

Instruction manual for SE series

Order number : SE415 , SE515 , SE445 , SE545 type

Please read and observe the following safety instructions.

Procedure for the replacement of inserts

(1) Cleaning

- Using compressed air, blow off dust from the faces of the shim (A), the locator (B), the holder (C) and the wedge (D) (see Fig. 1).
- Wipe the insert with a pieces of cloth, and never forget to remove adhesives with a hand lapper.

(2) Mounting of inserts

- As shown in Fig.2 slide the insert down along the shim face (A).
- As shown in Fig.3, rest the insert on the surface (C) of the holder, slide it along sideways and press it firmly on to the locator face (B) several times.

(3) Tightening of insert (see Fig. 4)

- Press the insert against the three faces of (A), (B) and (C), and tighten the clamp screw of the wedge T with a driver lightly.
- Release your hand from the insert and tighten the screw firmly. (tightening torque : 8 N·m (6 ft·lb))

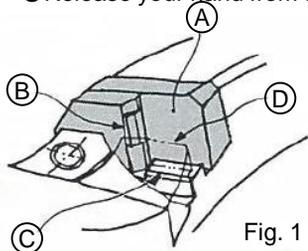


Fig. 1

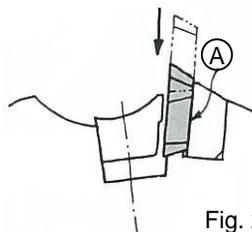


Fig. 2

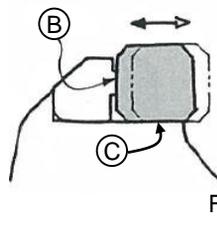


Fig. 3

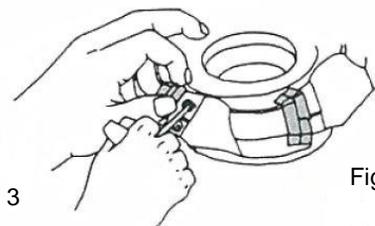
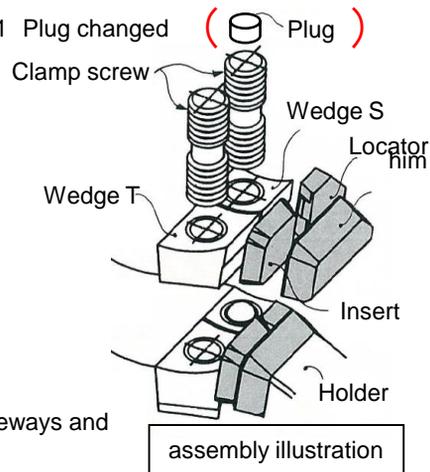


Fig. 4



assembly illustration

Procedure for the replacement of parts

Please replace new parts using the following guideline.

When the shim or the locator is damaged seriously, replace them with new parts.

(1) Guideline for parts lifecycle (Please check the order number of parts in the catalog.)

- The driver should be exchanged when its tip has worn off or becomes unable to tighten up the clamp screw.
- The clamp screw should be replaced when its hole has worn or becomes unable to tighten up the clamp screw.
- The wedges (T and S) should be replaced when they become unstable or unreliable for tightening the insert.
- The shim should be replaced when its face get serious damage or breakage exceeding W:0.5mm(.0197") * L:1mm (.0394") as shown in Fig. 5.
- The locator should be replaced when (E) shown in Fig.6 gets damage.
- The plug should be replaced when the shim or locator is exchanged.

(2) Procedure for the replacement of shims and locators

- Remove the insert and wedge T.
- Remove the plug on clamp screw of wedge S with a pointed tool.
- Loosen the clamp screw of wedge S, and remove, the shim and the locator.
- Take notes of the code written on the reverse side of the locator. The code indicates the size of the locator.
- The new locator should have a same code as the damaged locator. Also make sure that the pocket and the locator have cleaned up.
- Press the shim and the locator, and tighten the clamp screw of wedge S with the driver lightly.
- Release your hand from the shim and the locator, and tighten the screw of wedge S firmly. (tightening torque : 10N·m (7.4ft·lb))

Note : As shown in Fig.7 set the clamp screws of wedges T and S in such a way that their faces come between 0 to 1 mm (0 to .0394") below the surface of the each wedge.

- Put the plug into the clamp screw of wedge S. **※Refer to next page to check how to install the plug.**

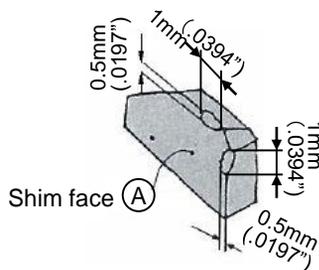


Fig. 5

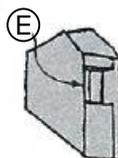


Fig. 6

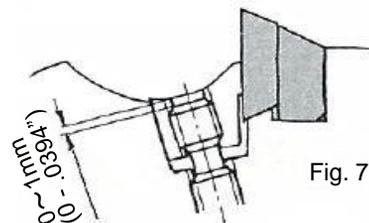


Fig. 7

How to install the plug

1. Necessary tools

- ① Precision screwdriver (for squeezing silicon plug into wrench hole)
- ② $\phi 3.3 \sim \phi 4.4$ pin with flat head



2. Installing steps

- ① Put the plug towards to wrench hole diagonally. ② Squeezing finished. Squeeze it into wrench hole with screw driver.



- ③ Push it into the hole further with flat head pin. Plug will stop at the upper part of wrench hole, since pin is wider than wrench hole.

- ④ Installation completed.

