

# The Flow of Setting Inserts on NF10000

1. Before setting inserts, clean the pockets and make sure that there are no dust on the pockets.

(Photo 1)

Note: it is very dangerous that dust, chip or other things remain on the pockets.

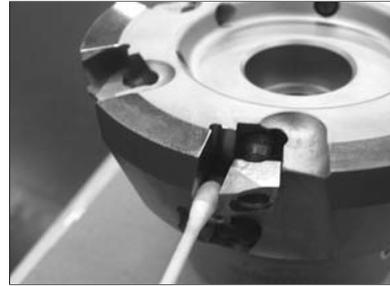
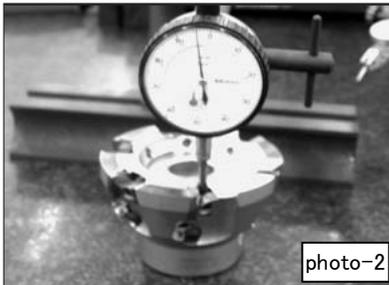


PHOTO-1 Cramping Wedge

2. Tighten the screws of the cramping wedges lightly and put the copper edge of the indicator on the inserts softly.

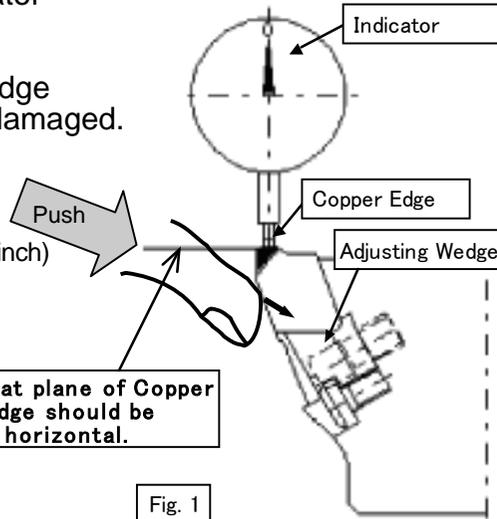
Note: Be careful putting the copper edge on the inserts or the inserts may be damaged.

3. Adjust the position of inserts to 0.05mm (0.002 inch) lower height than the standard height by rotating the screws of the adjusting wedges (photo-2)



The flat plane of Copper Edge should be horizontal.

Fig. 1



4. Set all inserts lightly as shown above. The order of this process is not important. You can set the inserts next to next. (photo-3)

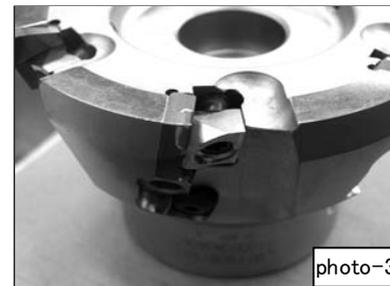


photo-3

5. Loosen the screws of the cramping wedges and re-tighten them tightly. The order of setting inserts tightly is IMPORTANT. The order should be as diagonal as possible. The example of the order for 6 pockets is shown in Fig. 2

Torque of tightening the screws of the cramping wedges should be between 7.8 and 8.8 Nm. (between 80 kgfcm and 90kgfcm) (Photo-4) When tightening, put your finger on inserts lightly. (Photo-5)

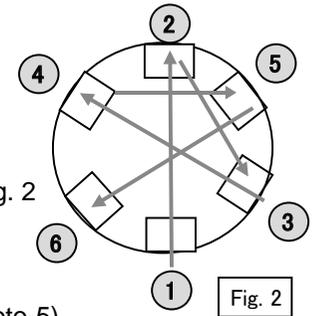


Fig. 2

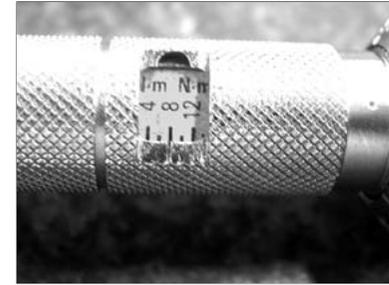


photo-4



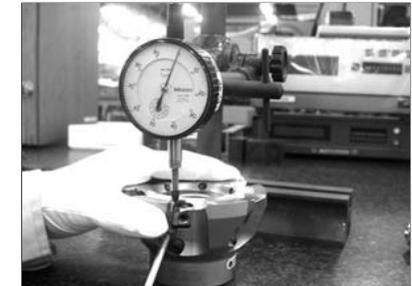
photo-5

6. Finally, tighten the screws of adjusting wedges and adjust the position of the inserts to the standard height. The runout of height of the inserts should be lower than 0.005mm (0.0002 inch).

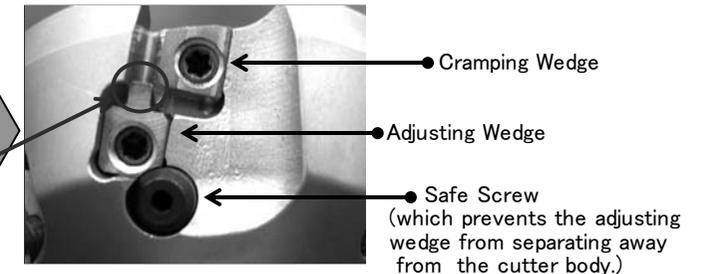
If too much tightening causes too high position of the insert, you have to loosen the screw of cramping wedge.

If you loosen the screw of cramping wedge, height of the inserts of other pockets may be changed. In this case, please redo this flow from the start.

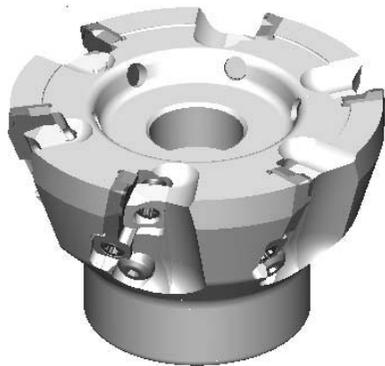
After tightening the screws of the cramping wedges, the position of the inserts may be about 0.01mm (0.0004 inch) higher than before. So, we recommend adjusting by tightening adjusting wedges after tightening the screws of cramping wedges.



These wedges and safe screw keep the inserts on the body. You do NOT have to re-tighten the screws of the adjusting wedges even if they become loose when using. Because the safe screws keep the adjusting screws on the cutter body and because the inserts are cramped firmly by the cramping wedges.



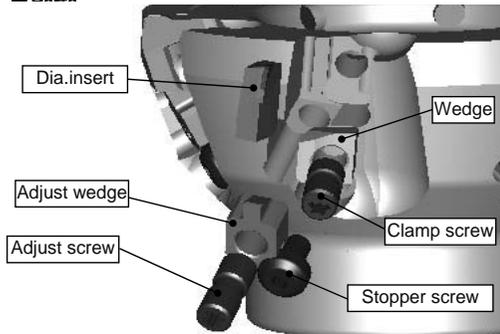
# For aluminium workpiece For high-speed milling NF10000Type 《Manual》



## Characteristic

- Anti-expulsion inserts system
- Axial runout adjusting wedge
- Rmax ;Max.2μm (Low cutting resistance shape;Minor cutting edge 3mm)
- You can get the same diameter after regrinding.  
(please read "Attention in use")

## Parts



Wedge	Clamp screw	Adjust wedge	Adjust screw	Stopper screw	Wrench
CWAF10R1	LS10T	CWAF10N	LS15T	CSAF10	TKY25T

Thank you for purchasing our high-speed face milling cutter for aluminium workpieces.  
To make the use of cutter, we have prepared this manual and that you will read it carefully and fully enjoy the best performance of the cutter.

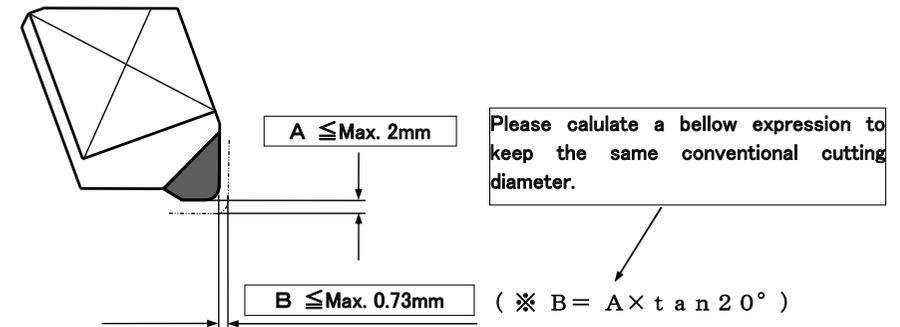
## Attention in use

### Maximum revolution and wedge clamp torque

Cutter diameter	Max. RPM	Clamp Torque
φ 80	16,000 min <sup>-1</sup>	8 [N·m]
φ 100	14,000 min <sup>-1</sup>	80[kgf·cm]
φ 125	12,000 min <sup>-1</sup>	6[Ft·Lb]

### Regrinding ; Max.2mm (Bellow figure)

#### Regrinding



■ Please set the inserts within 0.005 (aim) of axial runout.

## Specification of the insert

Shape	Tolerance	Pereraiption
	C	GDCN2004PDFR3

- 〈Caution〉
- Don't loose the stopper screws (The screws are fixed with adhesive agent)
  - Cutting edge is very sharp and dangerous, so please handle with care.
  - When you change inserts, please clean the seats with high pressure air.