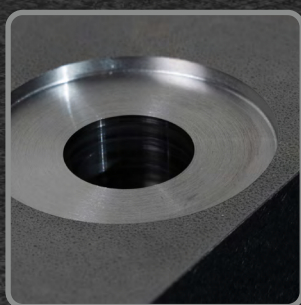
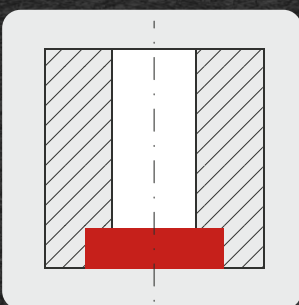




BSF Manual

Backspotfacing with Manual Activation.
Add-On for Standard BSF Range.





BSF Manual complements the existing BSF tool range with the option of manual activation. The blade can be retracted «by hand» and will fold out with the help of the activation speed.

- One manual shank for BSF series A-E, one for F-G
- Housings, controls and blades are identical to the standard BSF Range
- Existing tools can be modified with the shank for manual activation

Operation and Applications

Alternative to coolant or air

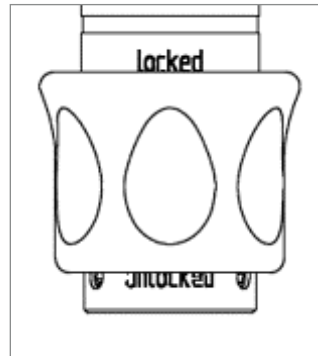
With its new shaft system, the BSF tool now has the option for blade activation using the manual activation ring. It is typically used when the coolant pressure is too weak and/or the air supply is not existing or consistent.

Wide range of application possibilities

The manual option is available for all standard BSF tools. Housings, controls and blades are identical to the standard BSF tool range. The application possibilities are therefore identical.

Observe Precaution

The manual operation must be carried out with caution. It is imperative safety considerations are taken. Absolutely no spindle rotation can be allowed when locking or unlocking the activation ring.



Upper position activation ring
Blade **UNLOCKED**
(blade will fold out when using activation speed)

Lower position activation ring
Blade **LOCKED**
(blade retracted)

Image 1: The activation ring has two positions - unlocked and locked.



! Only operate the activation ring when the spindle is at standstill!

1 Activation ring is in the LOCKED position, blade is retracted

2 Manual turning of activation ring to the UNLOCKED position, blade is unlocked

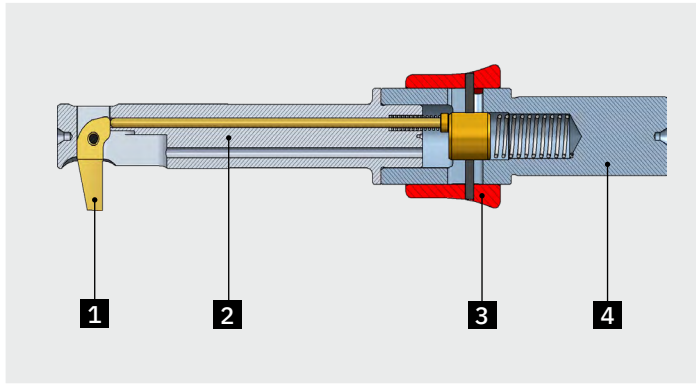


3 By starting the spindle rotation, the blade folds out into the working position when the activation speed is reached

4 Turning the activation ring to the LOCKED position forces the blade to fully retract

Images 2: The blade retracts and folds out by turning the activation ring by hand and using the help of activation speed.

Tool Concept



- 1** Blade
- 2** Blade housing
- 3** Activation ring
- 4** Shaft

Your tool solution

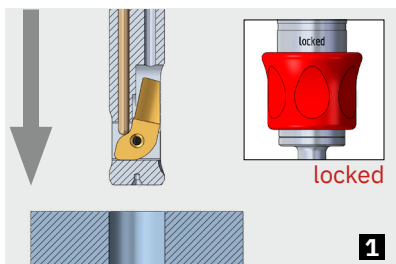
Do you have an application for the BSF Manual? We would be happy to check the feasibility and find a solution for you.



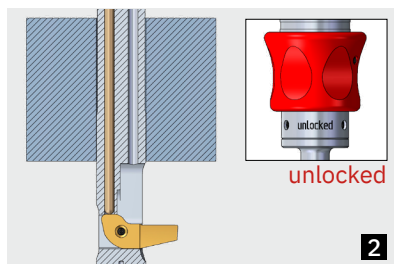
Contact

www.heule.com/en/contact

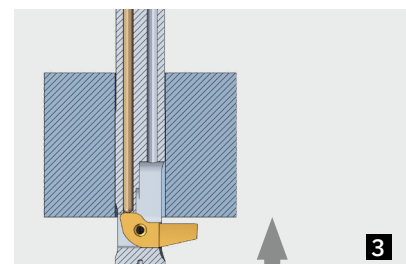
Sequence of Operation / Programming



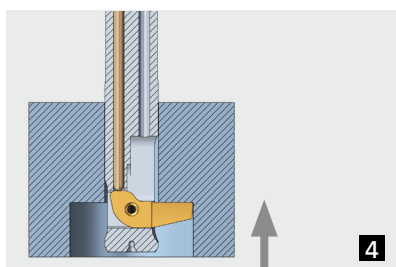
Position the tool above the top material surface, spindle stop, check that the activation ring is in locked position. With blade locked in feed tool through bore. **Only operate the activation ring when the spindle is at standstill!**



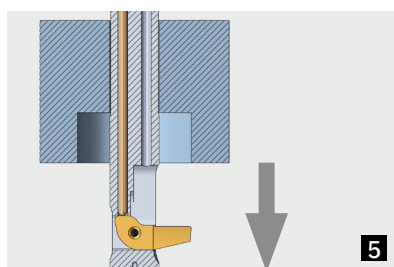
Turn the activation ring to the unlocked position. By starting the spindle rotation, the blade folds out into the working position when the activation speed is reached.



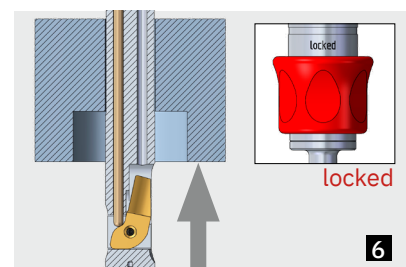
Position the tool in rapid feed with working speed until approx. 1.0 mm below the back of the workpiece surface (attention to burr height and part configuration). Start machining in working feed.



Continue machining to desired counterbore depth.



When the counterbore depth is reached, move down in rapid feed far enough to allow blade to fold in.



With spindle stopped, turn the activation ring to locked, the blade retracts. Now feed the tool out of the workpiece.

Onsite worldwide



+ Headquarters

HEULE Werkzeug AG
Balgach / Switzerland
Phone +41 71 726 38 38
info@heule.com
www.heule.com

+ Subsidiaries

HEULE Tool Corporation
Loveland OH / USA
Phone +1 513 860 9900
info@heuletool.com
www.heuletool.com

● Sales Partners

50 agencies in
35 countries worldwide
www.heule.com

HEULE Precision Tools
(Wuxi) Co. Ltd.
Wuxi / China
Phone +86 510 8202 2404
china@heule.cn
www.heule.cn

HEULE Korea Co. Ltd.
Gyeonggi-do / South Korea
Phone +82 31 8005-8392
info@heule.co.kr
www.heule.co.kr

HEULE Germany GmbH
Wangen im Allgäu / Germany
Phone +49 7522 99990-60
info@heule.de
www.heule.de

ONE OPERATION