

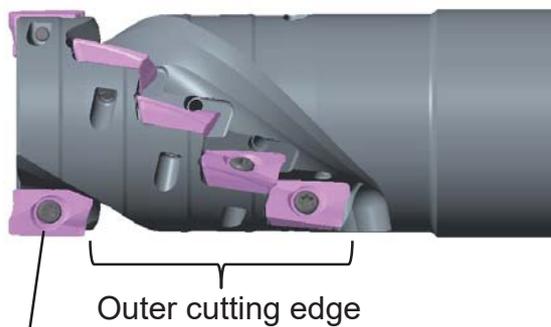
1. Possible setting inserts

● For bottom cutting edge

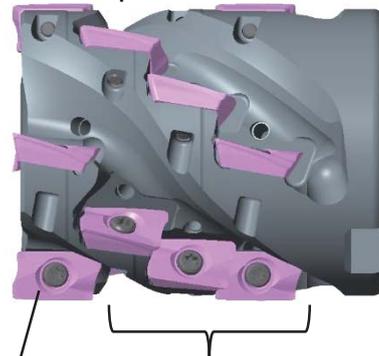
You can use less than R2.0mm(R.079") nose-radius inserts. If you want to use more than R2.4(R.094") nose radius inserts, you should process the holder to prevent holder and workpiece interference.

● For outer cutting edge

We recommend using R0.8(R.031") nose-radius inserts. You can use R0.4(R.016") or R0.2(R.008") nose-radius inserts too, but the tool life may slightly decrease. Please don't use more than R1.0(R.039) nose-radius inserts to get smooth workpiece wall.



Bottom cutting edge



Bottom cutting edge

2. Clamp screw for insert

Please use the screw "TPS25" for 20mm and .750" cutting edge diameter holders. Please use the screw "TPS25-1" for more than 25mm or 1.000" cutting edge holders. Please replace the clamp screws periodically because they are consumption parts. Please Don't use the clamp screw whose TORX-Plus drive hole is damaged.

3. How to set the insert

1. Prior to locating the insert, air blow the insert seat.
2. Press firmly down on the insert when tightening the clamp screw.
3. Use anti-seize cream to prevent the screw from seizing, clamp the screw by clamp torque 1.0N·m(8.91lbf-in).
4. Ensure that there is no space between the insert and the insert seat.

4. etc

- Please refer to tools-news about the cutting conditions.
- There is a danger of burn, if it is touched soon after cutting is done.
- Please don't touch the cutting edge of the insert with bare hand to prevent injury.
- Please tighten again with the attached wrench afterwards if you use an electric driver.