

Assembly instruction



Changing the insert

Disassembly

- Loosen clamp set (1 to 2 turns) and remove worn insert
- Clean pocket seat

Assembly

- Put new insert into pocket seat
- Press insert into the pocket seat while slightly tightening the clamp set
- Push insert against the drill, therefore place 0.03 mm feeler gauge between insert and drill
- Hold insert in position and tight down clamp set with recommended torque

Clamp set	Clamping set for	Tx	Torque (Ncm)
E4890	H 2006-... ..	6	70
E4991	H 3006-... ..	8	140

Torque wrenches

Drawing number	Version	Tx	Ncm
E5000	adjustable	6	20-120
E5001	adjustable	8	100-600
E5400-6	fixed	6	70
E5400-8	fixed	8	140

Ordering numbers for spare parts see pages 127-129