

# Instruction manual for VFX6

## 1. How to locate the insert

1. Prior to locating the insert, please air blow the insert seat.
2. Press firmly down on the insert when tightening the clamping screw.
3. To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded. (Clamp Torque=5.0Nm)
4. Ensure that there is no space between the insert and the insert seat.
5. Please use XNMU190912R-OO for the external insert.
6. Overall height (L1)<sup>\*1</sup> of the set changes if the following insert order number is set in the holder. (mm)

order number	Corner R	overall height (L1)
XNMU190932R-MS	R3.2	L1+0.7
XNMU190940R-MS	R4.0	L1+1.5
XNMU190950R-MS	R5.0	L1+1.5

※1: Please refer to the dimension L1 by the catalog or product news.

### Set bolt + Seal washer

Clamp Torque=80Nm

**HSC12045 , HSC12070 + W12-S1**

Clamp Torque=150Nm

**HSC16040 , HSC16080 + W16-S1**

Clamp Torque=320Nm

**HSC20040 , HSC20090 + W20-S1**

### Coolant nozzle

Clamp Torque=1.5Nm

**HSD04004H08(STD)**

Option

**HSD04004H06**

**HSD04004H12**

**HSD04004H16**

### External insert

**XNMU190912R-OO**

### Bottom insert

**XNMU19090OR-OO**

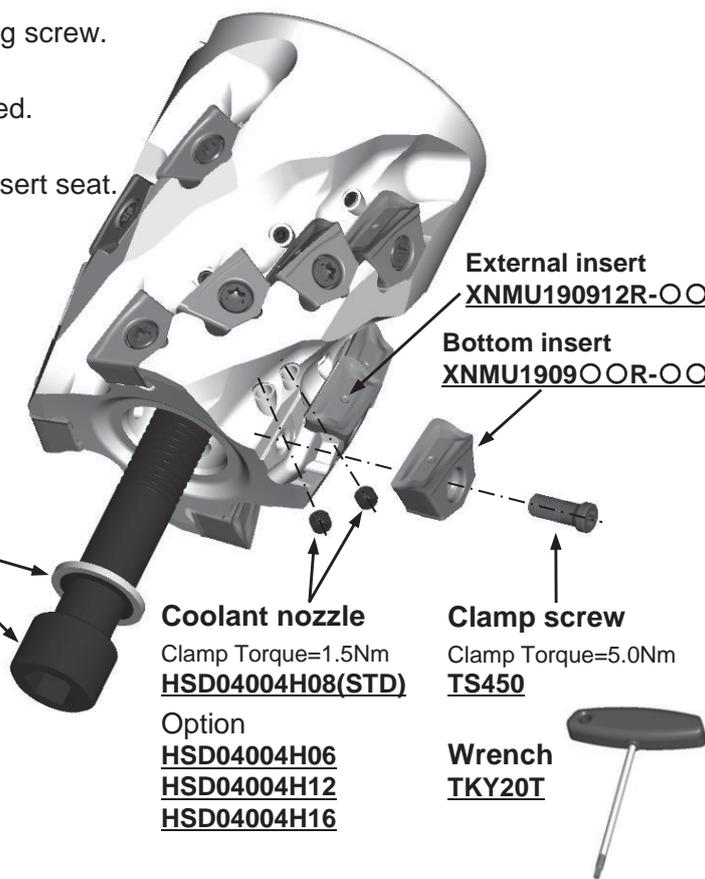
### Clamp screw

Clamp Torque=5.0Nm

**TS450**

### Wrench

**TKY20T**



## 2. Parts

1. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured.
2. Please replace the clamp screw periodically since they are consumption parts.  
Don't use the clamping screw whose TORX hole is damaged or thread wear is progresses.

## 3. Maintenance

The VFX can be used under high cutting conditions. If you notice any of the following problems it is recommended that you exchange for new tool in order to maintain safety.

1. Body
  - Deformation of the insert seat
  - Fatigue fracture , fatigue cracks
2. Insert
  - Wear ,fracture
3. Clamp screw
  - Deformation of the TORX hole , a stripped thread , wear

## 4. etc

1. Please refer to tools-news about the cutting conditions.
2. There is a danger of burn, if it is touched soon after cutting.
3. Don't touch the cutting edge of the insert with bare hand to prevent injury.
4. Please tighten again with the attached wrench afterwards if you used an electric driver.