

A

TKY25D TKY30R Wrenches

Screw GY06013M x 1pc.

Screws TS55 x 5pcs.

Holde

Modular Blade

GY **M25R** A - F 20
 GY **M25R** A - F 12

Long (5 holes) Medium & Short (4 holes)

Insert

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

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

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

B

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

Side Screws (3 screws)

Long Modular Blade (5 holes)

B'

Side Screws (2 screws)

Medium & Short Modular Blade (4 holes)

Note2) ① and ② should be matched. (See caption A)

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.

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

Good NG

F

Complete.

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