

A

TKY15D TKY30R
Wrenches

Screw
GY06013M x 1pc.

Screws
TS55 x 5pcs.

①

GYHR2020K00 - **M20R**
GYHRUS12C00 - **M20R**

Holder

Modular Blade

GY **M20R** B - F 18
GY **M20R** A - F 10

② ③

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

Insert

④

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

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

B

Screws : TS407
Wrench: TKY15D
Torque : 3.5 Nm
31 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 : TS407
Wrench: TKY15D
Torque : 3.5 Nm
31 lbf-in

Front Screws (2 screws)

Note3)
Please tighten the TS407 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.

Good **NG**

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

F

Complete.

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