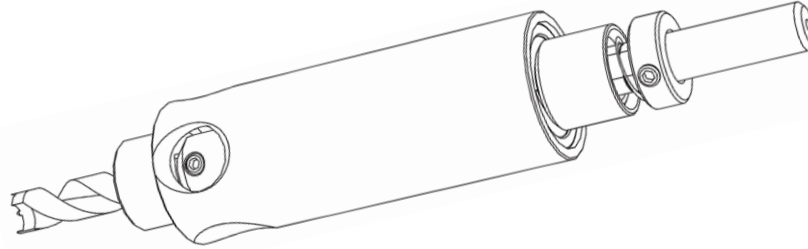


## Boring Spindle

Operating instructions



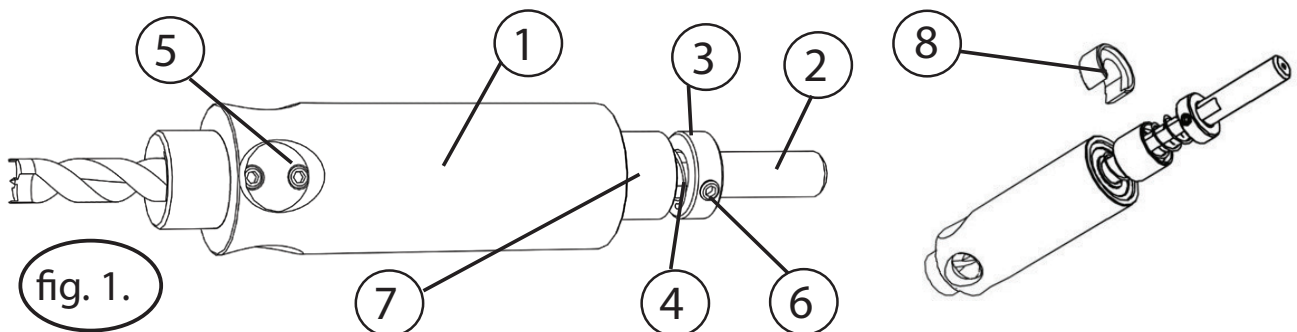
Producer:  
 IGM nástroje a stroje s.r.o.  
 Ke Kopanině 560, 252 67, Tuchoměřice  
 Czech Republic, EU  
 Phone: +420 220 950 910  
 E-mail: sales@igmttools.com  
 Website: www.igmttools.com



2022-06-20

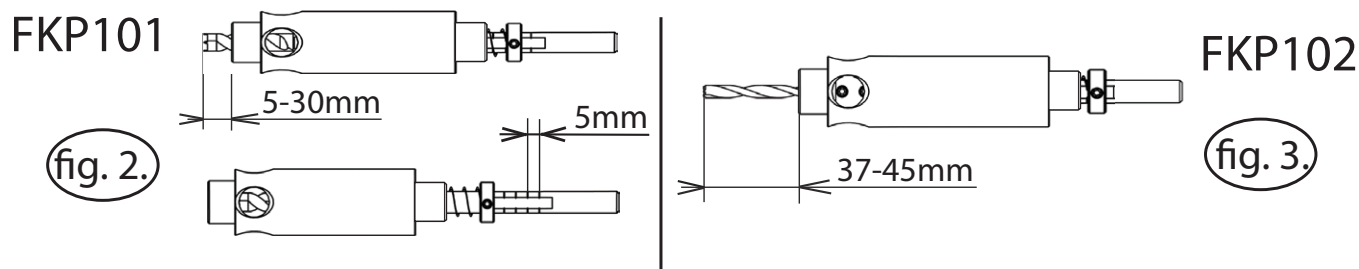
FKP101 FKP102 IGM Boring Bush Manual EN v3.5 A4ob

FKP101-102 Spare parts list		v.3	
Pos. #	Description	Pieces	Code
1	Corps for FKP 101 with bearings	1	
	Corps for FKP 102 with bearings	1	
2	Shaft FKP 101	1	
	Shaft FKP 102	1	
3	Stop ring	1	FKP101-3
4	Spring	1	FKP101-5
5	Setting screw M4x4 (grub screw)	2	FS200 153
6	Setting screw M4x5 (grub screw)	1	FS200 115
7	Spring stop FKP101	1	FKP101-7
8	Ring for FKP	1	FKP101-8
9	Imbus key 2	1	FS800002



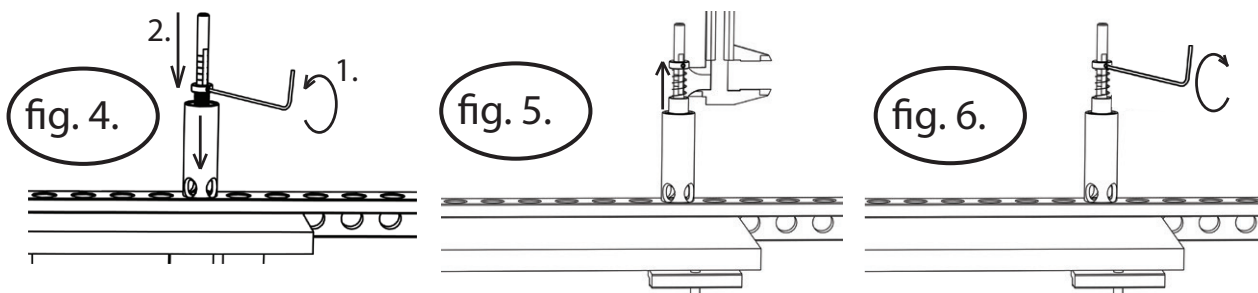
## Description of boring bush FKP101, FKP102

The boring bush is composed of a duralumin centering bush (pos. 1) and a 9 mm diameter shaft (pos.2) with tightening part for dowel bits. The boring shank is seated in the centering bush bearing to provide maximal boring precision. The tightening part is secured with a spring (pos.4) and a stop ring (pos.3) fixed by a screw (grub screw). The boring depth is set by the stop ring, for boring depth range see figure (fig. 2 & 3). The boring bush **FKP101** is for simple boring depth setting equipped with a scale with lines à 5 mm (fig. 2).



## Boring depth setting

The setting procedure is represented in the figure (fig. 4 to 5). Tighten the workpiece to the boring jig (FKP400 - 656). Put the boring bush into the 18 diameter hole so that after pressing onto the shank, the point of the dowel bit touches the workpiece. Put the ring for FKP (pos. 8) under the spring stop (pos. 7) (fig. 1). Loosen the setting stop ring screw (imbus key 2 is included in the FKP101-102 packing) and press the stop ring to the jig until the stop ring for the spring stop is seated under the FKP101 (fig. 4). The point of the dowel bit must still be touching the workpiece. The zero point for the boring depth setting is thus set. Set the required boring depth between the stop ring and the spring stop. The required depth set, tighten the screw of the stop ring (fig. 5 & 6). At the boring bush **FKP101**, this value can be read with the help of lines at the shank, distance of lines is 5 mm (fig. 2). When cutting into side set the boring depth longer than the required hole depth (min. 2 mm longer).



## Recommended accessories

### STOP RING FOR SIMPLE BORING OF 35 mm DOWELS

**FKP101-8**\_\_ Quick and simple to remove,  
boring depth change by 8 mm (fig. 1, pos. 8)

### DOWEL BITS WITH HM CUTTING EDGE AND A TIGHTENING SHANK S=8 mm

- C306-08011**\_\_ D 8x30 S8 mm dowel bit HM FKP101 (blind holes)
- C306-03021**\_\_ D 3x30 S8 mm dowel bit HM FKP101 (blind holes)
- C306-05011**\_\_ D 5x30 S8 mm dowel bit HM FKP101 (blind holes)
- C307-05011**\_\_ D 5x40 S8 mm dowel bit HM FKP102 (blind holes)
- C368-07011**\_\_ D 7x30 S8 mm dowel bit HM FKP101 (through holes for confirmate screws)

