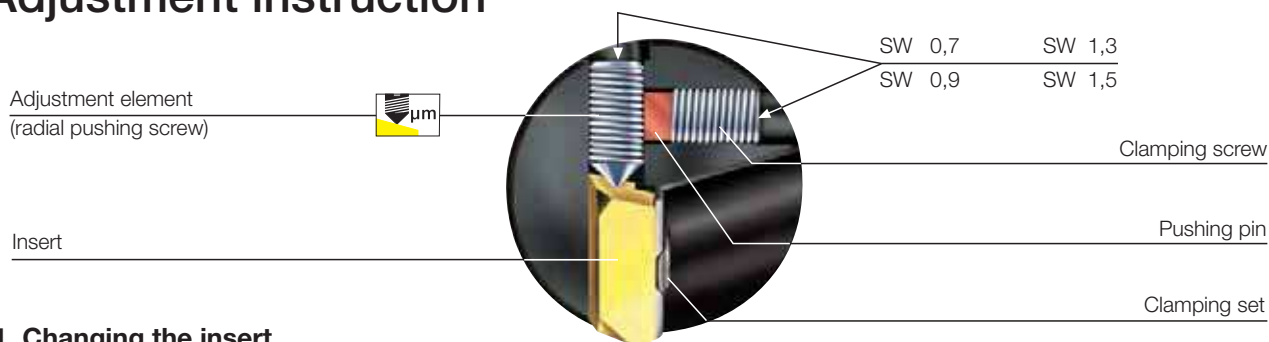


Adjustment system

Radial adjustment μ m-accurate adjustable

Adjustment instruction



1. Changing the insert

Disassembly

- Loosen clamping set (1 to 2 turns) and remove the worn insert
- Clean the insert pocket
- Turn out the adjustment element 1 to 2 turns

Assembly

- Put a new insert in the pocket seat
- Press insert into the pocket seat, keep under pressure and slightly tighten the clamp set:
 Torx 5 with 40 Ncm Torx 6 with 60 Ncm
 Torx 8 with 100 - 120 Ncm Torx 15 with 250 - 300 Ncm

2. Insert adjustment

- Clamp the holder in the presetting device
- Adjust the insert in diameter up to 0.05 mm smaller than target measure
- Tighten the clamp set
 We recommend to use our torque wrench:
 E 5000 adjustable 20 - 120 Ncm E 5400-5 fixed 45 Ncm for Tx5 E 5400-8 fixed 140 Ncm for Tx8
 E 5001 adjustable 100 - 600 Ncm E 5400-6 fixed 70 Ncm for Tx6 E 5400-15 fixed 345 Ncm for Tx15
- Adjust insert to the required machining diameter (It is not necessary to retighten the clamping set!)

Torque for clamping elements

Tool body Series	Clamping set	Torque (Ncm)	Torx size
H 1035	E 1100	45	Tx 5
H 1730	E 3441	45	Tx 5
H 2850	E 1085 / E 1112	70	Tx 6
H 3570	E 1060	140	Tx 8
H 4090	E 1040	345	Tx 15