

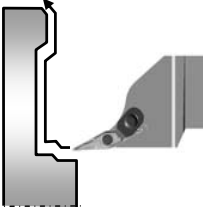
# Instruction manual for 25° profiling holder

## Operational Guidance

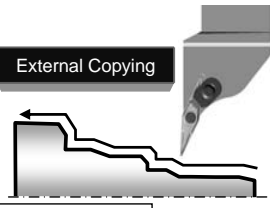
**Possible**

**End Face Copying\***

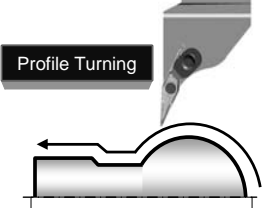
\*When end face copying, refer to the precautions Below.



**External Copying**

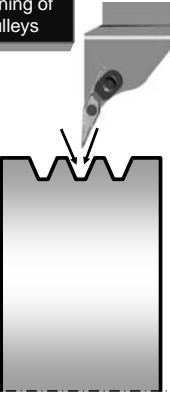


**Profile Turning**



**Not possible**

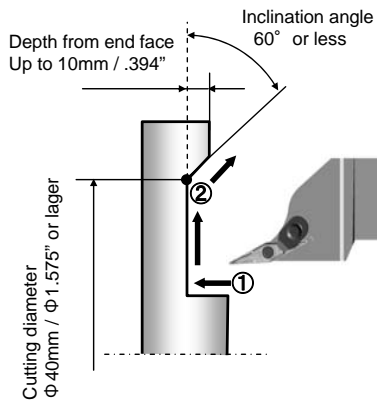
**Machining of V-pulleys**



When machining V-pulleys, use a VNMG insert.

## Notes when end face copying

Pay special attention to the following when face copying.



### Machining of an outer diameter (Step ①)

- To prevent burr formation, the depth of cut should be below half the nose radius.

### Machining of an inclination (Step ②)

- To reduce the contact length of chips, the depth of cut should be below half the nose radius.
- To prevent interference between the tool and the workpiece, the cutting diameter should be 40mm / 1.575" or larger, inclination angle 60° or less and depth from the end face up to 10mm / 0.394".

### When changing inserts

- When indexing inserts, it is recommended to reset the cutting edge position to maintain machining accuracy.

## The correct use of the torque wrench

- Fig.1 By holding the tip of the torque wrench, gently tighten the screw until it is finger tight.
- Fig. 2 After ①, tighten the screw to the set torque value as stated in table 1.
- After tightening the screw, check that the insert has been securely located.

Attached wrench		Torque (N·m)
Order No.	Size	
TYK08F	T8	1.0
TKY10F	T10 Table 1	2.0

Caution: Over tightening of the screw can lead to the damaging of the screwhead, and the wrench.



Fig.1



Fig.2

## The correct detachment of the insert from holder

There are some cases in which the insert can not detach from holder after cutting, because of the rhombic 25°  
Please refer the following steps, in case of these conditions.

- Fig.3 Put the tip of the attached wrench in screw hole of the insert not spotface of the holder.
- Fig.4 Lean down the wrench to the direction of end of holder along the bisector of the 25° corner.

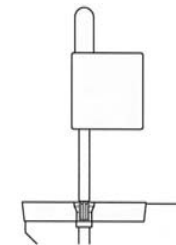


Fig.3

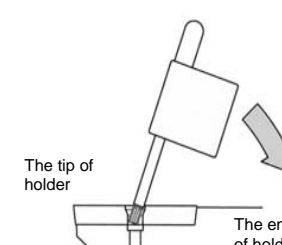


Fig.4

