

Romicron Assembly Instructions

The required parts for the adaptor assembly are identified on Figures 1 and 2. The SVS model is shown. The instructions are also valid to the SVU and SVUBB models.

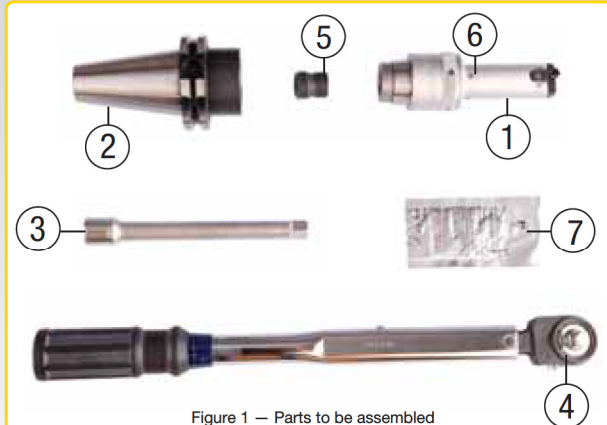


Figure 1 — Parts to be assembled

1	Boring head
2	Taper shank
3	Square extension (3/8" or 1/2")
4	Torque wrench
5	Differential connector
6	Positioning pin
7	Lubricant ASL-3G

WARNING:

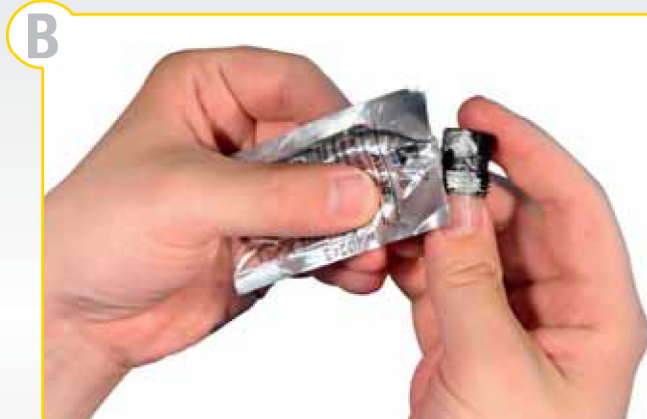
Before starting the assembly procedure, ensure that all surfaces to be assembled together are free of dirt and completely clean.



Figure 2 — Assembled Tool



A. Remove the Differential Connector (5) from the Taper Shank (2).



B. Lubricate the thread on the Differential Connector (5) with Lubricant ASK-3G (7), supplied with the Taper Shank (2).



C. Screw the Differential Connector (5) into the rear thread on the Boring Head (1) until the end of the thread. At this time it is not necessary to tighten the Differential Connector (5). Remember that the Differential Connector (5) has two different screws, so there is no way to assemble the wrong side.

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D. Screw the front end of the Taper Shank (2) onto the Differential Connector (5), now located at the back on the Boring Head (1). Screw carefully until the Positioning Pin (6) gently touches the Taper (2) face. Stop!



F. Insert the square end of the Extension (3) through the Taper Shank (2) and into the Differential Connector (5). Keeping the Positioning Pin (6) and the positioning slot aligned, turn the Extensions (3) anti-clockwise until you see that two Romicon faces are meshing. Ensure that the Positioning Pin (6) is inserted into the slot on the Taper Shank (2).



E. Unscrew the Taper Shank (2) a little bit until the Positioning Pin (6) is aligned with the positioning slot mark in the Taper Shank (2) face.



G. Tighten the Differential Connector (5) with the specified required torque, as shown on the table below. Use the Torque Wrench (4) to do this.

Tightening Torque Specifications

joint size	Torque Nm	drive square
KR32	30	3/8"
KR50	40	3/8"
KR63	55	1/2"
KR80	65	1/2"

Following these procedures will result in a rigid surface contact between the taper and the boring head face.