

Instruction manual for PMR type

1. Process of clamping the inserts

①Cleaning the insert seats

Please clean the insert seats with high pressure air or a brush.

If foreign particles are clamped between the insert and the insert seat, problems may occur such as, run out of the cutting edges and movement of the inserts during cutting.



②Clamping the inserts

Ensure the flat locating face of the insert makes solid contact with the locating surface of the insert seat.

Clamp the insert tightly with the screw and wrench while pushing the insert toward the locating surface of the insert seat.

☆Clamping torque :

$$\begin{aligned} \text{[PMR4 type]} \quad 3.5 \text{ N} \cdot \text{m} &\doteq 35.7 (\text{k g f} \cdot \text{c m}) \\ &\doteq 2.59 (\text{f t} \cdot \text{l b}) \end{aligned}$$

$$\begin{aligned} \text{[PMR6 type]} \quad 5.0 \text{ N} \cdot \text{m} &\doteq 51.0 (\text{k g f} \cdot \text{c m}) \\ &\doteq 3.70 (\text{f t} \cdot \text{l b}) \end{aligned}$$



2. Wrench information

①(T/Driver) shaped wrench

PMR type uses the TORX PLUS/TORX type clamp screw. The attached (T/Driver) shaped wrench is for exclusive use of this screw.

To get the best performance of the TORX PLUS/TORX screw and to keep the wrench hole life of the screw head long, please use the attached wrench.

②Hexagonal wrench

The attached hexagonal wrench is used to clamp the shim seat.

3. Caution

Please use original parts. If other parts (screws, shim seats etc.) are used, the performance will be inferior and safety can not be assured .