Adjustment instructions
HPC milling cutters

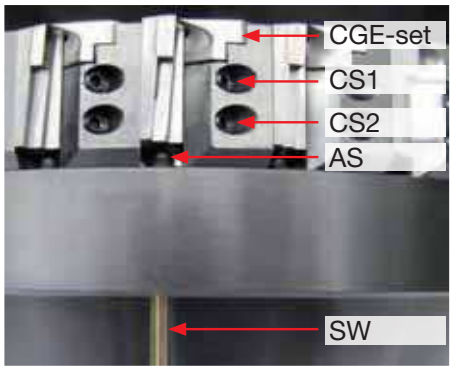
The chip-guiding elements are assembled at the factory!

1. Determine the highest chip guiding element.

Recommendation:
Place milling cutter in a setting fixture and rotate under the dial test indicator (DTI) and measure the individual chip guiding elements. (pict. 1)

2. Install the inserts and tighten the clamping screw (CS 1) to 15 Ncm.
Do not tighten the clamping screw (CS 2) !

3. Adjust the inserts in the axial direction with the adjustment screw (AS) to 10 µm below the final setting dimension.



Setting dimension = highest chip guiding element height +30 µm
The face run-out should be max. 2 µm.

4. Firmly tighten the clamping screw (CS 2) to 80 Ncm to perfectly align the insert then loosen again and re- tighten to 15 Ncm.

5. Tighten the clamping screw (CS 1) to 80 Ncm.

6. Adjust all inserts to the setting dimension. The face run-out should be max. 2 µm.
Tighten the clamping screw (CS 2) to 80 Ncm.

7. A control measurement has to be carried out after 10 minutes. If the face run-out is more than 2 µm, readjust the cutting plates without retightening the clamp screws.

Safety note:
In the event of damage the tool must be returned to the manufacturer for checking for technical safety reasons! Only original replacement parts must be used!

Recommended torque wrench:
E 6000 ➞ **adjustable** 10-80 Ncm Tx 6
Tx-bits 6 ➞ Bit Tx 6 for adjustable torque wrench E6000
Tx-bits 8 ➞ Bit Tx 8 for chip guiding elements (80 Ncm)
E 6001 ➞ **fixed** 15 Ncm Tx 6
E 6002 ➞ **fixed** 80 Ncm Tx 6