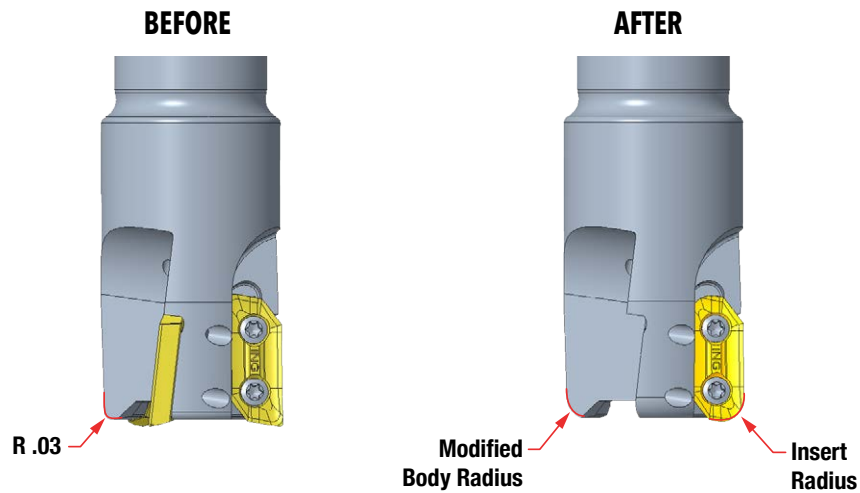


CUTTER BODY MODIFICATION FOR LARGE RADIUS INSERTS

When using an insert radius larger than indicated per Insert IC, be sure the cutter body does not protrude beyond the trailing edge of the insert. If it does, the housing corner can be modified on a lathe or grinder by enlarging the corner radius.



Insert Size	Modify Cutter Body if Insert Radius Exceeds	Insert Radius	Modified Body Radius
14 MM	.062"	0.079	0.075
		0.093	0.090
		0.118	0.115
		0.125	0.120
		0.157	0.155

Insert Size	Modify Cutter Body if Insert Radius Exceeds	Insert Radius	Modified Body Radius
25 MM	.093"	0.125	0.100
		0.157	0.125
		0.197	0.175

Insert Size	Modify Cutter Body if Insert Radius Exceeds	Insert Radius	Modified Body Radius
33 MM	.125"	0.197	0.100
		0.250	0.125

TECHNICAL INFORMATION

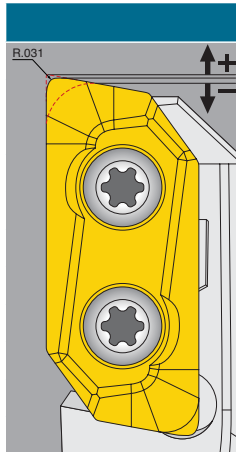


Insert Loading Instructions:

First lightly tighten both insert screws.
Next, completely tighten the bottom screw to specified torque.
Finally, tighten the top screw to specified torque.

Insert Size	Torque Specification
14 MM	17.7 in lb (2.0 Nm)
25 MM	35 in lb (4.0 Nm)
33 MM	44 in lb (5.0 Nm)

INSERT RADII OFFSET COMPARISON



Insert Part Number	Corner Radius	Offset
Insert -04	0.015	0.004
Insert -05	0.020	0.003
Insert -08	0.031	0.000
Insert -16	0.062	-0.007
Insert -20	0.079	-0.011
Insert -24	0.093	-0.014
Insert -30	0.118	-0.020
Insert -32	0.125	-0.022
Insert -40	0.157	-0.029
Insert -50	0.197	-0.039
Insert -64	0.250	-0.051

The lengths listed in the details of each cutter are created using the -08, 0.031" corner radius insert.

When using other inserts of different corner radii, use the above table to find the approximate linear offset, so as to adjust your machine offsets if needed.