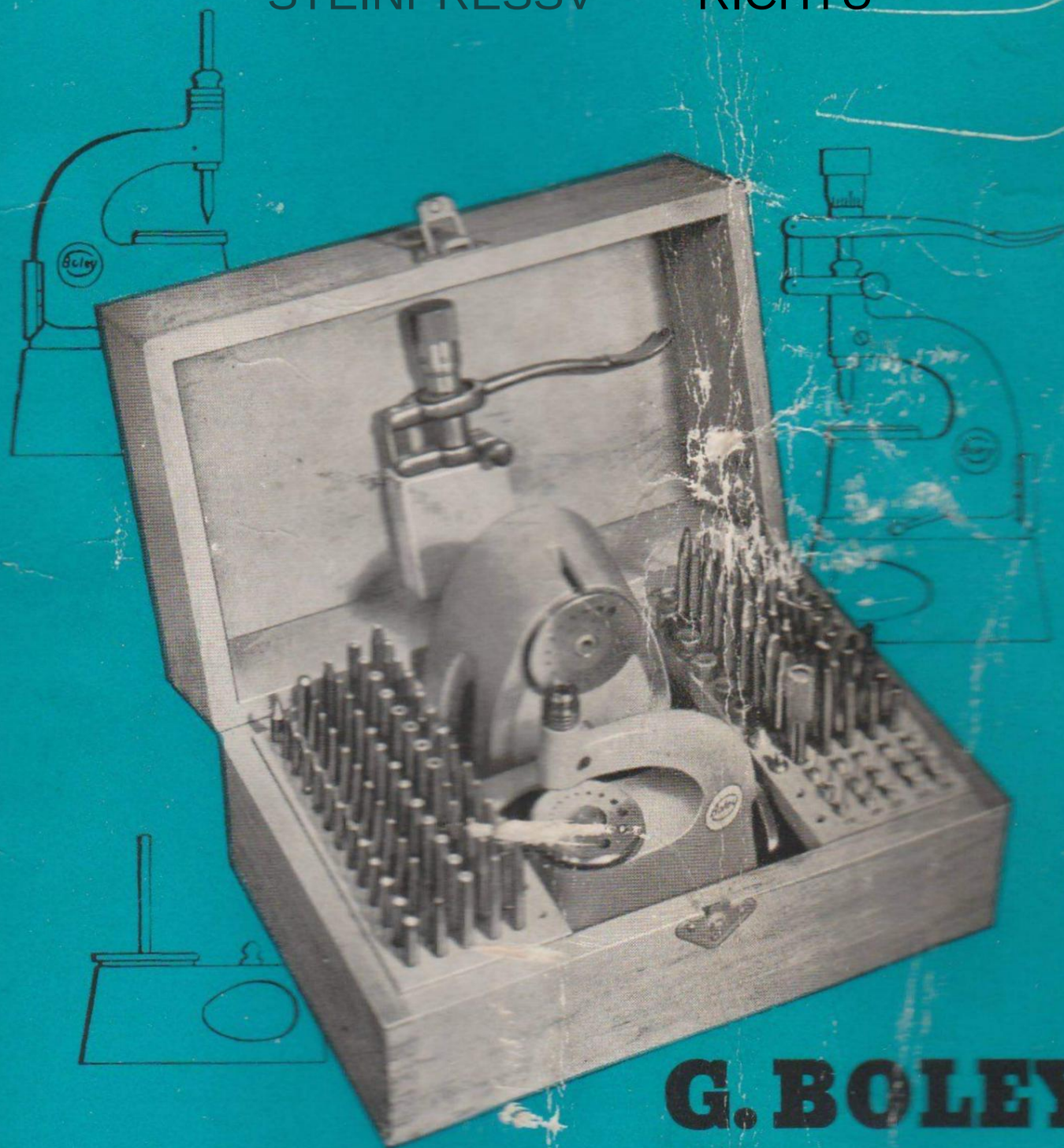




operation manual
DRIVENIE7MACHINE
vereinigt mit

STEINPRESSV

RICHTU NG



G. BOLEY

SPEZIALFABRIK FÜR UHRMA

SEIT 1870

CHERWERKZEUC-F

/NECKAR

ESSENTIALS!

G. Boley

B. 198b



The BOLEY- Triebnietmaschine

in the compilation 173gX

out of

Machine frame with punch guide and rivet
plate, anvil base, second, together
set rivet plate 173 gN, 114 hallmarks and
14 anvils, stone pressing device 173 gP,
15 friction awls from 69/100 to 299/100 with
Friction awl holder, hardwood box.

The instructions are also for them
Drive riveting machine 173gA valid



The order

the hallmarks,

anvil

and friction awls

in the wooden box is from the sketch on pages 4 and 5
visible. The rows of punches are arranged in steps
staggered to increase the overview and the production
to make it easier to remove the punches. To get involved
To avoid injury when removing the sharp punches,
the punch jack should be used. Put
Put each punch back in its place after use
Place back. Order in the punch box made easier
the work!

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so
so

○ 6 inserts for screw knockout punch No. 97.4

15 friction awls (with 1 holder)



Lineup

of the available punches, anvils and friction awls

Hallmarks..... set = 114 pieces,

Anvils..... set = 14 pieces,

Friction smoothing awls set = 15 pieces.

Hallmarks

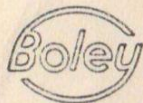
No.	Description	Outside 0 mm	Bohrgrs.- 0 mm
1	Centering punches		
	2.4 flat punches 2.5 without	0,6	
	hole 2.6 2.7 2.8 2.9 3 3.1 4 5	0,7	
	6	0,8	
	6.1	0,9	
	7 8	1,0	
	9 10	1,1	
		1,2	
12		1,3	
		1,4	
		1,5	
		1,7	
13		1,9	
		2,2	
		2,5	
		2,9	
		3,3	
		3,7	
		4,2	
13.5		4,7	



No. Description

External drillings.
0 mm 0 mm

14	Flat punches 14.5	0,3
	with bore 15 15.5 16	0,35
		0,4
16.5		0,45
17		0,5
17.5		0,55
18		0,6
18.5		0,65
19		0,7
19.5		0,75
20		0,8
20.5		0,85
21		0,9
22		0,95
		1,0
		1,1
23		1,2
24		1,3
25		1,4
26		1,5
27		1,6
28		1,7
29		1,8
30		1,9
31		2,0
32		2,1
33		2,2
34		2,3
35		2,4
36		2,5
37		2,6



No.	Description	Outside 0 mm	Bohrgrs.- 0 mm
39	Round punches	1	
40	without drilling	1,2	
41		1,4	
42		1,6	
43		1,8	
44		2,2	
45		2,6	
46		2,8	
47		3,2	
43		3,4	
49		3,7	
50,5		4,5	
51	Round punches		0,3
51.5	with bore 52 52.5 53		0,35
			0,4
53.5			0,45
54			0,5
54.5			0,55
55			0,6
55.5			0,65
56			0,7
56.5			0,75
57			0,8
57.5			0,85
58			0,9
59 60			0,95
61			1,0
62			1,1
			1,2
			1,3
			1,4



No.	Description	Outside mm	drilling size - 0 0 mm
63	Round punches		1,5
64	with bore		1,6
65			1,7
66			1,8
67			1,9
68			2,0
69			2,1
70			2,2
71			2,3
72			2,4
73			2,5
74			2,6
76	Funnel punches with		0,4
78	bore		0,6
80			0,8
82			1,0
83			1,2
85			1,6
90	Chisel punches (chisel width)	1,5	
92		4,7	
93	Shovel punches		
95	Grain punches		
97.4	screw deflection 0.4 hallmarks with		0,7
	replaceable 0.5 inserts		0,8
		0,6 1,0	
104	canned oz		
105	with flat countersink		



No.	Description	External drilling size - 0 mm 0 mm
112	Triangular punches	
118	Shoot rash punches	0,5
119		0,7
120		1,0
121		1,4
122		1,8
123		2,2

anvil
Set = 14 pieces

AM 5 flat	5,2	
AM 6 not drilled	6	
AM 7	7,5	
AM 8	9	
AM 9	11	
AMII flac	5,2	3
Drilled on 14	6	3,5
AM 12	7,5	4,5
AM 13	9	5,5
AM 15	11	7
AM 17 slotted wedge anvil	10	
AM 18 pointed wedge anvil	10	
AM21 anvil		
bulletproof	9	2/7
AM 27 grooved anvils	3	



No. Description	External drilling size - 0 now 0 mm
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No. 173 gR: **Reibglättahlen**

only to 173 gX

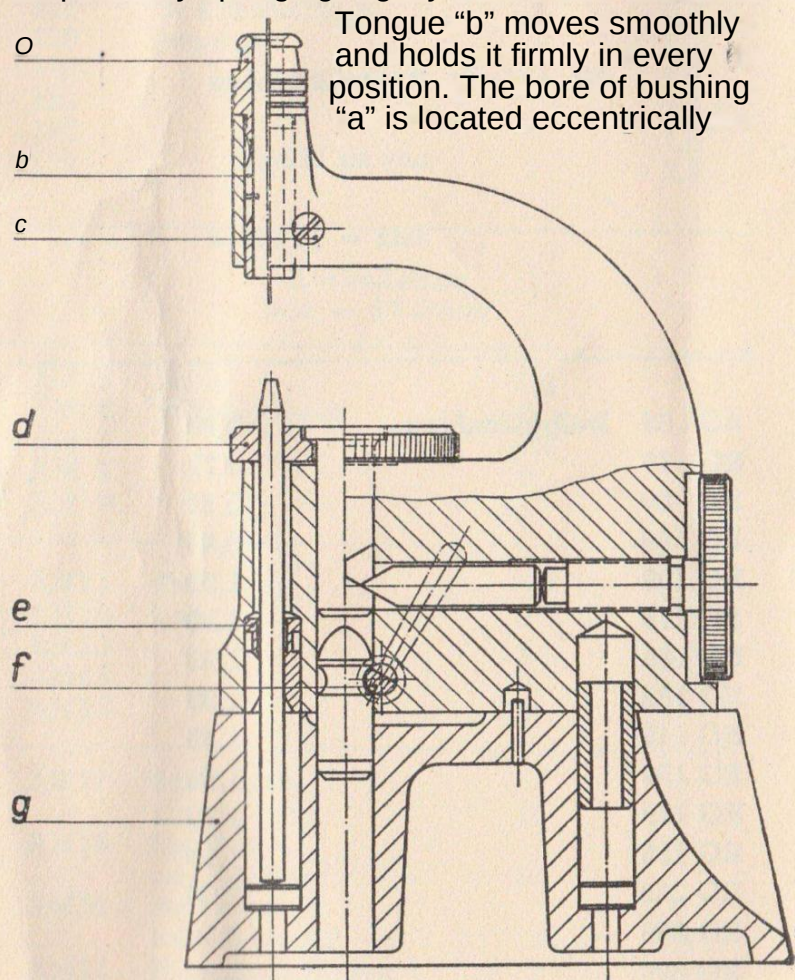
Set = 15 pieces

RG 69 Reibglättahlen	0,69
RG 79	0,79
RG 89	0,89
RG 99	0,99
RG 109	1,09
RG 119	1,19
RG 129	1,29
RG 139	1,39
RG 149	1,49
RG 159	1,59
RG 179	1,79
RG 199	1,99
RG 229	2,29
RG 259	2,59
RG 299	2,99



Frame and anvil base

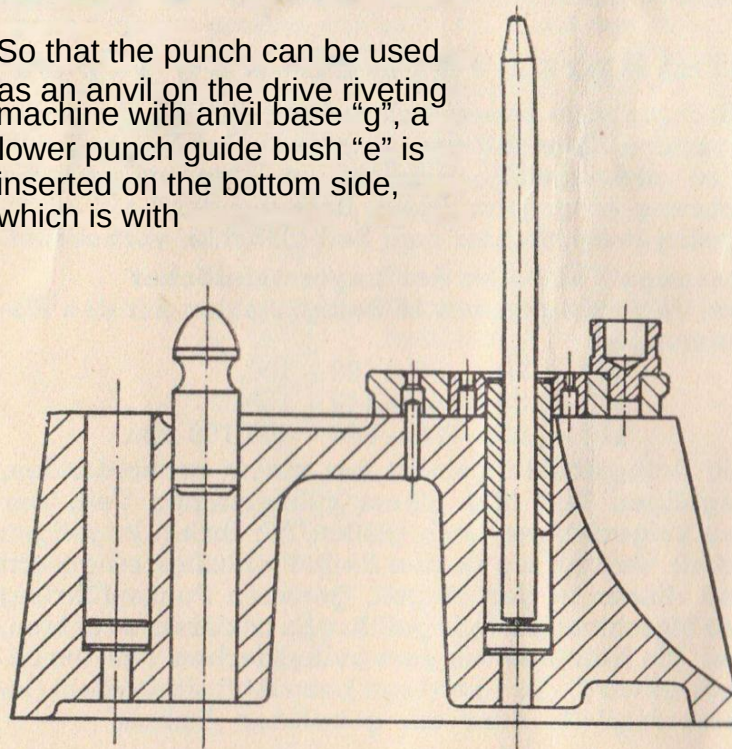
The replaceable punch guide bush "a" provides the punch by springing slightly inwards

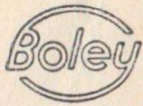


trish; After loosening the pressure screw "c", the bushing can be turned to precisely adjust the punching to the hole circle of the rivet plate "d". This arrangement enables replacement of guide bushing "a" and rivet plate "d" without sending the drive riveting machine to the factory.

The rivet plate "d" has a cylindrical recess in which it is clamped to the machine frame using a tension bolt and clamping screw. There is little play for lateral displacement, so that each of its bores can be adjusted to precise alignment using the centering guide bushing "a".

So that the punch can be used as an anvil on the drive riveting machine with anvil base "g", a lower punch guide bush "e" is inserted on the bottom side, which is with





the upper guide bushing "a" and the punch hole of the rivet plate "d" match in the axis.

The machine frame is clamped onto the anvil base using the dome device "f" so that it does not lift off the anvil base when the stone pressing device is used.

The anvil base can be used separately as a rivet bench or pointer anvil using the additionally supplied second rivet plate 173 gN (see illustration on page 13). The second rivet plate is assembled: hardened and polished steel plate on the outside with 18 working holes, brass disc on the inside with 9 working holes.

Stone pressing device 173gP

With their help, press-in stones can be used on the BOLEY drive riveting machine. The press-in stone is not held, but inserted into a cylindrical hole. This hole is prepared with a special reamer, the so-called friction awl.

Precise reaming of the bearing stone holes

15 smoothing awls with the dimensions are available

69 - 79 - 89 - 99 - 109, 119 -
129 - 139 - 149 - 159, 179 - 199
- 229 - 259 - 299/100 mm.

The friction awl consists of a cutting, conical part and a cylindrical part that smoothes the reamed hole. With their tapered shaft they are inserted into the reamer holder and this is guided in the long, precise punch guide of the machine frame. It is important to ensure that the reamer is guided through to the cylindrical part. The drive rivet plate or a drilled anvil serves as a base when reaming.

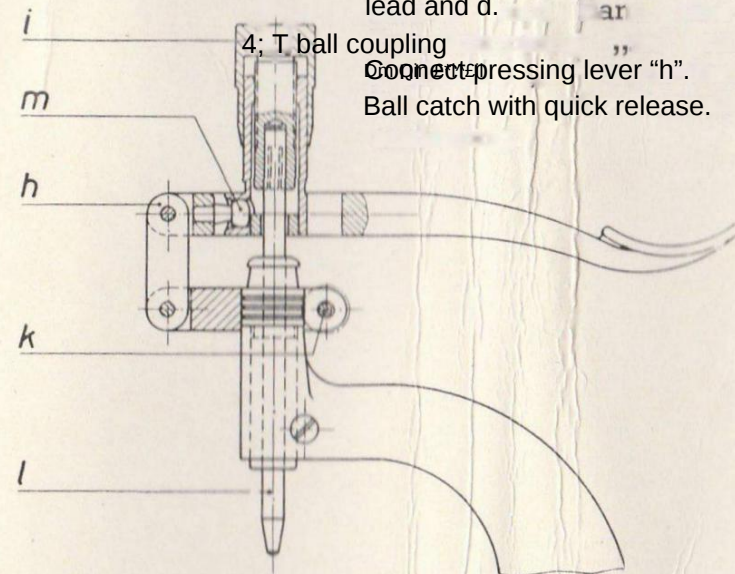


The success of the press-in work depends on the good condition of the friction awls. These are ground to the utmost precision and treated with the utmost care.

Pressing in the stones

The bearing and cover stones are 1 / ¹⁰¹ mm larger than the prepared holes so that they have a secure press fit. The stone pressing device 173 gP consists of a lever system "h" with a micrometer screw "i". The lever system is placed on the punch guide bush "a" and clamped using the knurled screw "k". As press stamp "1"

The large selection of punches that are inserted into the micrometer screw "i" are used. Flat punches are used for the flat watch jewels and the cover jewels, and a hollow punch is used for the curved balance jewels. Punch with a micro-adjusting meter screw first in about m" with the machine: nenges ar lead and d.





Stein absolut plan eindrücken

The pressing pressure is applied sensitively to the carefully designed hand lever. A suitable base or serves the base punches with an abutment in the anvil base serves as a base.

This means a much larger selection of the shape and size of the anvils for all types of work.

Press the stone in exactly as deep as required.

The depth adjustment of the press punch takes place on. 1000 mm has on the measuring drum the micrometer "uh" is to precise graduations that are easy to read. If the screw "P" pressed regulate whether the stone is higher or deeper in order to be then the required micrometer screw "I" can easily be adjusted to the desired size.

stone The replacement is broken. Remove the old stone with perhaps a plaster

clean the hole and press a new pressing stone of the same size into the hole.

Even a single setting stone can be easily replaced with a press-in stone. Is the version still good, you just rub away the stone layer. If the frame is already damaged, the entire frame is removed with a larger reamer. After being pressed in, the press-in stones sit completely securely, exactly flat and in the correct position Height.

The stone pressing is constructed so that faster on riveting on press work and around terms of h lei het is. No restrictions whatsoever in work] ridingsehab. With the pressing lever in place, both riveting and riveting can be carried out.