

Instruction manual for WSF406W

This cutter is equipped with adjustment mechanism on all insert seats. When the cutter is shipped, it is tightened to the maximum adjustment position, so please loosen it before use.

1. Procedure for inserts setting

- ① Before setting the insert, clean the seat using air blow or brush. (Fig.1)
- ② Use the Wrench provided to loosen the screw on the adjustment mechanism. (1-1.5 rotation)
- ③ While holding the insert to the seat, tighten the clamp wedge screw using the wrench provided.



Fig1, Cleaning area

2. Procedure for inserts adjustment

- ① Clamp inserts (Temporary)
 - Set the inserts, make sure you have loosened the screws on the adjustment mechanism before it is used.
※The standard for loosening screws is 1 to 1.5 rotations of the wrench.
 - Temporarily tighten the insert at 1.0N-m (0.74ft-lbf).
 - ② Adjustment of cutting edge height
 - Turn the screw of the adjustment mechanism and adjust the height of cutting edge.
※Adjust to 0.010mm before the target height of cutting edge.
 - ③ Clamp inserts
 - Tighten the insert to 6.0N-m (4.43ft-lbf).
 - ④ Fine tuning
 - To fine adjust, turn the screw of adjustment mechanism and adjust the insert's height.
 - The run out of the cutting edge should be 0.010mm or less.
- ※After tightening, the height of cutting edge will protrude by about 0.010mm that compared to the temporary tightening.

3. Other

- Please use our genuine parts.
If you use parts other than our genuine parts, there is a possibility of performance degradation or safety problems.

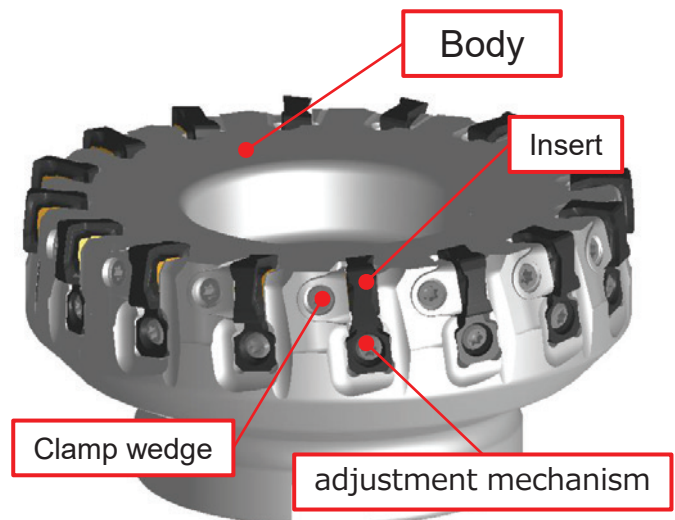


Fig2, set condition