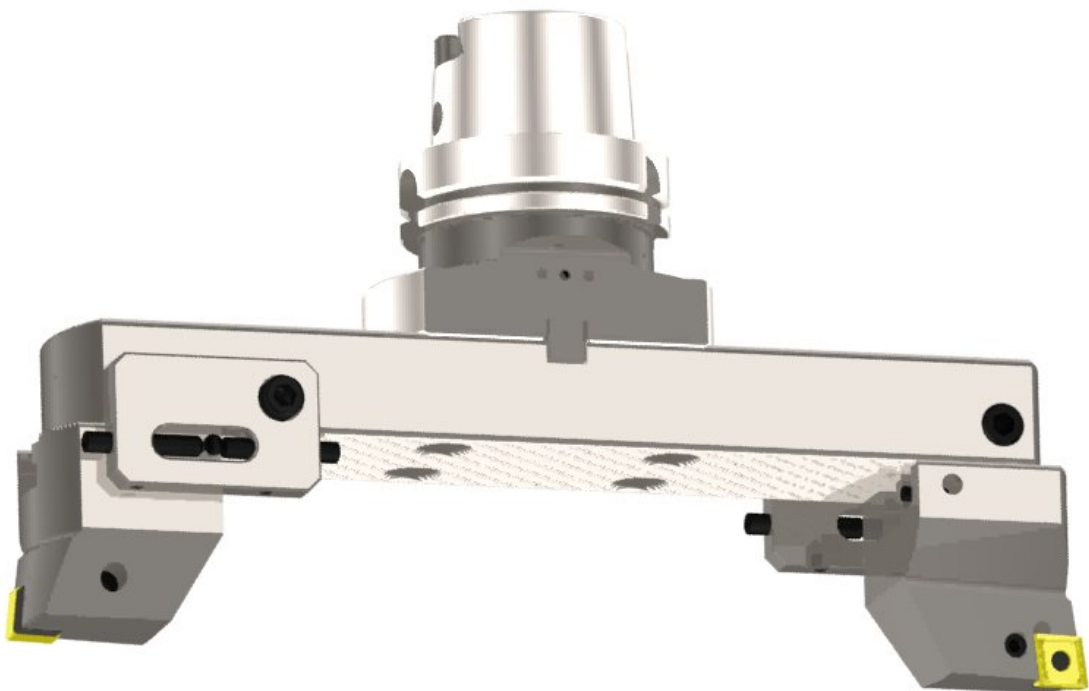


# SWISS+TOOLS

## Operating instructions

### Bridge tools Ø150-655 mm



## 1. Basic safety information



**Before first use, please read the operating instructions carefully. These provide important safety information and information concerning use and maintenance of the tool.**

This precision boring tool is designed for finishing bores in metallic materials.

Specific information on the machining of individual metallic materials is not the subject of these operating instructions. No other application is permitted and could be dangerous. The manufacturer cannot be held responsible for damage or injury caused by improper use. A damaged tool could endanger your safety! Decommission the tool immediately and contact your suppliers. This tool complies with the prescribed safety regulations. Repairs must be undertaken only by trained personnel. Improper repairs can represent a considerable risk for the user. Keep the Operating instructions for use in a safe place for future use.

## 2. Application and operation

The tools of this series are for roughing and finishing operations. The diameter range  $\varnothing$  150 – 655mm can be reached with 10 extension bridges.

## 3. Tool features

- manufactured from hardened and ground alloyed case-hardening steel
- as monobloc- or modular tool available
- main body and insert holders have a teeth profile
- the tools have a special teeth profile which is positive locking and actuated by adherence
- with inner coolant supply
- tools are able for pin turning
- to reach the diameter range there is original SWISSTOOLS equipment necessary

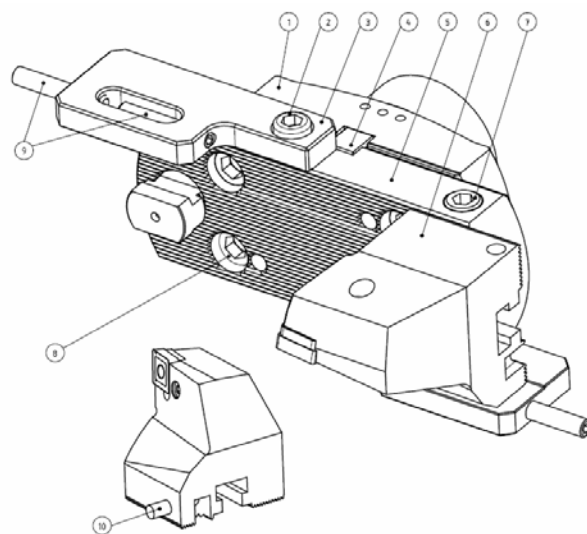
## 4. Operation

### Hole making

1. Clean the gearing and lubricate it
2. Wedge (4) must be installed on the bridge (1)
3. Install the extension bridge (5) with four head screws (8) onto the bridge
4. Tighten the screws (8) with 50 Nm
5. Push the insert holder (6) onto the extension bridge (5)
6. Install the presetting plate (3), for extension bridge  $\varnothing$ 130 and  $\varnothing$ 230 use screw (2) M10x12, for all others use the screw (2) M10x18
7. For presetting the insert holders (6) use the setting screws (9).
8. Tighten the clamping screw (7) with 50 Nm



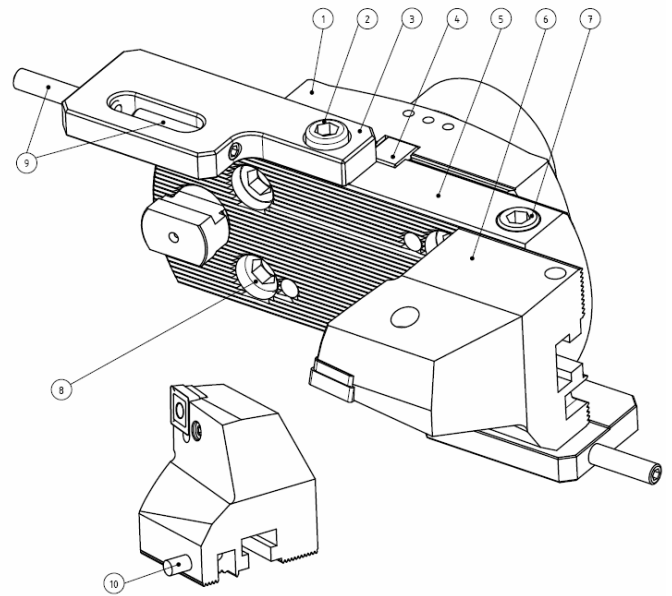
**Attention:** Facing a pin turning application the pin (10) must be installed. The pin is included in the set.



Tools delivered prior to year 2007 / 2008 can be upgraded. For upgrading remove the safety handle and follow the installation instruction above.

## Pin turning

1. Clean the gearing and lubricate it
2. Wedge (4) must be installed on the bridge (1)
3. Install the extension bridge (5) with four head screws (8) onto the bridge
4. Tighten the screws (8) with 50 Nm
5. Push the insert holder (6) onto the extension bridge (5)
6. Install the presetting plate (3), for extension bridge Ø130 and Ø230 use screw (2) M10x12, for all others use the screw (2) M10x18
7. For presetting the insert holders (6) use the setting screws (9).
8. Tighten the clamping screw (7) with 50 Nm



**⚠ Attention:** Facing a hole making application the pin (10) must be installed. The pin is included in the set.

Tools delivered prior to year 2007 / 2008 can be refitted by making a bore for the pin. Please contact your distributor or [www.swisstools.org](http://www.swisstools.org).

**⚠** To avoid damage to parts of the adjustment mechanism, do not make any diameter adjustments in the clamped state.

**⚠** To avoid damage to parts, never use force when carry out adjustment.

## 6. Service

It's not necessary to grease the tool. The teeth profile has to be cleaned before assembling. Service and repairs will be done in our company.

## 7. Technical data

Ø range mm Hole making	Ø range mm pin turning	Max. rpm
150-205		1250
200-255	10-65	1000
250-305	60-115	850
300-355	110-165	700
350-405	160-215	600
400-455	210-265	530
450-505	260-315	480
500-555	310-365	440
550-605	360-415	400
600-655	410-465	360

SWISSTOOLS tools are subject to constant further technical development. You can obtain up-to-date information from our product catalogue as well as on our website.

We reserve the right to technical changes.

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