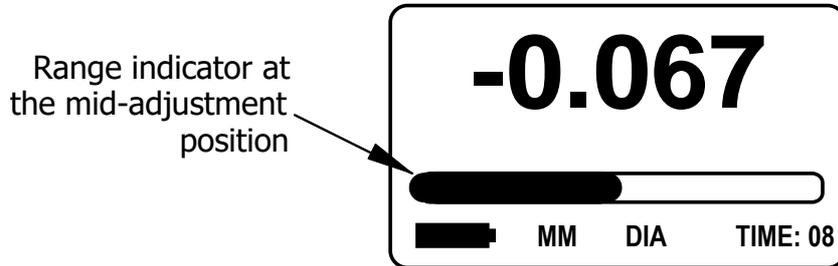
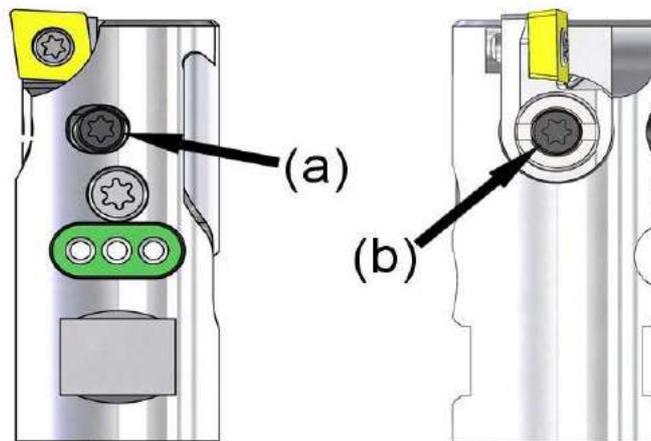


SB016 – Smartbore Plus coarse adjustment procedure

1. Use the Smartbore Adjuster range indicator to set the SB-PLUS head to its approximate mid-adjustment position. (Ignore the digital position readout).



Ensure that an insert is correctly fitted and carry out the following steps in a presetter:



2. Slacken the M3 side locking screw **(a)** with a 1.5mm AF Allen key.
3. Use a T7 Torx driver to set the head to its approximate preset size by adjusting the coarse adjustment screw **(b)**.
4. Re-tighten the the locking screw **(a)** to a torque of 1.0 Nm
5. Finally, use the Smartbore Adjuster to precisely set the tool to the required cutting diameter.

Further fine adjustments should only be made using the Smartbore Adjuster, as shown.



Note that there is approximately +/- 0.25 mm (on diameter) of fine adjustment available from the mid-adjustment position. The head must not be adjusted beyond this range.

SB017- PREVENTATIVE MAINTENANCE FOR SMARTBORE PLUS BORING HEADS.

Smartbore Plus boring heads require regular maintenance to ensure optimal performance and durability, especially when machining cast iron.

The greasing process is designed to flush out small chips and machining dust that may build up in the cartridge mechanism.

Grease should be pumped into the cartridge until it emerges clean from around the slide.



www.rigibore.com

RECOMMENDED GREASING INTERVALS			
MATERIAL \ USAGE	Heavy	Medium	Light
Ferrous (cast Iron) - no coolant	3/week	2/week	1/week
Ferrous (cast Iron)	2/week	1/week	1/week
Ferrous (steel)	1/week	1-2 weeks	1/month
Non-ferrous	1-2 weeks	1/month	6/year

The correct operation and micron accuracy of the adjustment will be negatively affected unless the above schedule is adhered to.



Available from Rigibore:

Grease gun and cartridge: UFPG-00
Grease cartridge: UFPG-RFL

The above are supplied with 200g of recommended lubricant:

[Castrol Longtime PD2](#)

This product can additionally be used to maintain all UFP cartridges.