

V10000 Type Operation Manual

1. How to attach insert

- Clean the insert seats with high pressure air or brush.
- Wipe the side and back faces of inserts.
- Apply an anti-seizure lubricant to an insert clamping screw. Tighten the screw while lightly pressing of the insert. (Refer to a right table for the recommended clamp torque)
- Ensure that there is no space between the insert and the insert seat

Recommended Clamp Torque.

Parts	Clamp Torque [N.m] / [Kgf.cm]
HBH06016	8 / 81.6
HBH04008	4 / 40.8
CS350790T	3.5 / 35.7

2. How to adjust the run out.

• When V10000 is shipped, we are adjusting the run out to 5 μ m or less by using the special inserts. If you want to adjust the run out in attaching insert yourself, please follow the undermentioned procedure.

- First, attach the inserts to cartridges. (Fig.1)
- Second, temporarily clamp cartridges in the main body. (Fig.2) The temporarily clamp torque is half of the recommended clamp torque. Please note that the run out at the time of final tightening grows when the clamp torque at the time of a temporary tightening varies.
- Third, adjust with the adjustment screws so that the height of the inserts may steady. (Fig.3)
- Fourth, tighten cartridges by the recommended clamp torque. (Fig.4)

Please note that there is a possibility that the breakage is generated when parts are clamped by un-recommended clamp torque, and V10000 used by the high revolution.



Fig.1



Fig.2



Fig.3



Fig.4

3. About balancing

- As for V10000, the balance is adjusted by using a special chip to G6.3. So that The balance is not destroyed, don't operate the balance adjustment screws (HSS05005) in the body outer.
- The balance would be changed when the cartridge is replaced. Please ask us the re-balancing when you use the cutter by the revolution more than a right table. However, the re-balancing is not needed about $\varnothing 125$ in use in the maximum revolution.

Diam.	Re-balancing Rev.(min ⁻¹)
$\varnothing 63$	17,000
$\varnothing 80$	14,500
$\varnothing 100$	14,000
$\varnothing 125$	0

4. Caution

- Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured.
- Please make the body annulment disposal when it is bumped and strongly shocked by mistake. There is a possibility that the body is damaged when using it as it is.
- Please use V10000 below the maximum revolution of the catalog description.
- Please note the handling of the insert. Because the cutting edge can be sharpened, you might be injured.