

TONSHOFF SET UP SHEET			
DATE	MATERIAL	MACHINE NO.	CYCLE TIME
STATION	LEFT SIDE	CENTER	RIGHT SIDE
	RPM: 450 or 560	RPM: 355	RPM: 355
	GEARBOX: 2.8-1	GEARBOX: 2.8-1	GEARBOX: 2.8-1
2	OPERATION: Head for cap-end - 1 1/8 thread x 1.015 undercut with 5/8 carbide tip drill	OPERATION: Head to drill 2 3/4 bolt center x 17/32 drills	OPERATION: Head to face off bottom & hold centerline with 15/16 carbide tip drill
	RPM: 1000	RPM: 144 - 193 slow	RPM: 180
	GEARBOX: 1.1-1	GEARBOX: 4.1-1	GEARBOX: 7.1-1
3	OPERATION: 7/16 drill rough for stem thread Held in Bushing & 11/16 collect	OPERATION: Head to face-off side and hold 2.084 size for serration dia. Use Tonshoff Adapter	OPERATION: Reamer for bottom end Finish Oper. to Main Seat Held in 63/64 head--9DD Adapter
	RPM: 710	Use the "THICK" jaw adapters	RPM: 710
	GEARBOX: 4.1-1	Set jaws 2 notches away from center	GEARBOX: 2.8-1
4	OPERATION: Fly-cutter head with finish reamer for stem & gland thread with tool to break edge		OPERATION: Hydraulic Recess for Main Seat
	RPM: 280	RPM: 125 - 211 FAST	RPM: 145 - 165 slow
	GEARBOX: 7.1-1	GEARBOX: 2.8-1	GEARBOX: 2.8-1
5	OPERATION: Combination 3/4 - 16 & 1 1/8 - 16 die head & tap.	OPERATION: Finish reamer to face-off for serration and hold centerline. Held in 63/64 head. Long H.V. Adapter	OPERATION: Finish reamer for backseat Held in 63/64 head with 63/64 Adapter
	RPM: 180	RPM: 100 - 236 slow	RPM: 125 - 210 slow
	GEARBOX: 4.1-1	GEARBOX: 2.8-1	GEARBOX: 4.1-1
6	OPERATION: 9/16 - 18 stem tap Held in 63/64 head	OPERATION: Head with serration tool and reamer to cut 1 1/4 I.D. Short H.V. adapter	OPERATION: Head to drill 1 5/8 bolt center x 7/8 deep
	DESCRIPTION		DRAWING NO. AND PART NO.
			M331 JAC-1

Approved By _____

Rev: _____ Date _____