


The following list shows the changes that have been made in this version of the Allied Master Criterion Catalog. Please make notes within your copy of the catalog or simply print this change log and keep it with your catalog.

| Section | Date | Page | Change(s) |
|---------|----------|---------------------------------------|---|
| B20 | 12/30/19 | B20: 13 | Incorrect diameter range for item number MDS16M <ul style="list-style-type: none"> • Current diameter range reads 18.00 - 27.00. Should be 18.00 - 24.25 |
| | 12/30/19 | B20: 37 | Missing coated trigon Insert Form <ul style="list-style-type: none"> • Should be WBGX0301... |
| | 12/30/19 | B20: 60 | Torque setting under lock screw column is incorrect for the following item numbers: CB1250B, CB1250CC, CB1250TC, CB032MCC, & CB032MTC <ul style="list-style-type: none"> • Current setting is 0.6 (Nm). Should be 0.7 (Nm) |
| | 01/06/20 | B20: 60 | Increased torque spec to 0.6 (Nm) for items CB1000CC, CB1000TC, CB025MCC, CB025MTC |
| | 01/16/20 | B20: 53-54 | Added in master shanks DIN 69871A and DIN 2080 |
| | 02/18/20 | B20: 54 | Removed the following shanks: <ul style="list-style-type: none"> • CB038M-ISO30 • CB038M-ISO40 • CB038M-ISO50 |
| | 09/01/20 | B20: 34 | Incorrect L1 dimension <ul style="list-style-type: none"> • Was: 5.165". Should be 3.166" |
| | 01/07/21 | B20: 3, 9, 17, 22, 27, 30, 34, 38, 42 | Added note to pages: <ul style="list-style-type: none"> • IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues. |
| | 01/03/22 | B20: 51 | Added -1 on the ending of the insert screw item numbers |

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| B20 | 02/18/22 | B20: 55 | <p>Revised instructions for Micro Adjusting Boring heads</p> <ul style="list-style-type: none"> Was: <div style="text-align: right; font-size: small;">BORING Criterion® Modular Boring Systems </div> <hr/> Setup Instructions Micro Adjusting Boring Heads <hr/> Adjusting Micro Adjusting Setting Boring Heads (see figure B2) <ol style="list-style-type: none"> Loosen locking screw (6). Turn dial screw (3) to desired graduation to make macro adjustment. Tighten locking screw (6) to proper torque spec (laser marked on tool). Turn micro adjusting dial screw (4) clockwise to desired graduation to make micro adjustment. Locking of micro adjustment dial screw (4) is not required. <div style="border: 1px solid black; padding: 2px; font-size: x-small;"> IMPORTANT: Do not loosen the gib screws (5). It can cause poor performance. </div> <div style="border: 1px solid black; padding: 2px; font-size: x-small;"> NOTE: To machine smaller bore diameter, turn dial (3) counterclockwise one full rotation to remove any backlash. Once backlash is mitigated, turn dial screw (3) clockwise to desired graduation. </div> <div style="border: 1px solid black; padding: 2px; font-size: x-small;"> NOTE: The micro adjusting dial screws only have a total range of 0.006" (0.152mm) on diameter. To zero, turn dial (4) clockwise until dial screw bottoms out. Turn the dial (4) two complete turns counterclockwise. Turn dial (4) one half turn clockwise. Dial is now centered for 0.003" (0.076mm) positive or negative travel. </div> Now: <hr/> Setup Instructions Micro Adjusting Boring Heads <hr/> Setting Up Micro Adjusting Boring Heads (see figure B2) <p>Set the micro adjusting dial screw range</p> <ol style="list-style-type: none"> The micro adjusting dial screws (4) only have a total range of 0.006" (0.152mm) on diameter. To zero, turn dial (4) clockwise until dial screw bottoms out. Turn the dial (4) two complete turns counterclockwise. Turn dial (4) one half turn clockwise. Dial is now centered for 0.003" (0.076mm) positive or negative travel. <p>Setting the diameter of the boring head</p> <ol style="list-style-type: none"> Loosen locking screw (6). Turn dial screw (3) to adjust to the desired diameter using a pre-setter or plunge indicator, or the dial screw (3). Tighten the locking screw (6) to the proper torque spec (laser marked on the tool). <ul style="list-style-type: none"> Micro adjustments will be made at the machine. Make a shallow test cut (roughly 0.250" deep) to determine the actual diameter. Use the micro adjusting dial (4) to adjust to the finish diameter. Do not release the locking screw (6) for micro adjustments. <ul style="list-style-type: none"> If the hole diameter is more than .002" from the target hole size return to step 2. <div style="border: 1px solid black; padding: 2px; font-size: x-small;"> IMPORTANT: Do not loosen the gib screws (5). It can cause poor performance. </div> <div style="border: 1px solid black; padding: 2px; font-size: x-small;"> NOTE: Backlash occurs when the diameter of the boring head needs to be decreased. To remove backlash, turn the dial (3) counterclockwise at least one half of a full rotation past the desired adjustment. Once backlash is mitigated, turn dial screw (3) clockwise to the desired adjustment. </div> |