



Adjustment Instructions

Inserts

Face Mills

End Mills

Die and Mold

Slotting

Thread Milling

Widia Cutters

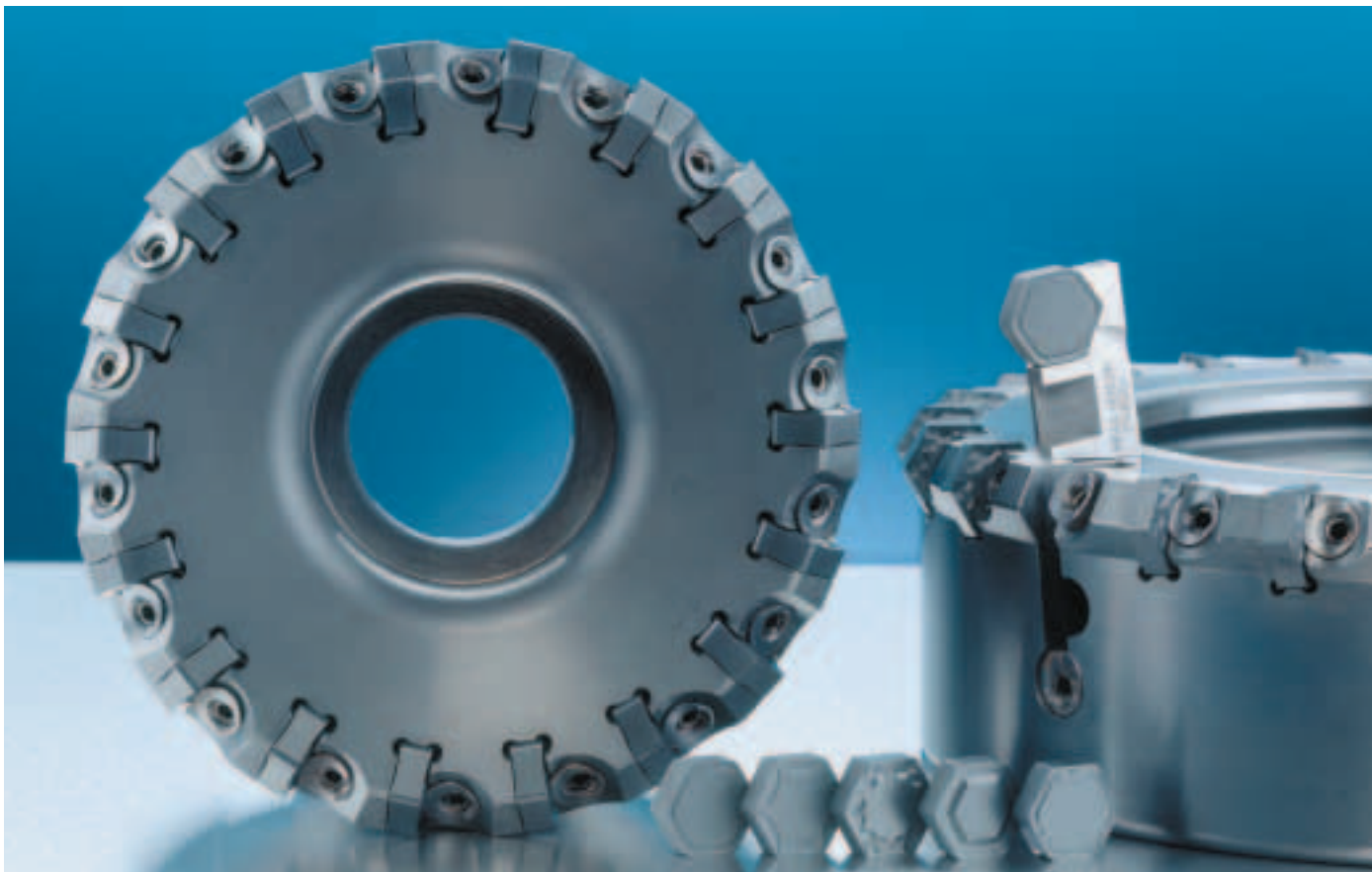
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- **Before being used for the first time**, the milling cutter must be carefully cleaned of anti-corrosive materials, dust, etc.
- The milling cutter should only be washed when all components have been dismantled.
- Only the double-threaded screws of the clamping or adjusting wedge should be lubricated with copper grease; all other components must have clean metallic surfaces.
- A torque wrench is recommended to tighten the double-threaded screws.
- When fitting indexable inserts on the milling cutter, ensure that they are inserted in the correct position in a clean insert seat, and that they are held in position during clamping.

For 45° roughing mills without anvils, the following rules must be observed:

- The double-threaded screws of the clamping wedges of the indexable inserts are first pre-tightened to approximately 18 in./lbs. and then tightened to a final torque of 65 in./lbs.

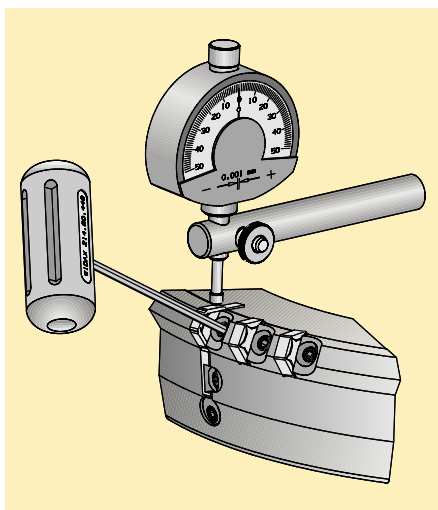
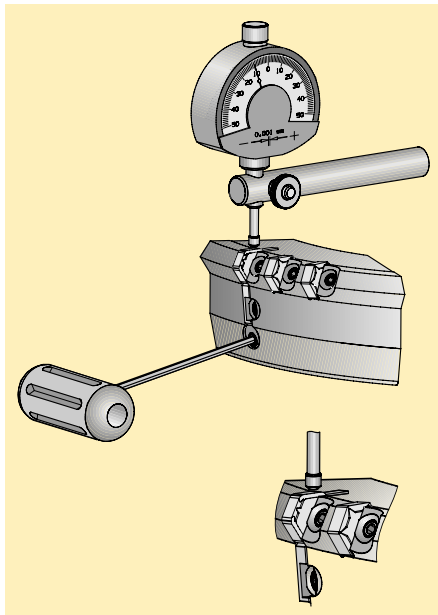
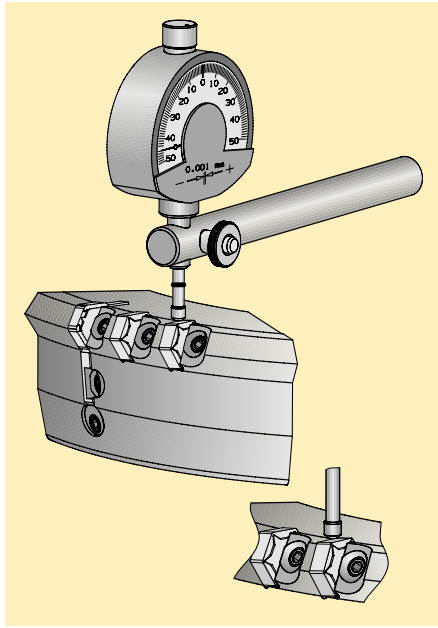
Attention:

At each tool adjustment the body, the indexable inserts and spare parts must be checked and replaced, if necessary.

Before each tool use the double-threaded screws of the indexable inserts and the stops must be tightened in the specified order to a torque of 65 in./lbs. In addition, even if the anvils have not been adjusted, the double-threaded screws of the adjusting wedges must be checked to see if these have been tightened to a torque of 25 in./lbs. If not, they must be re-tightened to this torque.



Insert Setting Procedure



This procedure is to be used on all 60° lead roughing/finishing mills using the unmarked roughing anvil, the finishing anvil (marked ●), and the corrected edge anvil (marked ◐). These steps must be followed when adjusting the cutters for finishing inserts.

- 1.) Clean all insert pockets.
- 2.) Install all wedges and anvils. Torque the anvil lock wedge screw to 25 in./lbs.
- 3.) Install all inserts, making sure they are seated properly in the pocket, and torque the insert lock wedge screws to 25 in./lbs.
- 4.) Torque the wedge screws for all fixed pocket inserts to 65 in./lbs.
- 5.) Loosen the anvil insert wedge screw and the anvil lock wedge screw.
- 6.) Pressing the insert into the anvil pocket, adjust the anvil to .008 - .012 below the fixed pocket inserts.
- 7.) Torque the insert lock wedge screw and the anvil lock wedge screw to 25 in./lbs.
- 8.) Adjust the axial position to .0010 - .0015 above the fixed pocket inserts.
- 9.) Loosen the anvil insert lock wedge screws and then re-torque to 25 in./lbs.
- 10.) Adjust the axial position to the final dimension, .0015 - .0020 above the highest fixed pocket insert.
- 11.) Torque the insert lock wedge screws and the anvil lock wedge screws to 65 in./lbs.
- 12.) Conduct a final check of the axial run-out and position.

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