

**A**

**Hold**

Screw  
GY06013M x 1pc.

TKY25D TKY30R  
Wrenches

Screws  
TS407 x 4pcs.

①

GYDL\*\*\*90\* - **M25R**

**Modular Blade**

Use blade)

- GYM25R/L-D12
- GYM25R/L-E12
- GYM25R/L-F12
- GYM25R/L-G14
- GYM25R/L-H14
- GYM25R/L-J14

GY **M25R** A **F** 12

②                      ③

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**Insert**

④

GY2M0300 **F** 040N-MS

GY2M0318 **F** 030N-GM

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

**B**

Screws : TS55  
Wrench: **TKY25D**  
Torque : 5.0 Nm  
44 lbf-in

Side Screws  
(2 screws)

Note2) ① and ② should be matched.

**C**

Screws : TS55  
Wrench: **TKY25D**  
Torque : 5.0 Nm  
44 lbf-in

Front Screws  
(2 screws)

Note3)  
Please tighten the TS55 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.

**F**

Complete.

Good                      NG

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

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