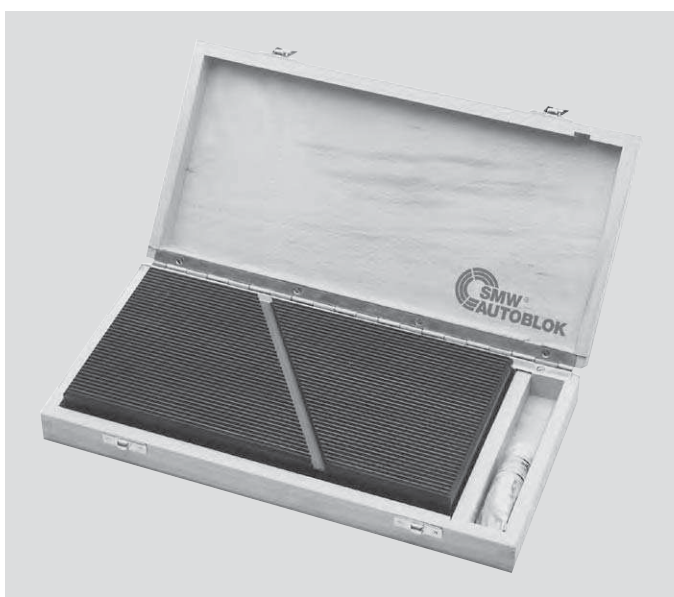
Recommendations:

For highest repeatability and accuracy please follow these instructions:

- Always tighten mounting bolts of the top jaws with a torque wrench.
- Always position boring rings as close as possible to the clamping area.
- Always bore top jaws at machining pressure.

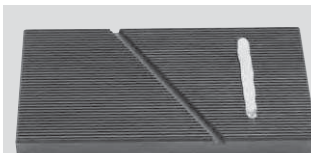
Dress and cleaning plate RPS

With 2 different fine serrations to clean and dress top jaws with fine serration inch/metric

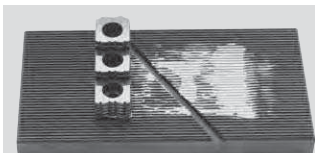


- Dress and cleaning plate, hardened, precision ground serrations
- 2 different serrations, on the upper and lower side of the plate. Just turn it!
- Rapid cleaning of the top jaws serration. Swarf and dirt is accumulated in the diagonal groove
- Dressing of light damage on the serration by using the grinding compound

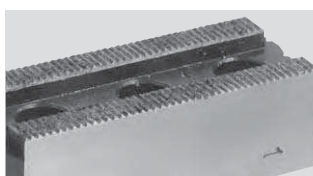
Dressing and cleaning of serration



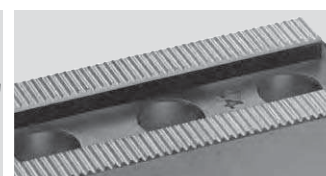
Apply grinding compound (corn 320) near the outer edge



Put the jaw on the grinding compound and move it back and forth, with a light pressure.



Dirty/damaged serration



Serration after dressing and cleaning

SMW-AUTOBLOK Type	Id. No.	Serration		kg
		upper side	lower side	
RPS-D	081912	1/16" x 90°	3/32" x 90°	7.8
RPS-M	081914	1.5 x 60°	3 x 60°	7.8
RPS-MD	081913	1.5 x 60°	1/16 x 90°	7.8