

GYDR/L***90 - M25L / R Assembly Instruction

A

Holder

Screw
GY06013M x 1pc.

TKY25D TKY30R
Wrenches

Screws
TS407 x 4pcs.

①

GYDL***90 M25R

Modular Blade

Use blade)

GYM25R/L-D12
GYM25R/L-E12
GYM25R/L-F12
GYM25R/L-G14
GYM25R/L-H14
GYM25R/L-J14

GY M25R A - F 12

② ③

Insert

GY2M0300 F 040N-MS
GY2M0318 F 030N-GM

④

Note1) ③ and ④ are changed by the insert size.

B

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

Side Screws
(2 screws)

Note2) ① and ② should be matched.

C

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

Front Screws
(2 screws)

Note3)
Please tighten the TS55 screws
in order of [Side screws] → [Front screws].

D

Note4)
Please clean the insert-seat
before installing the insert.

Note5)
③ and ④ should be matched.
(See caption A)

E

Screw : GY06013M
Wrench : TKY30R
Torque : 6.0 Nm
53 lbf-in

Note6)
Don't tighten this screw [GY06013M]
without installing the insert.
Modular blade might be damaged.

F

Complete.

Good NG

Note7) [GY06013M] is inclined.
Ensure that the wrench is perpendicular
to the screw tightening.

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