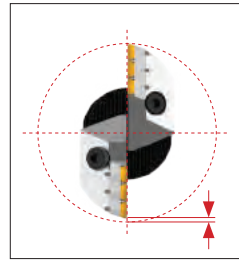


VolCut Technical Information

Setup Instructions | Minimum Pilot Calculation



Step 1:
Loosen the mounting screws on both cartridges.

Step 2:
Set one cartridge to the finish diameter by tightening the adjustment screw against the adjustment pin.

Step 3:
Tighten the mounting screws on the cartridge to 15-19 Nm.

Step 4:
Set the opposing cartridge with 4 mm - 5 mm radial offset inward by tightening the adjustment screw against the adjustment pin (optimum situation for each insert to remove equal material).

Step 5:
Tighten the mounting screws on the cartridge to 15-19 Nm.

Note: Drilling systems with OP inserts are used as single cutters. The replaceable inserts are mounted offset in diameter. Please review the assembly instructions.

Minimum Pilot Calculation

Calculation: Finish Diameter - Opening Range = Minimum Pilot Hole Diameter

Insert Holder	Diameter Range	Opening Range
151019	65.00 mm - 70.00 mm	15.24 mm
	70.00 mm - 83.00 mm	47.75 mm
151039	82.00 mm - 87.00 mm	15.24 mm
	87.00 mm - 103.00 mm	68.07 mm
151059	100.00 mm - 105.00 mm	15.24 mm
	105.00 mm - 130.00 mm	68.07 mm
151069	125.00 mm - 130.00 mm	15.24 mm
	130.00 mm - 205.00 mm	68.07 mm
149030	200.00 mm - 3255.00 mm	68.07 mm

Example: To open an existing hole to 114.30 mm diameter, a 151059 insert holder would be used with a 148007 serrated tool body, and the minimum pilot diameter would be 114.30 mm - 68.07 mm = 46.23 mm.