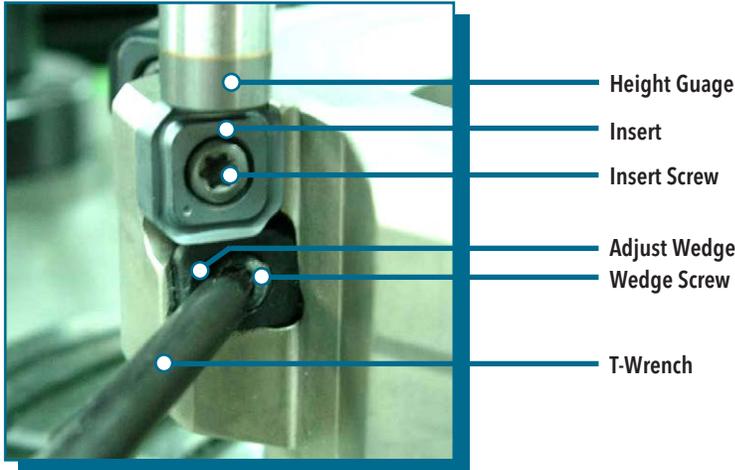
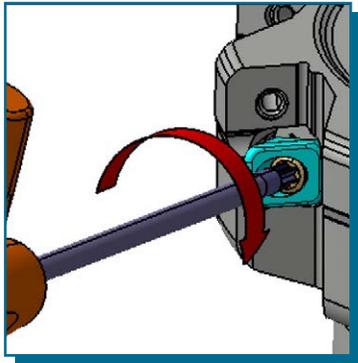


AXIAL ADJUSTMENT SET-UP

Component Identification:



1 Rotating the wedge screw clockwise, tighten the wedge to the utmost.



*Please note that you should tighten the wedge until it reaches the bottom of the pocket. Avoid using too much force.

2 Mount the insert.



*Tighten the insert screw completely (35in. lbs.)

3 Upon tightening of inserts, measure the cutter run-out, select the highest insert as a datum.



*Do not damage the insert edge on gauge setting.

Continue set-up on next page...

AXIAL ADJUSTMENT SET-UP (CONTINUED)

4 Set up the cutter height, raising one insert by turning the wedge screw counter-clockwise.



*Adjust 0.01mm (.0004") at least.

5 Adjust AXIAL RUNOUT of the remaining inserts the same way as the original insert.



*Note: The adjustable amount should not be over 0.1mm (.004").

*GAUGE user guide.



5.1 Adjust AXIAL RUNOUT by rotating the wrench gradually until it meets the 0.005mm (.0002") range.



5.2 When beyond the acceptable range. Please reset it with steps (1), (2), and (5).



6 RUNOUT adjustment is completed. (Do not clamp the insert screw any further once it is fixed.)



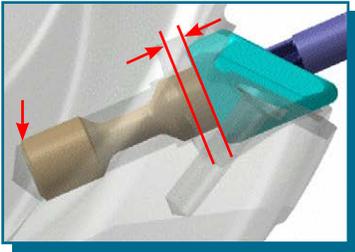
Continue set-up on next page...

AXIAL ADJUSTMENT SET-UP (CONTINUED)

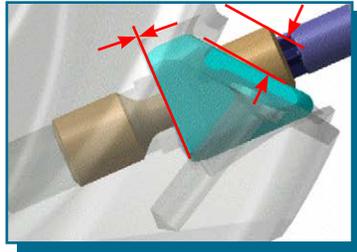
Note on Setting:

- When you change the insert corner, please start over from 1st step.
- You must remove dirt & debris on the surface of inserts or pockets before mounting inserts as this product requires high accuracy.
- When you reassemble the wedge after completely separating it, please put it together as in picture (3).

1 **NO**
Gap between wedge and pocket bottom with screw bottomed out.



2 **NO**
Wedge bottomed out with screw excessively sticking out of top of wedge.



3 **YES**
Wedge bottomed out and screw is below wedge.

