

Instruction manual for ASX400 type

1. Process of clamping the inserts

①Cleaning the insert seats

Please clean the insert seats with high pressure air or a brush.

If foreign particles are clamped between the insert and the insert seat, problems may occur such as, run out of the cutting edges and movement of the inserts during cutting.

②Clamping the inserts

Ensure the flat locating face of the insert makes a solid contact with the locating surface of the insert seat.

Clamp the insert tightly with the screw and wrench while pushing the insert toward the locating surface of the insert seat.

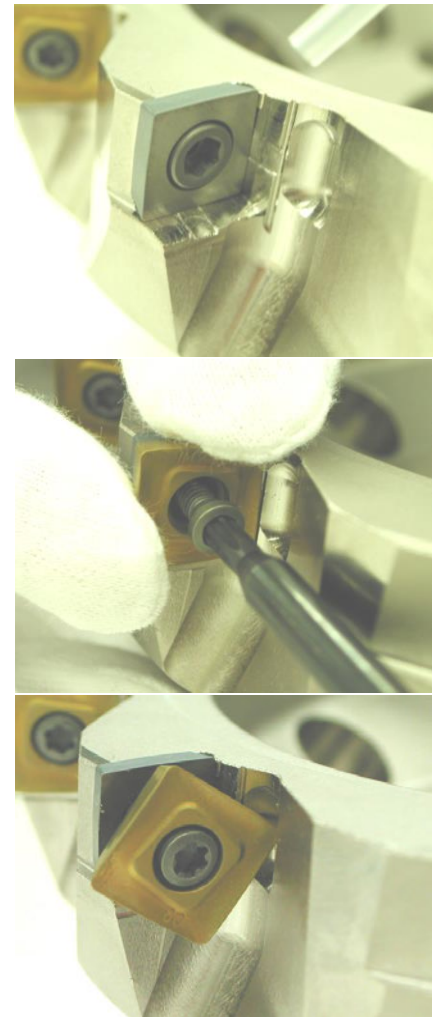
☆Clamping torque : $3.5 \text{ N}\cdot\text{m} \doteq 35.7 (\text{k g f}\cdot\text{c m})$
 $\doteq 2.59 (\text{f t}\cdot\text{l b})$

③Indexing the insert

Loosen the clamping screw and rotate the insert to a new corner.

To change the corner, it is not necessary to loosen the screw completely.

(Please clean the insert seat before re-clamping the insert.)



2. Wrench information

①T shaped wrench

ASX445 type uses the TORX PLUS type clamp screw. And the attached T shaped wrench is for exclusive use of this screw. Clamping the screw with the wrench, the clamping force will be 20% stronger than using the original TORX wrench. To get the best performance of the TORX PLUS screw and to keep the wrench hole life of the screw head long, please use the attached wrench.

②Hexagonal wrench

The attached hexagonal wrench is used to clamp the shim seat. The wrench size is 3.5mm.

3. Caution

Please use original parts. If the other parts (screws, shim seats etc.) are used, the performance will be inferior and safety can not be assured.

When using milling cutters at high speeds, inserts may disengage or parts may become damaged due to the strong centrifugal force generated.

Maximum allowable RPM as well as suitable tightening torque of the clamping screws are shown on the cutter body.

Please follow these guidelines to ensure safety.