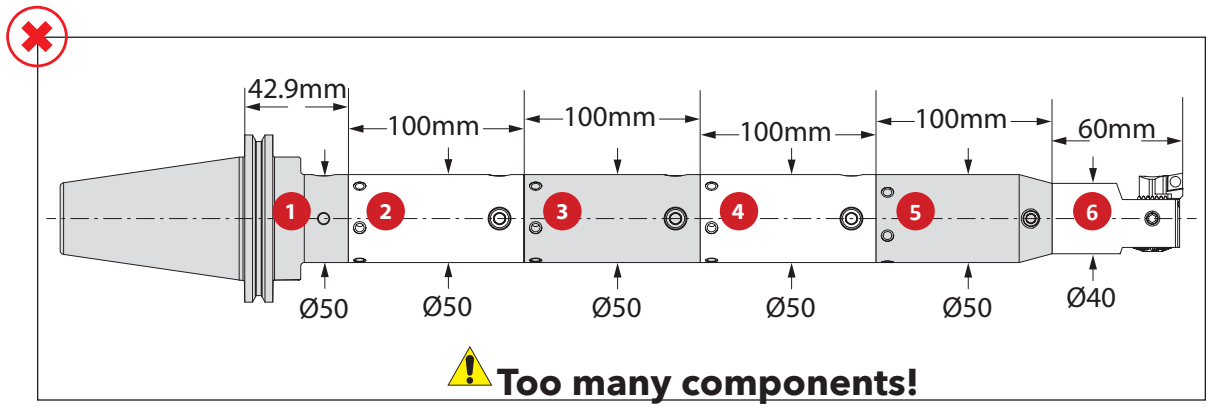
ALLIED MACHINE & ENGINEERING | WOHLHAUPTER®

Guidelines for not Exceeding Recommended Length to Diameter Ratio

To calculate, see graphics below:



NOTE: Length to diameter ratio is calculated using body diameters, not cutting diameter.
NOTE: Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)

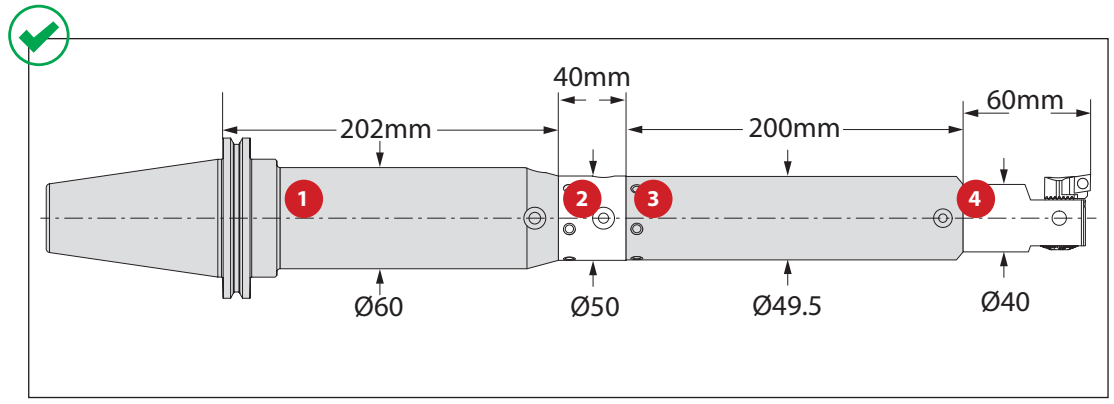
Step 1: Find L : D by component

1. 0.9 = 42.9/50
2. 2.0 = 100/50
3. 2.0 = 100/50
4. 2.0 = 100/50
5. 2.0 = 100/50
6. 1.5 = 60/40

Step 2: Add each L : D Average

0.9
2.0
2.0
2.0
2.0
+ 1.5
10.4 = L : D ratio

Too long with too many components!



NOTE: Length to diameter ratio is calculated using body diameters, not cutting diameter.
NOTE: Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)

Step 1: Find L : D by component

1. 3.2 = 202/60
2. 0.8 = 40/50
3. 4.0 = 200/49.5
4. 1.5 = 60/40

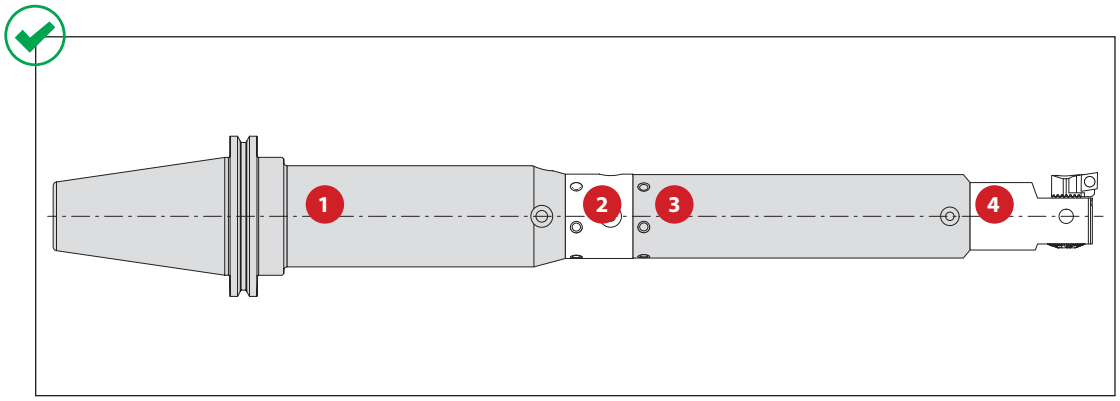
Step 2: Add each L : D average

3.2
0.8
4.0
+ 1.5
9.5 = L : D ratio

WARNING **Tool failure can cause serious injury. To prevent:**
-Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)
Factory technical assistance is available for your specific applications through our Application Engineering department. *ext:* **7611** | *email:* **appeng@alliedmachine.com**

Calculating Tool Assembly Weight

To calculate, see graphics below:



Step 1: Find weight for each component circled in the example table below

Example:

	MVS Connection	Boring Range	4 Boring Head					
	D_1 & D_2	A	X_1	X_2	L_2	D_5	Weight	Part No.
i	40 - 22	2.087 - 2.598	2.953	1.535	2.854	–	1.543 (lbs)	**320004**
m	40 - 22	53.01 - 65.98	75.00	39.00	72.50	–	0.70 (kg)	**320004**

Step 2: Calculate total assembly weight

1 6.6 kg
2 0.6 kg
3 3.5 kg
\+ 4 0.7 kg
11.4 kg

Step 3: Consult machine tool builder to ensure tool assembly weight does not exceed machine capabilities.

⚠ WARNING **Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage, and/or serious injury. To prevent:**
-Consult machine tool builder for machine's weight limitations.
Factory technical assistance is also available for specific applications through our Application Engineering department. *ext:* **7611** | *email:* **appeng@alliedmachine.com**