

## ■ To bore jaws on the clamping chuck

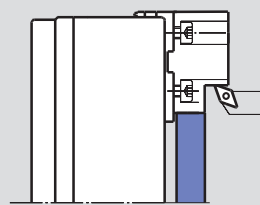
ADS, Id. No. 082689

### Parts included:

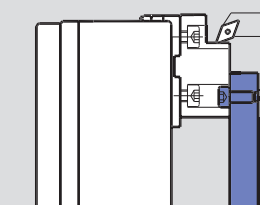
- Packing box
- Boring rings 36 pieces
- Loading tool



## Applications



external clamping



internal clamping

## 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 Ø 20 - 50 mm each stepped 2 mm. From Ø 50 - 150 mm stepped in 5 mm increments.
- Clearly organized in packing box.
- Rings from Ø 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.
- Loading tool is used for the safe insertion of the rings without danger of injuries.

## 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.

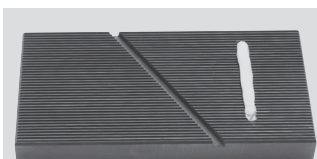
- With 2 different fine serrations to clean and dress top jaws
- With fine serration inch/metric

## Dress and cleaning plate RPS

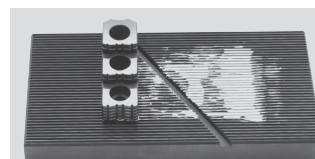


- Dress and cleaning plate, hardened, precision ground serrations.
- 2 different serrations, on the upper and lower side of the plate. Just turn it!
- Rapid cleaning of the top jaws serration. Swarf and dirt is accumulated in the diagonal groove.
- Dressing of light damage on the serration by using the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

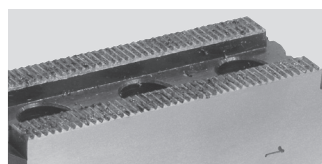
### Dressing and cleaning of serration



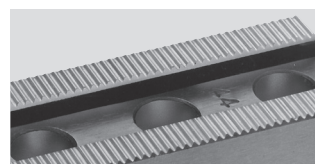
Apply grinding compound (corn 320) near the outer edge.



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

### Parts included:

- Dress and cleaning plate
- 1 tube of grinding paste
- Wooden box

### Extra grinding paste:

Id. No. 037133