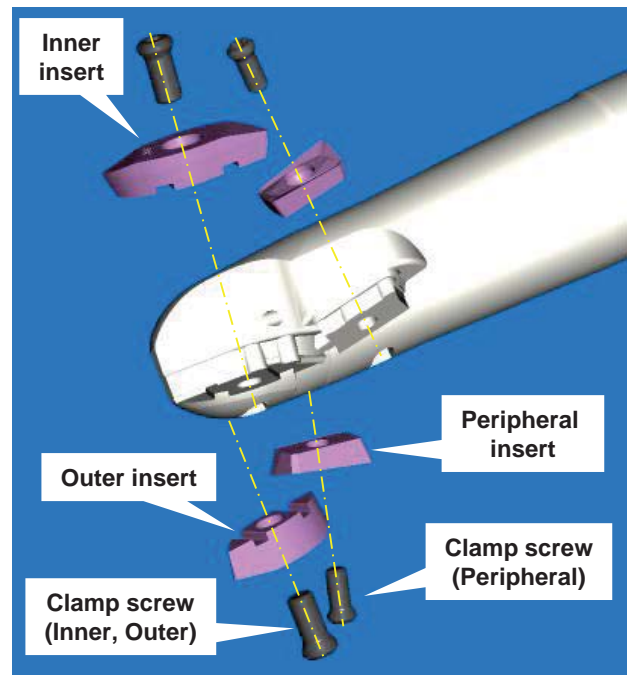


Instruction manual for SRM2

1. How to locate the insert

1. Prior to locating the insert, air blow the insert seat.
2. Press firmly down on the insert when tightening the clamping screw.
3. To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded.
4. Ensure that there is no space between the insert and the insert seat.



The clamping screw & the clamping forces.

Cutter diameter	Insert screw (Inner, Outer)	Wrench (Inner, Outer)	Clamping force (Nm)	Insert screw (peripheral)	Wrench (peripheral)	Clamping force (Nm)
Φ16	TS25H	TKY08D	1.7	---	---	---
Φ20	TS32	TKY08D	2.0	TS25	---	1.0
Φ25	TS43	TKY15T	6.0	TS25	TKY08F	1.0
Φ30·32	TS55	TKY25T	7.5	TS43	TKY15F	3.5
Φ40	TS6S	TKY30T	10.0	TS43	TKY15F	3.5
Φ50	TS6	TKY30T	10.0	TS43	TKY15F	3.5

2. Parts

1. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured .
2. Please replace the clamp screw periodically since they are consumption parts.
Don't use the clamping screw whose TORX hole is damaged or thread wear is progresses.

3. etc

1. Please refer to tools-news about the cutting conditions.
2. There is a danger of burn, if it is touched soon after cutting.
3. Don't touch the cutting edge of the insert with bare hand to prevent injury.