

Instruction manual for FBP415

Procedure for the replacement of inserts

The life of the cutting tool and the accuracy of its finished surface depend largely on the accuracy of the run out of its edges.

Inserts should be properly replaced according to the undermentioned procedure.

(1) Cleaning

*Using blasts of air, blow off dust particles from the face of insert mount A, B, C. (See Fig 1~2), or wipe off insert with pieces of cloth.

*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.

(2) Mounting of inserts

*As shown in Fig. 1, slide the insert down along the sheet face A.

*As shown in Fig. 2, rest the insert on the face B of the cutter body, slide it along sideways and press it firmly on the locator face C.

(Note) If you must set wiper inserts, please set them on the position with W character. (See Fig 3)

(3) Tightening of inserts (See Fig 4).

*First, press the insert on to the face A B C on which the insert rests, and tighten the clamp screw of wedge only lightly.

*Then, tighten the screw of wedge firmly.

(Tightening torque : about $8\text{N} \cdot \text{m} = 81.6 \text{kgf} \cdot \text{cm}$)

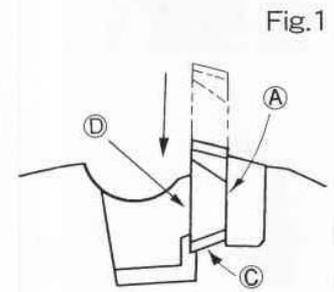


Fig.1

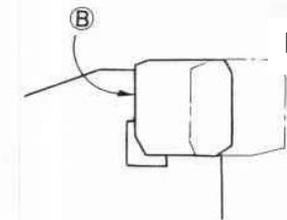


Fig.2



Fig.3



Fig.4

Procedure for replacement of parts

If either the seat or the locator should be damaged seriously, replace them with new ones.

Damage may affect badly the tool life as well as tool performance. The parts should also be exchanged for a new one at times.

(1) Standard service life of parts of the cutter

*The wedges should be replaced when they become unstable and unreliable for tightening the insert.

*The clamp screw should be replaced when its hole becomes worn.

*The seat should be replaced when its end become worn off and useless for tightening insert, and the overhang of seat and insert becomes excessive.

(2) Procedure for replacement of seats

*Remove the insert and wedge

*Remove the seat by loosening the screw

*Set the new seat and insert.

(Note) As shown in Fig.5, set both clamp screws of wedges in such a way that their heads come between 0.5 to 1mm below the surface of the respective wedge.

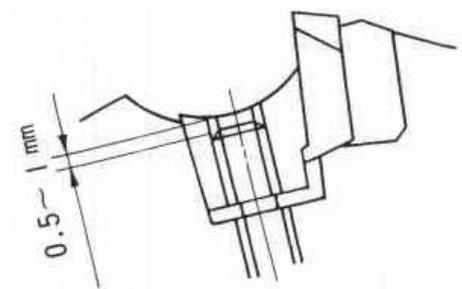


Fig.5

Caution

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