

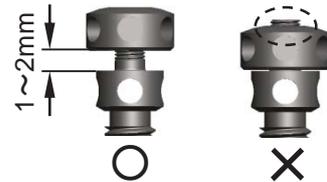
# Instruction manual for “FMAX”

## 1. How to locate the insert

1. Before locating the insert, please clean the insert seat.
2. Hold the insert firmly on the seat when tightening the clamping screw.
3. To prevent the screw from seizing, use anti-seize cream, and ensure that the clamping forces are not exceeded.  
(Clamp Torque=2.58Ft.Lb)
4. Ensure that there is no space between the insert and insert seat.

## 2. How to adjust the run out

1. Temporary clamping (Fig.1)
  - Attach the adjustment nut with about 1~2mm gap from the adjustment screw, and locate the insert.
  - ※ The adjustment screw should not run out.
  - Tighten the insert temporary with a torque.(0.74Ft·Lbf)
2. Semi-adjusting (Fig.2)
  - Rotate the adjustment screw and semi-adjust by extruding the insert.
  - The run out should be 10μm or less.
3. Fine-adjusting (Fig.3)
  - Tighten the insert by the recommended clamp torque. (2.58Ft·Lbf)
  - To fine adjust, rotate the adjustment nut and extrude the insert.
  - The run out should be 5μm or less.
  - ※ The adjust-range of an adjustment nut is about 5μm.



Please adjust finely by using both the adjustment nut and the adjustment screw.

Fig.1 1N·m(0.74ft·lbf)

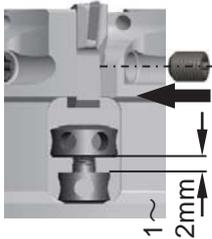


Fig.2

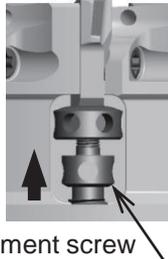


Fig.3 3.5N·m(2.58ft·lbf)



Fig.4  
adjustment wrench



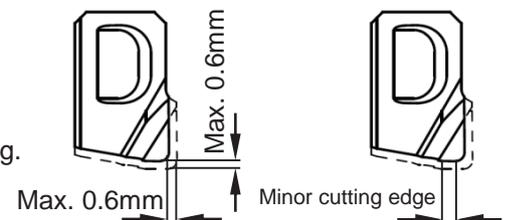
## 3. About balancing

As for FMAX, the balance is adjusted to G6.3.  
In order to avoid the inbalance of the cutter,  
Please do not touch or adjust the screws on  
the body outer.



## 4. About regrinding

- The maximum regrinding amount should be 0.6mm.
- Don't locate the different regrinding inserts for balancing.
- Be aware that the minor cutting edge will become small by regrinding.
- Be aware that the cutter diameter will become small by regrinding.
- ※ Please request us if you want to offer.



## 5. Caution

- Please use the original parts. If not there is a possibility of some safety problem occurs.
- Please use FMAX below the maximum revolution of the catalog description.
- When attaching or removing the insert from the cutter, please wear an equipment that protect your hands since the cutting edge can be sharp and you might cause injury.