









## DIATOOL compensation holder

<p><b>1.</b></p>	<p>Insert tool into holder and tighten the Weldon screw.</p>		<p><b>5.</b></p>	<p>Turn the setting ring until the setting screw closest to the highest run-out is positioned as close as vertically below the dial gauge.</p>	
<p><b>2.</b></p>	<p>Locking screw is set by the manufacturer. Do not touch it!</p>		<p><b>6.</b></p>	<p>Set the Allan-key at the closest screw vertically below the dial gauge and tighten it carefully until about half of the run-out is eliminated.</p>	
<p><b>3.</b></p>	<p>Loosen all setting screws to allow the setting ring to be turned freely within the set 60°.</p>		<p><b>7.</b></p>	<p>Should the closest setting screw not be exactly vertically below the gauge, tighten the closest screw on the other side carefully until the runout is further reduced. Turn the reamer 360° and check run-out.</p>	
<p><b>4.</b></p>	<p>Set dial gauge onto the concentricity control zone of the tool. Use a 0,001 mm (1 μm) dial gauge. Turn the tool 360° and go onto the highest run-out indication.</p>		<p><b>8.</b></p>	<p>If necessary repeat point 6 &amp; 7 until the run-out is completely eliminated.</p>	
			<p><b>9.</b></p>	<p>Turn the reamer again 360° and check the concentricity. Important: Take-off the Allan key!</p>	