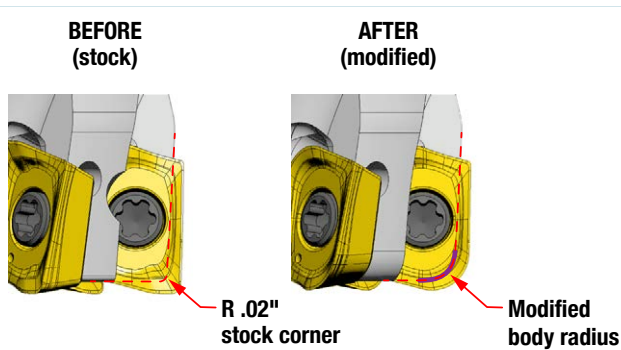


HI-POS⁺

09 CUTTER BODY MODIFICATION FOR LARGE RADIUS INSERTS

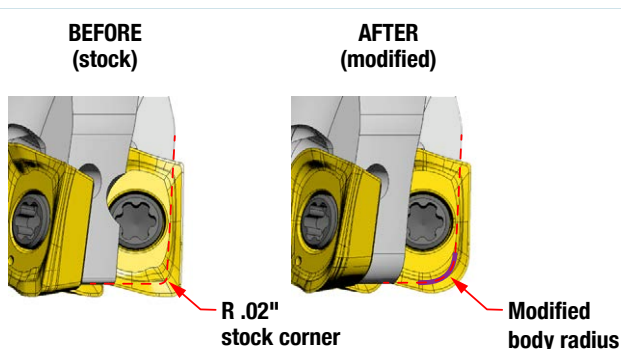


Insert Size	Modify Cutter Body If Insert Radius Exceeds	Insert Radius	Modified Body Radius
9mm	.062"	0.078	0.050
		0.120	0.100

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.

HI-POS⁺

13 CUTTER BODY MODIFICATION FOR LARGE RADIUS INSERTS

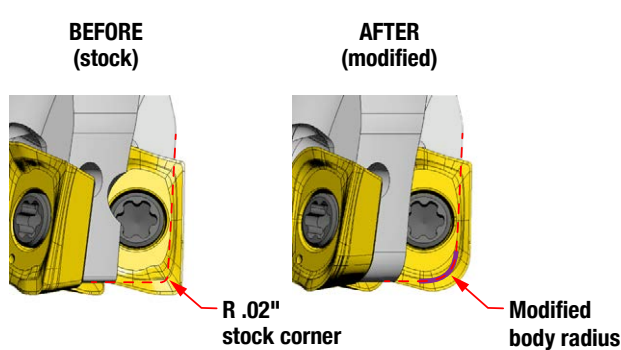


Insert Size	Modify Cutter Body If Insert Radius Exceeds	Insert Radius	Modified Body Radius
13mm	.078"	0.093	0.080
		0.125	0.100
		0.156	0.150

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.

HI-POS⁺

17 CUTTER BODY MODIFICATION FOR LARGE RADIUS INSERTS



Insert Size	Modify Cutter Body If Insert Radius Exceeds	Insert Radius	Modified Body Radius
17mm	.093"	0.125	0.110
		0.156	0.110
		0.187	0.110
		0.250	0.200

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.