



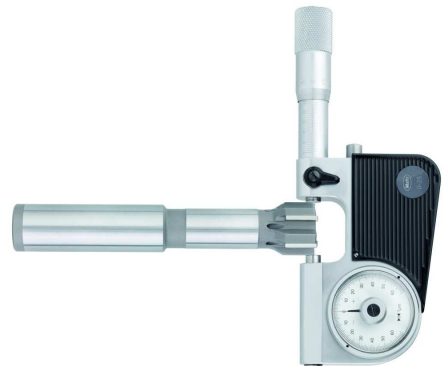
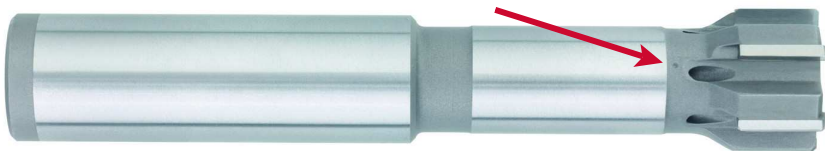
# Diatool Handling Instructions

## Basics

When manufactured, all Diatool monoblock reamers are ground and set within the bore diameter tolerance field and require no diameter setting by the customer. Standard practice is for expandable reamers to be ground to  $\frac{1}{2}$  or to the mean of the tolerance. Solid (non-expandable) reamers are ground to  $\frac{2}{3}$  of the tolerance. At customer request, Diatool reamers can be ground to any target diameter.

## Measurement

The diameter of the reamer can be checked with any commercially available micrometer. The two blades to be measured are  $180^\circ$  opposite and marked with a dot (see photo below). The reamer must be measured up front, just behind the lead, because of the back-taper. Be very careful not to damage the reamer blades with the micrometer. We recommend to measure the bore after reaming rather than the reamer itself.



## Expansion

The conical screw has to be turned carefully clock-wise with the key until the required diameter is reached. About  $30^\circ$  represents an expansion of about 6 - 12 microns mm depending on diameter. This manipulation is meant to be for wear compensation only. Should the reamer be over expanded accidentally, loosen the conical screw completely and adjust again.

