

# Van Norman Blind Hole Tool Holders

## Setup Instructions

Follow the procedures below to obtain consistent setup of the Van Norman Blind Hole Tool Holders.



Figure 1

Using the VN-BHFX Setting Fixture as pictured below with the tip of the cutter in contact with the face of the fixture. See Figure 2



Figure 2

Insert and adjust the calibration screw so that a .030 feeler gauge just fits between the

calibration screw and setting fixture when the cutter tip is in contact with the face of the setting fixture. See Figure 3

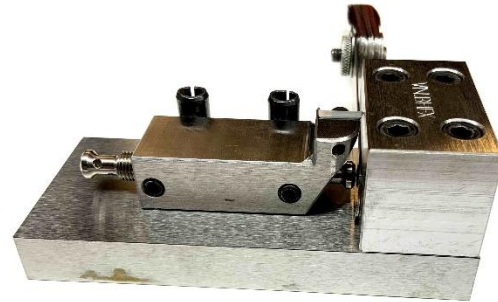


Figure 3

Take care in making this adjustment. Once done, lock the set screw for the calibration screw. When the cutter tip is in contact with the face of the setting fixture you should now have .030 gap between the calibration screw and the face of the setting fixture. See Figure 4

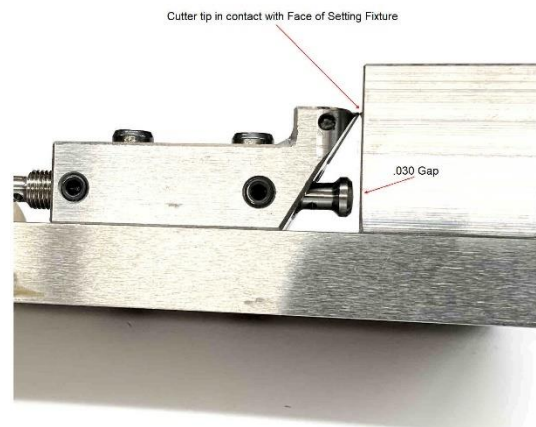


Figure 4

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This .030 gap is set so that when boring a cylinder the calibration screw does not drag in the cylinder.

At this point the calibration screw is set and you are ready to set the tool holder and do a test bore.

Set the tool holder in the micrometer as pictured in figure 5 and use the same .030 feeler gauge between the micrometer anvil and the adjusting screw. Set the cutter as you would the original tooling. Every time you use this particular Blind Hole Tool Holder you will use the .030 feeler gauge between the anvil and adjusting screw. See Figure 5



Figure 5

After you have bored a test hole it may be necessary to adjust the calibration screw slightly to make the bore size match your particular boring bar. Once this is achieved it should not be necessary to readjust the calibration screw again.

The Adjustment Screw is all that will be adjusted to set to different bore sizes. When using this method, you should get good

repeatable results when setting to different bore sizes. It is best practice to keep the .030 feeler gauge with the tool holder as you will need it every time you set this Tool Holder.