



Alberti®

LIVE TOOLING



LIVE TOOLING

**INSTRUCTION
BOOK**

TOOL RUN-IN

A short run-in of the tool is required to distribute the lubrication and to check that all components are functioning correctly. The tool will run hotter than normal during the first few hours of operation. Tool temperatures of up to 70°C (158°F) are acceptable if not associated by abnormal tool noise.

Prior to initial use of this tool, it is necessary to perform the following run-in procedure:

1. Run tool at 500 RPM for 20 minutes, then stop and wait 10 minutes.**
2. Run tool at 1,500 RPM for 15 minutes, then stop and wait 10 minutes.**
3. Run tool at 2,000 RPM for 15 minutes, then stop and wait 10 minutes.**
4. Run tool at 3,000 RPM for 5 minutes.**

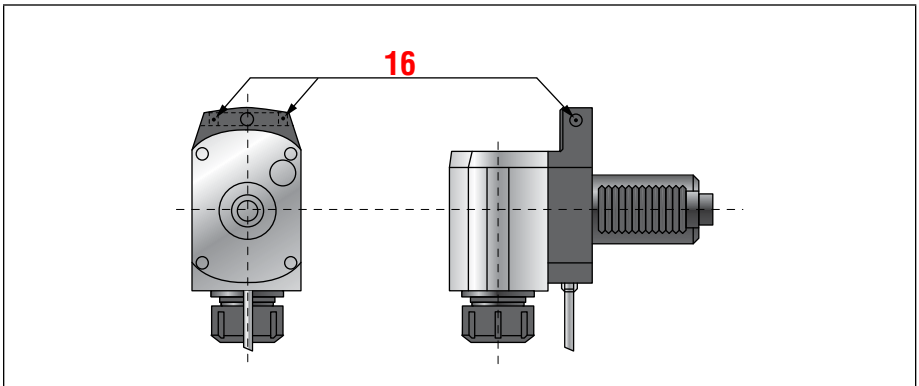
Run-in procedure is complete.

****For all tools with a 4:1 or 2:1 gear ratio, cut the run-in times and RPM in half!**

WARNING: Failure to observe the run-in recommendations will compromise the warranty of the live tool.

RADIAL POSITIONING OF THE LIVE TOOL

Install the tool on the turret and adjust the position parallel to the “X” axis using the adjusting screws (16) on the tool body.



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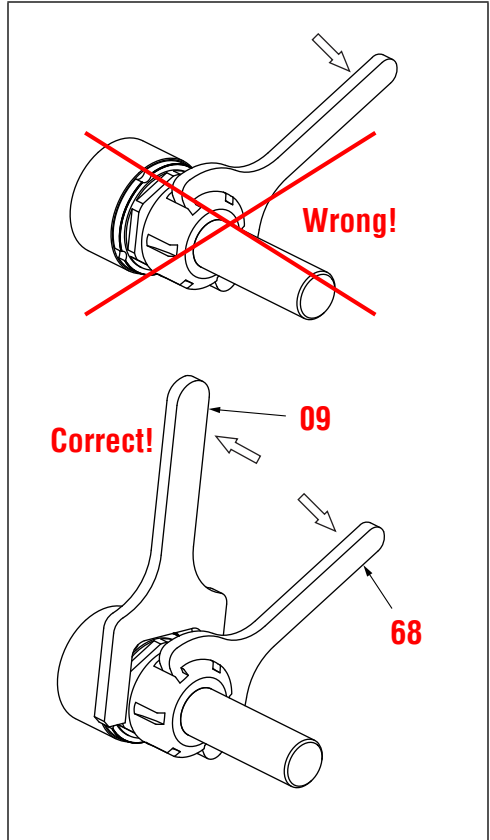
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CLAMPING A CUTTING TOOL IN THE LIVE TOOL COLLET

To clamp a cutting tool in the live tool collet, proceed as follows:

1. Put the suitable spring collet in the slotted nut.
2. Screw the nut on the collet chuck.
3. Insert the cutting tool and tighten by hand.
4. Important: To fully tighten the nut, you must use **both** wrenches **68** and **09** - included with the live tool - as shown at right.
Warning: failure to follow these instructions may cause severe damage to the bevel gears in the live tool.
5. Use the opposite procedure to unclamp the cutting tool.



LIVE TOOL MAINTENANCE

Alberti live tools are supplied greased and ready for use. Keep to the suggested time intervals and grease quantities. Poor or excessive lubrication could be harmful. The following lubrication intervals and grease amounts are suggested:

Every 500 working hours re-grease 4:1 and 2:1 speeder tools with 1-1.6 oz. of **Kluber NB 52** high speed bearing grease.

Every 1,000 working hours re-grease standard 1:1 tools with 1-1.6 oz. of **Kluber NB 52** high speed bearing grease.



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WARRANTY

All product lines sold by KOMA Precision Inc. carry a manufacturers guarantee of one year from the date of purchase. This warranty covers parts and labor due to defects in materials and workmanship. This warranty does not apply to any products that have been subject to misuse, neglect or accident. Products repaired by KOMA Precision Inc. will carry a 90 day warranty. Additional or extended warranty is available upon request for an additional fee.

PARTS AND SERVICE

Please contact
Koma Precision, Inc.
for parts and service
on Alberti lathe tools.

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