

**OPERATING INSTRUCTION FOR  
HORIZONTAL BORING MACHINE  
MODEL DA 85 T  
(ROTARY TABLE TYPE)**



**IKEGAI IRON WORKS, LTD**

## CONTENTS

## INTRODUCTION

1.	Outline .....	2
2.	Specifications .....	2
3.	General Assembly Drawing .....	4
4.	Main Dimensions of Tool Mounting Parts .....	5
5.	Gear Train Diagram .....	7
6.	Cautions for Transportation .....	9
7.	Cleaning .....	10
8.	Installation .....	11
9.	Lubrication .....	15
1)	Spindle Head .....	18
2)	Tail Bracket .....	20
3)	Change Gear Box .....	20
4)	Saddle and Table .....	21
5)	End Support .....	22
10.	Operation .....	25
1)	Cautions before Starting .....	25
2)	Explanation of Symbols on Etched Indication Plates .....	26
3)	Pendant Switch Box .....	27
4)	Selection of Spindle Speed .....	32
5)	Selection of Feed Rate .....	34
6)	Selection of Feed Direction .....	37
7)	Operation of Spindle Feed Direction Change Lever .....	39
8)	Operation of Handwheel .....	40
9)	Rapid Feed Operation .....	42
10)	Cautions in Shifting the Levers .....	43
11)	Manual Feed Operation by Crank Handles .....	43
12)	Thread Cutting Work .....	46
13)	Clamping .....	50
14)	Measuring of Spindle Axial Movement .....	52
15)	Measuring by Digital Micro-Counter .....	54
16)	90° Indexing of Table .....	62

17)	Measuring of Saddle Longitudinal Movement .....	63
18)	Safety Device and Releasing Method .....	63
11.	Adjustment .....	64
1)	Spindle Bearings .....	64
2)	Gibs .....	64
3)	Spindle Head Clamps .....	66
4)	Backlash Eliminator .....	67
5)	Clamping Levers .....	68
12.	Maintenance .....	69