

## 1. Notes which undertake installation

① **Please confirm whether there is interference with the use machine tool.**

Especially, the casing cannot be set up when the casing comes in contact with the ATC magazine, the cutting rubbish and the treatment device to hold disregarding and the processing thing, and it is necessary to remodel the machine tool. Please refer to Figure 1. A position of the positioning pin and a relative position with the cutting rubbish outlet can be easily changed by changing  $\alpha$  and the  $\beta$  corner in Figure 1.

② **Please set up the positioning block for the casing turn stop on the main axis edge.**

Because the casing cannot be fixed if there is no positioning block, the Qing cutter cannot be set up. It is possible to fix by using the block if the size is suitable for the positioning pin when the block for the oil supply etc. are existing. However, please note that the casing cannot be set up when the size is not suitable for the pin. Please inquire right or wrong of the installation of the maker of the machine used when there is originally no block. (Figure 1 and 2).

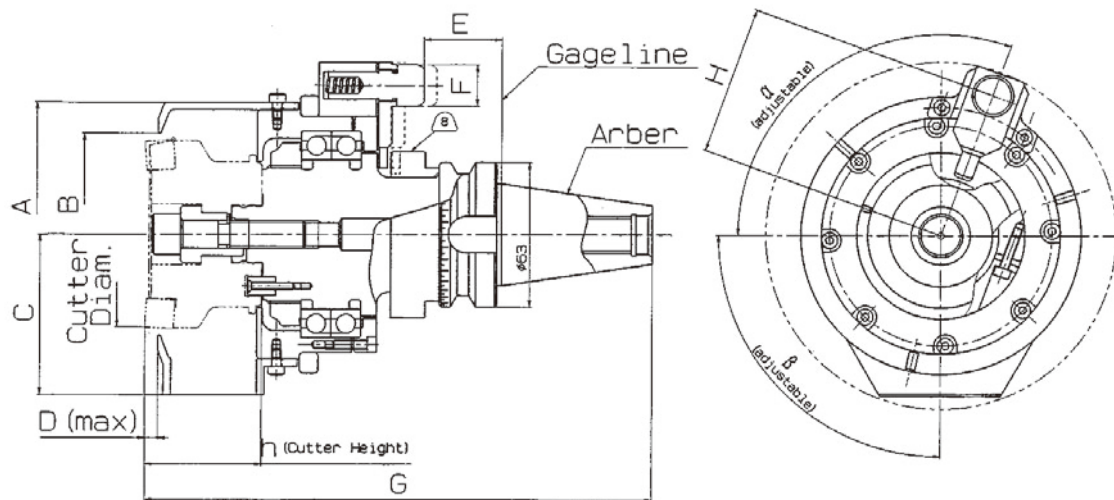
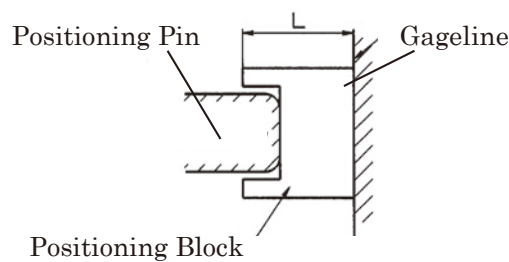


Fig.1 Standard

Order No	Diam (φ)	Arbor	A	B	C	D	F	F	G	H	J	$\alpha$	$\beta$	h	W(ke)
QMC080-BT40	80	BT40	115	88	70	5	33.7	18	167	65	152	adjustable		50	6.1
QMC080-BT50		BT50	123	115	74					80	182				6.8
QMC100-BT40	100	BT40	135	108	80				173	65	152			7.8	
QMC100-BT50		BT50	160	135	92.5					80	182			10.6	
QMC125-BT50	125	BT50	160	135	92.5				179	80	182			63	13.1



Arbor	Lmax
BT40	42
BT50	45.5

Table.1 E with positioning Pin(Unit:mm)

Arb.	E			
	Pin A	Pin B	Pin C	Pin D
BT40	20.1~30	10.1~20	0.1~10	-10~0
BT50	22.1~32	12.1~22	2.1~12	-8~2

\* **The casing does not adhere when L exceeds Lmax.**

Fig.2 Max. Height of Positioning Block

- ③ **Please confirm the transportable weight of ATC.** The cutter is occasionally dropped when the tool changes when the weight of the cutter exceeds it. Please refer to Figure 1 for the weight of the casing. Please refer to the catalog or manual for the weight of using the facemills.

## 2.Directions

- ① **Please average and drive at the beginning.** Please refer to the Qing cutter catalog of our company for details. Moreover, please use in the permissible rotation number without fail. (Refer to the table below)

Average and about the drive method

a)When the number of maximum revolutions of machine tools used is higher than the number of casing maximum revolutions

- ① Stop at 45 seconds of one minute after the casing is averaged and rotates for 15 seconds by the number of revolutions . This is done by five cycles as one cycle.
- ② Stop at 45 seconds of one minute after the casing is averaged and rotates for 15 seconds by the number of revolutions . This is done by five cycles as one cycle.
- ③ Stop at 30 seconds of one minute after the casing is averaged and rotates for 30 seconds by the number of revolutions . This is done by five cycles as one cycle.
- ④ Stop at 15 seconds of one minute after the casing is averaged and rotates for 45 seconds by the number of revolutions . This is done by five cycles as one cycle.

b)The number of maximum revolutions of machine tools used must average lower than the number of casings of maximum revolutions and it is higher than the number of revolution

After①operation, ②~⑤ is operated by the number of machine tools of max. revolution.

c)The number of maximum revolutions of machine tools used must average and when it is lower than the number of revolutions

- ①~⑤ is operated by the number of machine tools of maximum revolutions.

Order No.	Max Rev.(min-1)	Drive Rev.(min-1)
QMC080-BT40	11,200	5,600
QMC080-BT50	11,200	5,600
QMC100-BT40	10,000	5,000
QMC100-BT50	10,000	5,000
QMC125-BT50	8,100	4,050

- ②**The bearing is an articles of consumption, and about one year's bearing exchange is necessary according to the cutting condition.**

If it is had to remove chips in the casing by the air etc. when inserts are exchanged, the exchange period of casing is extended. As a standard of the exchange ,

- the allophone came to be generated.
- The turn of arbor became unwell (Please confirm it when you exchanged inserts).

Please interrupt use without fail and inquire of our company sales when such a situation is generated.

The responsibility cannot be assumed for the breakdown of the machine tool main axis when the cutter is used.

- ③**In use for a long time, wear on the inside of the casing occasionally occure by chips.** When the wear is excessive, the exchange of the casing is needed.

- ④**When height D of the casing is set near the depth of cut(DOC), the suck rate does UP.** (example:D=1.5mm DOC=1mm)Please set D greatly, and avoid the interference of a casing and a possible thing when the amount of the incision is unstable.

- ⑤Please confirm the casing and **confirm whether loosening of the screw occurs** when before use and the chip is exchanged.

- ⑥**Please use in dry.** The chip welding in the casing pulls happening chip blocking if uses in wet and the mist atmosphere. Moreover, when the cutting liquid in the pre-processing remains in the processing thing, it is similar. Please confirm it is regular the chip welding in the casing.

