

# QEJ029 GYM25 R / L D - ※※ Assembly & Use Instruction

**A**

**Modular Blade**

Long Medium

Holder

GYHR2525M00 - **M25R**  
GYHRUS16D00 - **M25R**

Insert

GY2M0300 **F** 040N-MM  
GY2M0318 **F** 030N-GM

**M25R** **F** 20-060  
**M25R** **F** 12-060

**B**

Screws  
Wrench  
Torque

[Side] screws

**C**

Screws: TS55  
Wrench: **TKY25D**  
Torque : 5.0 Nm  
44 lbf-in

[Front] screws

Please tighten the TS55 screws in order of [Side] → [Front].

**D**

Min. Dia.  $\phi 60\text{mm}$  (2.362inch)

Max. Dia.  $\phi 85\text{mm}$  (3.346inch)

Ex) marked as  $[\phi 60 \sim \phi 85]$

Please use within these diameters at the first grooving. After the first grooving, there are no limit of cutting diameter.

Attention ) Please use it in recommended cutting condition.

While using exceeded cutting condition, The modular blade might be damaged as shown. And with the chatter vibration will make similar damage even if using it short time.

normal contact surface

damaged surface

**Attention) Be careful enough so that there is a sharp part in the product when you set it.**

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