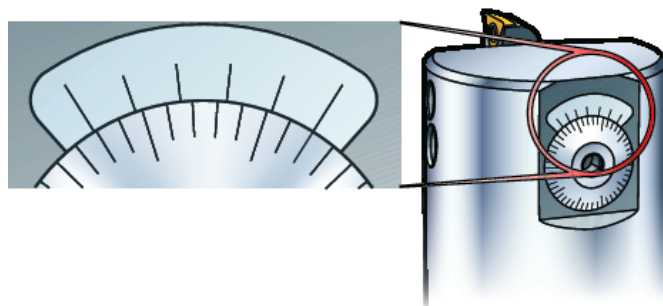


## Setting scale for CoroBore® 825 and Fine boring head 391.37A / 391.37B

One full turn of the scale will move the insert 0.25 mm radially. Subsequently the diameter change will be 0.5 mm.

The dial has 50 divisions. Each division represents  $0.5/50 = 0.010$  mm/diameter.

The vernier has 5 divisions. Each scale division can be divided into 5 parts  $0.010/5 = 0.002$  mm, making it possible to adjust the diameter by 0.002 mm.



### Example of setting

In this example the blue line on scale disc is reference since it is aligned to a line on the vernier in the start position.

Start position



Adjusted position



Scale disc turned clockwise until line of scale (red) lines up with second line (green) of vernier. Diameter increased by 0.002 mm.



Scale disc turned clockwise until line of scale (red) lines up with third line (green) of vernier. Diameter increased by 0.004 mm.



Scale disc turned clockwise until line of scale (red) lines up with fourth line (green) of vernier. Diameter increased by 0.006 mm.



Scale disc turned clockwise until line of scale (red) lines up with fifth line (green) of vernier. Diameter increased by 0.008 mm.



Scale disc turned clockwise until line of scale (red) lines up with sixth line (green) of vernier. Diameter increased by 0.010 mm = 1 division of scale.