



Inserts

Face Mills

End Mills

Die and Mold

Slotting

Thread Milling

Widia Cutters

Vintage Cutters

Accessories

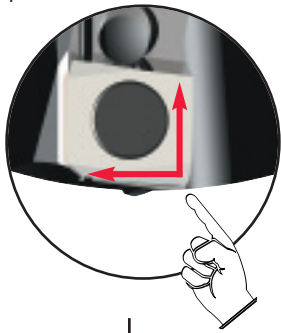
Technical Data

Mat'l Database

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Insert Loading Procedure

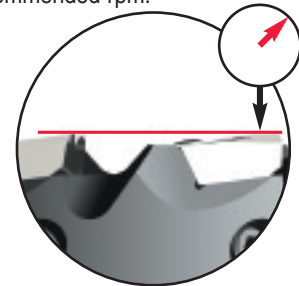
1. Clean insert and insert pocket seat.
2. Load insert – push insert against pin and axial pocket wall.



3. Tighten screw to a torque of 45 in.-lbs. (5 Nm).





4. Check the axial runout.
5. Do not exceed the maximum recommended rpm.



tool diameter inch (mm)	maximum axial runout	maximum rpm	clamp screw	clamp stud	inch coolant screw	metric coolant screw
2.5 (63)	10 um	20000	420.060	410.085	S-445 / (420.103)	125.025 / (420.104)
3 (80)	10 um	15900	420.060	410.085	S-458 / (420.121)	420.120
4 (100)	10 um	12750	420.060	410.085	420.162	420.160
5 (125)	10 um	10200	420.060	410.085	420.201 / 470.240	420.200 / 470.232
6 (160)	15 um	7950	420.060	410.085	420.241 / 470.241	470.233
8 (200)	15 um	6350	420.060	410.085	470.242	470.234
10 (250)	15 um	5100	420.060	410.085	470.243	470.235

Spares

		
clamp stud	clamp screw	hex wrench
410.085	420.060	170.003



Tightening torque of clamping screw is 45 in.-lbs. (5 Nm). To ensure proper cutting operation, all clamping screws must be held to this torque setting.

Torque wrench (KTW-45) and 3 mm hex bit (69709922164) can be purchased separately to ensure proper torque setting.