

# Instruction manual for SPX

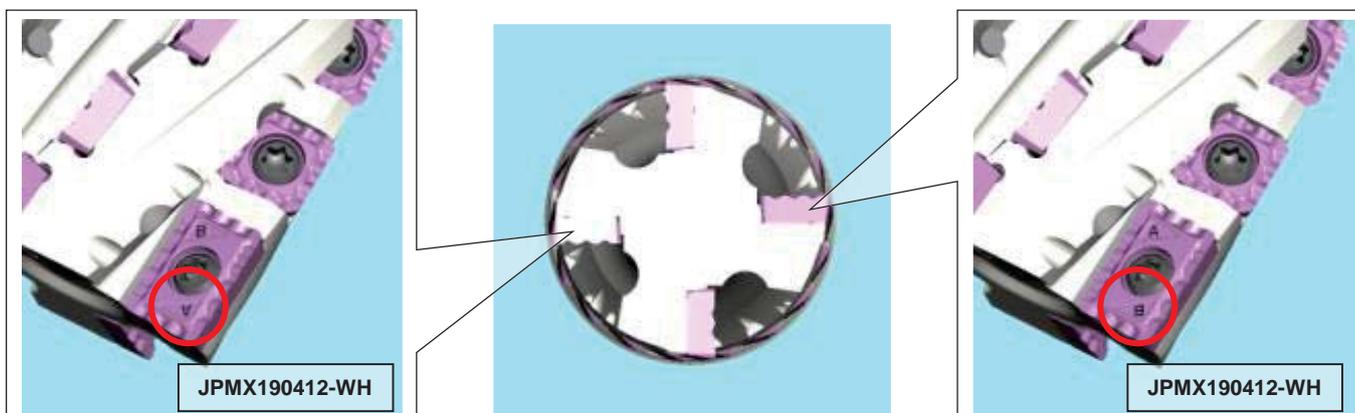
## 1. How to locate the insert

1. Prior to locating the insert, please air blow the insert seat.
2. Press firmly down on the insert when tightening the clamping screw.
3. To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded. (Clamp Torque=7.5Nm)
4. Ensure that there is no space between the insert and the insert seat.
5. SPX uses three types of insert.

Bottom inserts : JPMX190412-WH, MPMX120412-WH  
--- Each 2 pieces

Peripheral inserts : SPMX120408-WH  
--- 20 ~ 40 pieces

6. "JPMX190412-WH" has two different major cutting edge of A and B in one insert.  
If you set A corner in one seat, please set B corner in another seat.  
You can get better performance about wall shape and chip control. (Good cutting performance will be achieved even if the same corners are set in the 2 bottom seats.)



## 2. Parts

1. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured .
2. Please replace the clamp screw periodically since they are consumption parts.  
Don't use the clamping screw whose TORX hole is damaged or thread wear is progresses.

## 3. etc

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