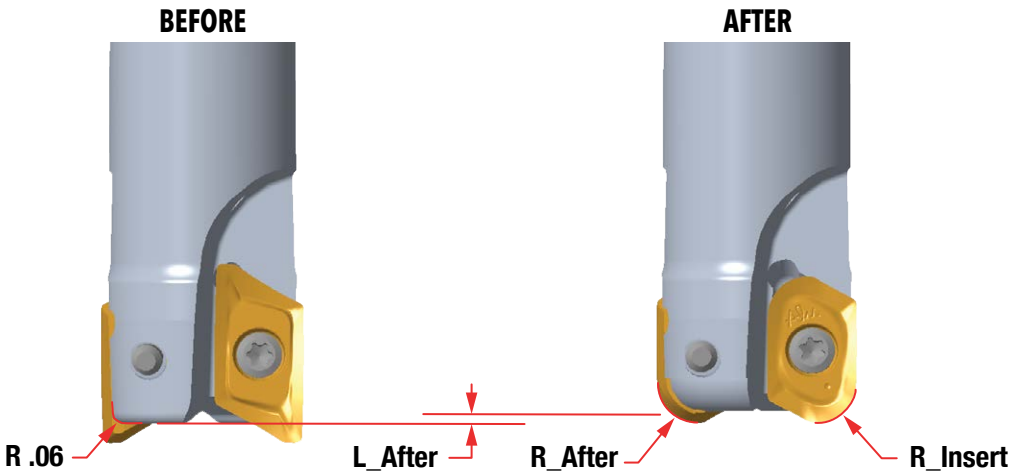
HIPOS ALU CUTTER BODY MODIFICATION FOR LARGE RADIUS INSERTS

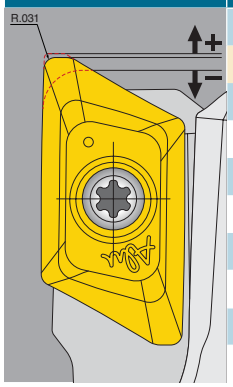
When using an insert radius larger than indicated per Insert IC, be sure the cutter body does not protrude beyond the trailing edge of the insert. If it does, the housing corner can be modified on a lathe or grinder by enlarging the corner radius.



Insert Size		R_Insert	L_After	R_After
16 MM	Insert -30	0.118	0.015	0.095
	Insert -32	0.125	0.020	0.100
	Insert -40	0.157	0.035	0.130
	Insert -50	0.197	0.050	0.165

Insert Size		R_Insert	L_After	R_After
22 MM	Insert -30	0.118	0.020	0.145
	Insert -32	0.125	0.025	0.155
	Insert -40	0.157	0.045	0.180
	Insert -50	0.197	0.075	0.215
	Insert -64	0.250	0.110	0.255

HIPOS ALU INSERT RADII OFFSET COMPARISON



Insert Part Number	Corner Radius	Offset
XEVT...04	0.015	+0.008
XEVT...08	0.031	0.000
XEVT...12	0.047	-0.008
XEVT...16	0.062	-0.015
XEVT...20	0.079	-0.023
XEVT...24	0.093	-0.030
XEVT...30	0.115	-0.041
XEVT...32	0.125	-0.045
XEVT...40	0.157	-0.061
XEVT...50	0.197	-0.080

OAL and LF cutter dimensions are measured using the R.031" insert.
When interchanging inserts with other corner radii, the OAL and LF dimensions will change and an offset will need to be utilized.