

# Hunger RDS

## Counterboring Tools

for machining valve seat ring bores



	Type RDS1	Type RDS2
<b>Capacity:</b>		
Bore diameter	20 - 60mm	35 - 90mm
<b>Feed Motions:</b>		
Rotation	By hand	By hand
Horizontal feed motion	0,05mm/rev	0,05mm/rev
Vertical feed motion	0,05mm/rev	0,05mm/rev

# RDS Counterboring Tools

## Working principle:

The valve seat ring bore is refaced in a lathe-type counterboring and facing action. The RDS is equipped for counterboring the seat ring bore as well as facing the bottom of the seat ring bore with a single point cutting tool.

An adjustable stop for the tool slide permits quick selection of the proper sized counterbore diameter.

A pilot inserted in the valve guide aligns the RDS in centerline with the valve guide.

A swiveling guide arm is provided below the crank handle for additional support.

To eliminate run out when the RDS is rotated around the pilot, the swiveling guide arm is locked in place either by a steady rest which is mounted on the cylinder head or by means of the Hunger K2000 cylinder head stand.

Pilots and steady furnished with VD valve seat refacing tool also suit for the RDS tool.

## Handling:

Operation is straightforward.

First, insert the pilot into the valve guide.

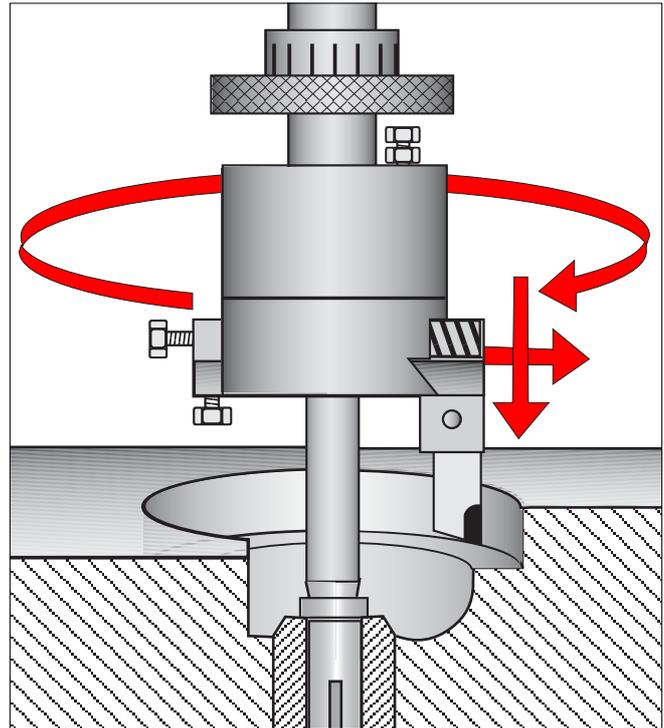
Then place the RDS over the pilot and lock swiveling guide arm in place.

To counterbore the valve seat ring bore, set the stop for the tool slide to the desired oversize diameter and position the cutting tool just in contact with the upper end of the valve seat bore.

Turn infeed to set the desired depth of cut.

Rotate RDS with crank handle and halt downfeed actuator to counterbore the valve seat ring bore in centerline with the valve guide.

Reface bottom of the counterbore in the same manner.



## RDS1 Components

Item	Description	Part No.
1.	RDS1 Counterboring tool	219 20 000
2.	Pilot Typ 1	see to Catalog V12
3.	Cutting tool	see to Catalog V12
4.	Steady	216 55 500
5.	Service tools	
6.	Storage case	219 90 044

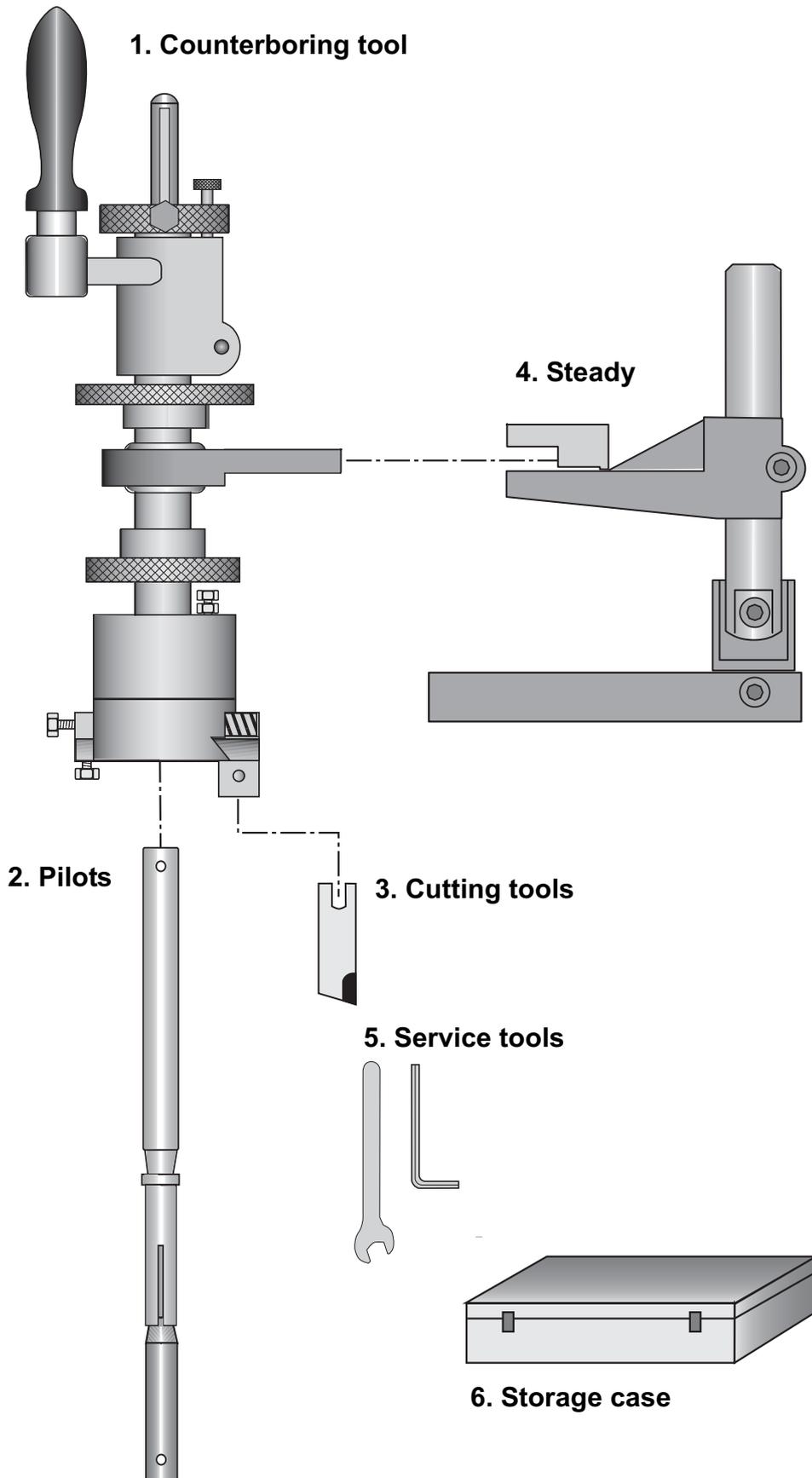
## RDS 2 Components

Item	Description	Part No.
1.	RDS 2 Counterboring tool	219 20 000
2.	Pilot Typ 2	see to Catalog V12
3.	Cutting tools	see to Catalog V12
4.	Steady	216 55 500
5.	Service tools	
6.	Storage case	220 90 045

The available pilots and the available cutting tools are listed in our Catalog V12 Automotive "Tools and Equipment for Automotive Workshops".

The Catalog can be downloaded as pdf file from our website "www.ludwig-hunger.de".

# RDS1 Components



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