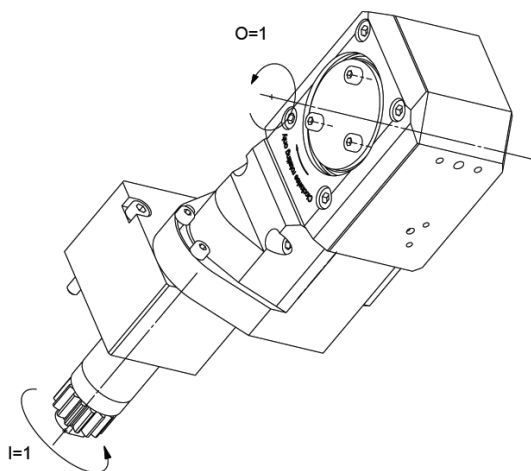


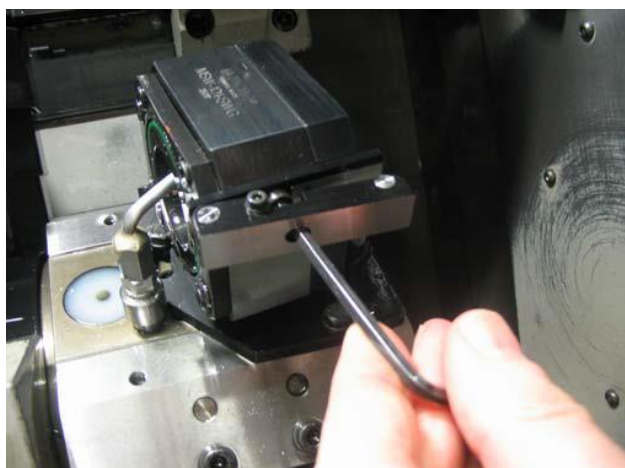
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Français

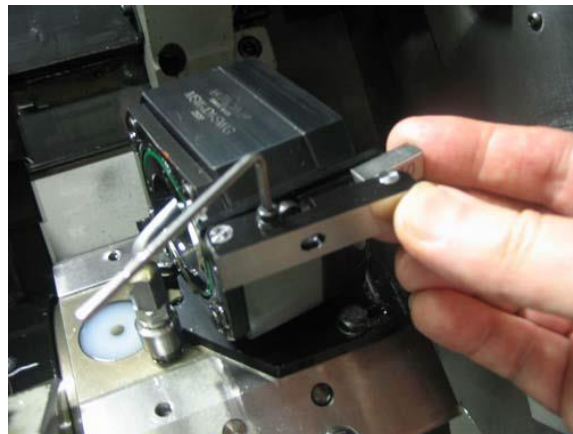
1. Pour fixer le porte-outil sur la machine, l'introduire dans les positions T08-T09 et serrer les vis de fixations (important, veillez à ce que les vis aient la même force de serrage).



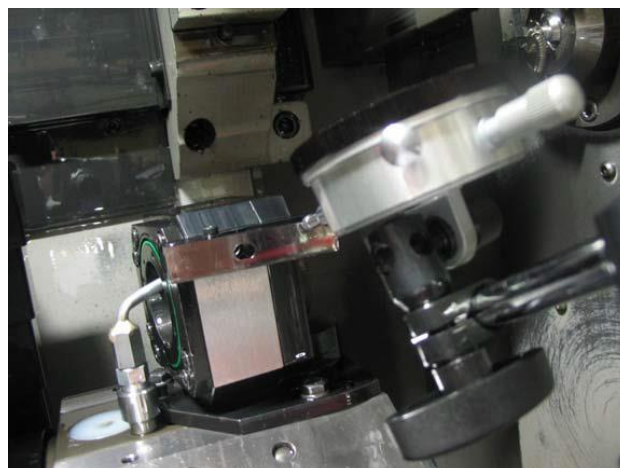
2. Fixer le reglangle sur le porte-outil.



3. Desserrez la vis, puis sélectionnez la cale de contrôle correcte (voir table Sinus 0°-15°). Resserez la vis et retirez la cale de contrôle. Le reglangle est maintenant réglé pour l'angle d'hélice nécessaire.



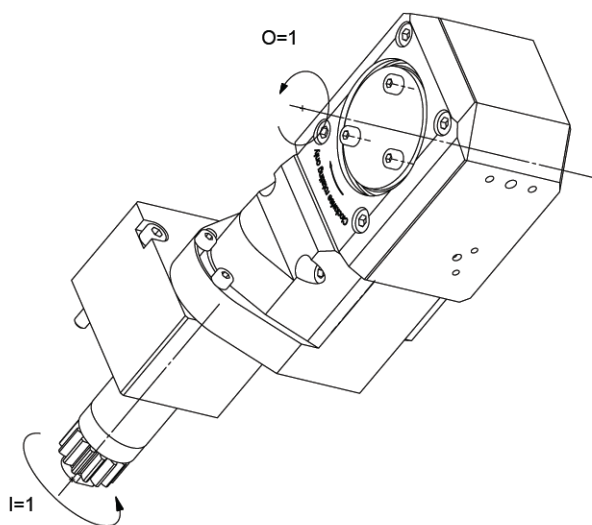
4. Desserrer les vis de fixation sur le corps du tourbillonneur. La tête sera en mesure de pivoter à droite. Vous pouvez maintenant régler la tête sur l'angle correct. Contrôler l'angle avec le palpeur en déplaçant l'axe. On doit lire ZERO sur l'instrument de mesure. Pour finir: sur ZERO, inscrivez le résultat dans le programme. Vous devez serrer les vis de fixation sur le corps du tourbillonneur en place avant d'exécuter le travail.



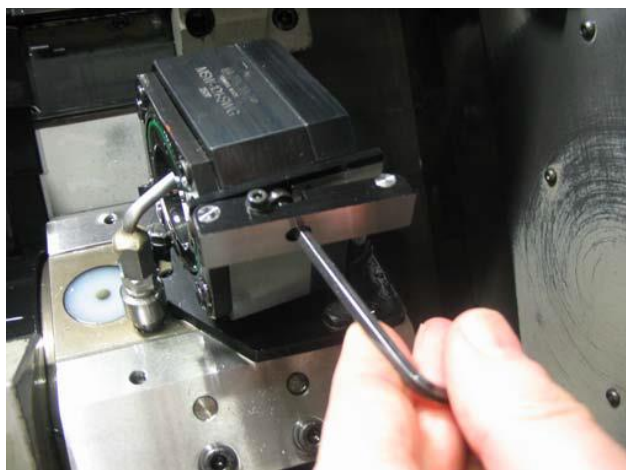
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English

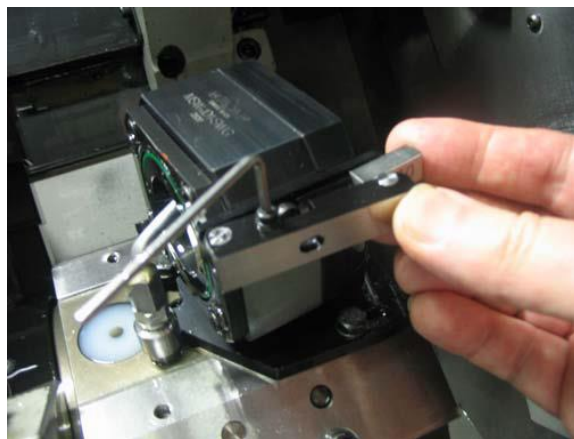
1. To fix the tool holder on the machine, introduce it on the positions T08-T09 and tighten the screws of fixations (Important, make sure that the screws have the same strength of tightening).



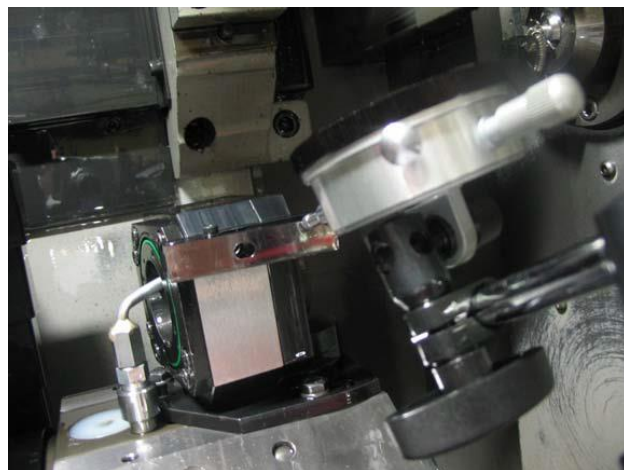
2. Fix the reglance to the whirling attachment.



3. Loose the screw, then select the correct slip gauge (see table Sinus 0°-15°). Re-tighten the screw and remove the slip gauge. The reglance is now set for the required helix angle.



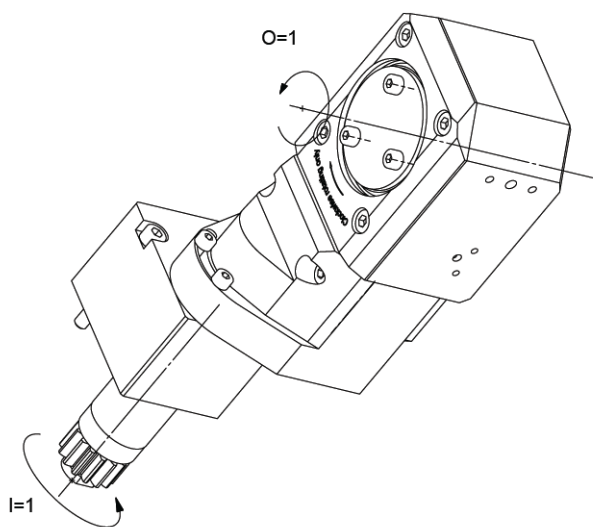
4. Loose slightly the fixation screws on the whirling head. The head will be able to rotate to the right and left. You can now settle the head on the correct angle. Controle the angle with the feeler and moving the axe. It must read ZERO on the measuring instrument. Close: on ZERO, enter the result of the whirling process. You can thighten the fixation screws to fix the thread-whirling head in place before running the job.



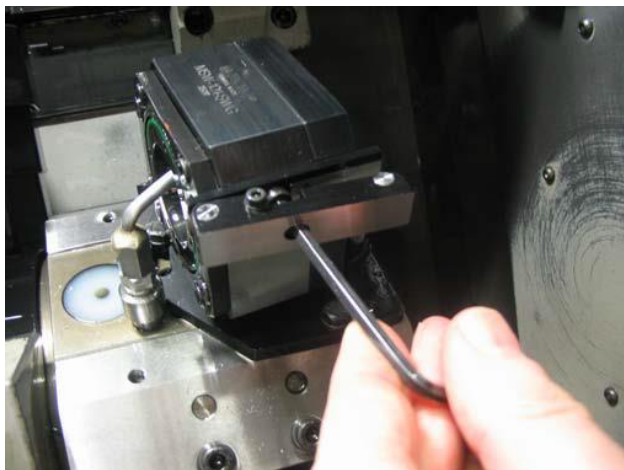
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Deutsch

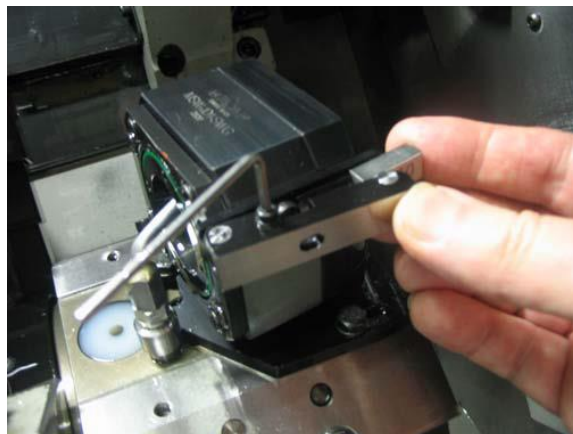
1. Montieren Sie das Werkzeug auf die Positionen T08-T09 auf der Maschine. Ziehen Sie die Schrauben an (Wichtig, achten Sie darauf, dass die Schrauben gleichmässig angezogen sind).



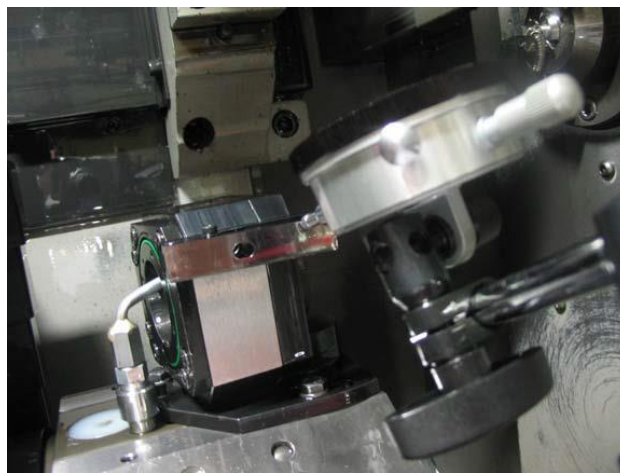
2. Befestigen Sie den „Reglangle“ an den Wirbelkopf



3. Lösen Sie die Schrauben und wählen Sie die richtigen Endmasse (siehe Tabelle Sinus 0°-15°). Ziehen Sie die Schraube an und entfernen Sie die Endmasse. Den „Reglangle“ ist jetzt auf dem erforderlichen Steigungswinkel eingestellt.



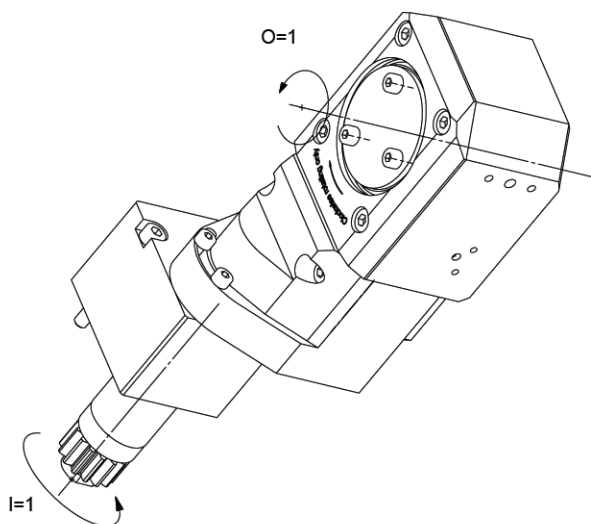
4. Lösen Sie die Schrauben am Körper von dem Wirbelkopf. Den Kopf kann jetzt nach rechts gedreht werden. Sie können jetzt den Kopf auf den richtigen Winkel einstellen. Kontrolle vom Winkel mit dem Fühlhebelsmesstaster durch die Bewegung von der Achse. Ziehen Sie die Schrauben an und überprüfen Sie den Offset.



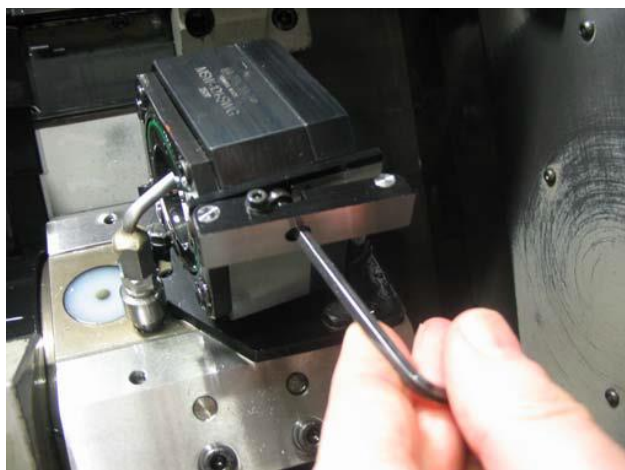
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Italiano

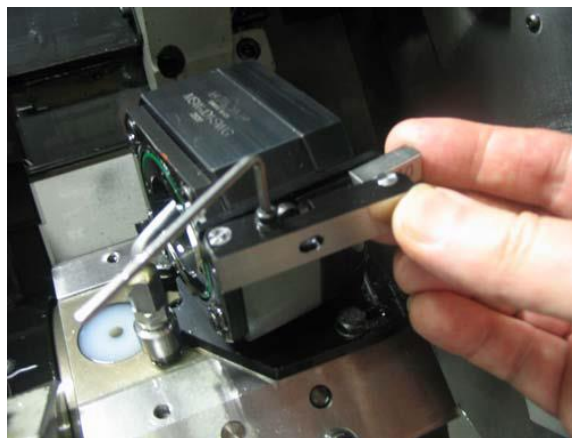
1. Per fissare il porta-utensile sulla macchina introdurre il in posizione T08-T09 e serrare le viti di fissaggio. (importante, guardare che le viti hanno la stessa forza di serraggio).



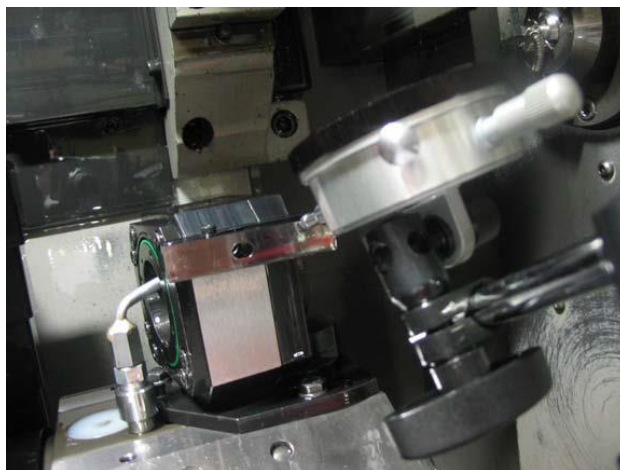
2. Fissare il "Reglangle" su il swirler.



3. Allentare la vite, e quindi selezionare il controllo spessore corretto (vedi tabella Sinus 0 ° -15 °). Serrare le viti e rimuovere il controllo di spessore. Il reglangle è ora impostato per l'angolo di elica necessaria.



4. Allentare le viti sul difissaggio del swirler. La testa può ruotare verso destra. È ora possibile impostare la testa sulla corretta angolazione. Controllare l'angolo con tastatore spostando l'asse. ZERO deve leggere sullo strumento di misura. Infine: ZERO, inserire il risultato nel programma. È necessario serrare le viti sul difissaggio del swirler in vigore prima di eseguire il lavoro.



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REGLANGLE-SW Table sinus 0°-15°

	0'	10'	20'	30'	40'	50'
0°	1.00	1.15	1.29	1.44	1.58	1.73
1°	1.87	2.02	2.16	2.31	2.45	2.60
2°	2.74	2.89	3.04	3.18	3.33	3.47
3°	3.62	3.76	3.91	4.05	4.20	4.34
4°	4.49	4.63	4.78	4.92	5.07	5.21
5°	5.36	5.50	5.65	5.79	5.94	6.08
6°	6.23	6.37	6.52	6.66	6.80	6.95
7°	7.09	7.24	7.38	7.53	7.67	7.81
8°	7.96	8.10	8.25	8.39	8.53	8.68
9°	8.82	8.97	9.11	9.25	9.40	9.54
10°	9.68	9.83	9.97	10.11	10.25	10.40
11°	10.54	10.68	10.83	10.97	11.11	11.25
12°	11.40	11.54	11.68	11.82	11.96	12.11
13°	12.25	12.39	12.53	12.67	12.81	12.95
14°	13.10	13.24	13.38	13.52	13.66	13.80
15°	13.94	14.08	14.22	14.36	14.50	14.64