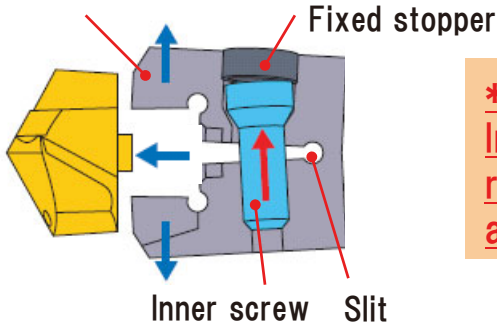


Operation manual of **S-TAW** repair method

Back metal with taper



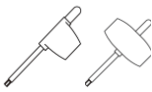



*The damage when unclamping (without insert)

*Caution:

In case you replace parts, we recommend you to replace in our company or replace by yourself in accordance with the following operating suggestions.

◎ Parts table

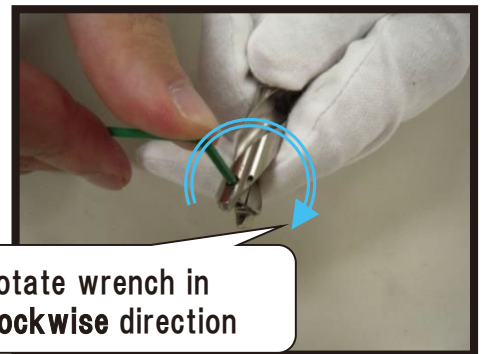
Holder order number			Inner screw , stopper Order number	Inner screw	Stopper	Wrench	Torque wrench *1		
						① ② 	 For stopper		
Metric	Inch								
1000S16	0026	WS203107TPS-35LH	WS203107TPS	WS35LH	①TIP06F	2859H2.0 <u>Torque reference Value</u> 1.2 (N·m) 10.62 (lbf·in)			
1050S16	0027								
1100S16	0028								
1150S16	0030								
1200S16	0031								
1250S16	0032								
1300S16	0034	WS253909TPS-45LH	WS253909TPS				WS45LH	②TIP08W	2859H2.5 <u>Torque reference Value</u> 2.0 (N·m) 17.70 (lbf·in)
1350S16	0035								
1400S16	0036								
1450S16	0037								
1500S20	0039								
1600S20	0041	WS304912TPS-55LH	WS304912TPS	WS55LH	②TIP10W	2859H3.0 <u>Torque reference Value</u> 5.0 (N·m) 44.25 (lbf·in)			
1700S20	0044								
1800S20	0046								

*1. Recommendation: Wiha_Torque driver

Operation procedure1. Unfix stopper.

If you rotate stopper in counterclockwise direction, there's a high risk of damaging the screw threads. Rotate the wrench in **clockwise** direction with the wrench fitted in the stopper hole.

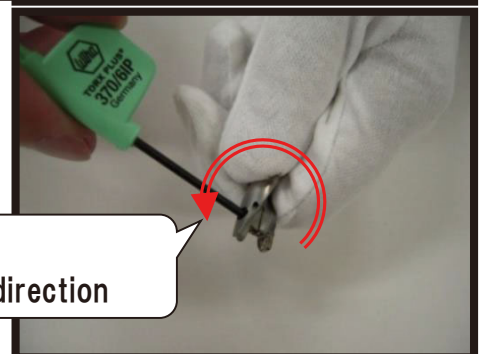
If the stopper can not be unfix, destroy the stopper by end milling.



Operation procedure2. Unfix inner screw.

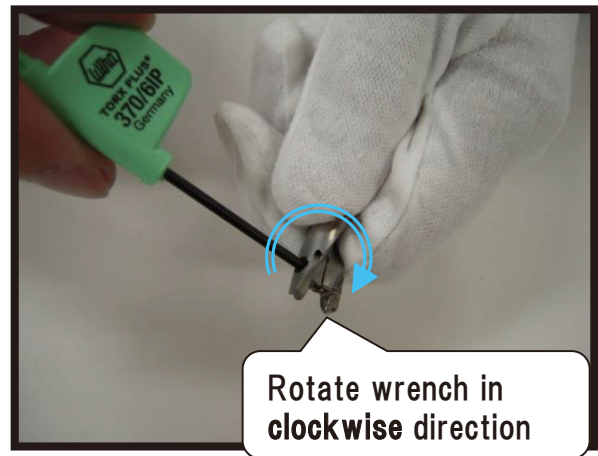
Rotate the wrench in **counterclockwise** direction with the wrench to unfix inner screw.

Rotate wrench in counterclockwise direction



Operation procedure3. Insert new inner screw.

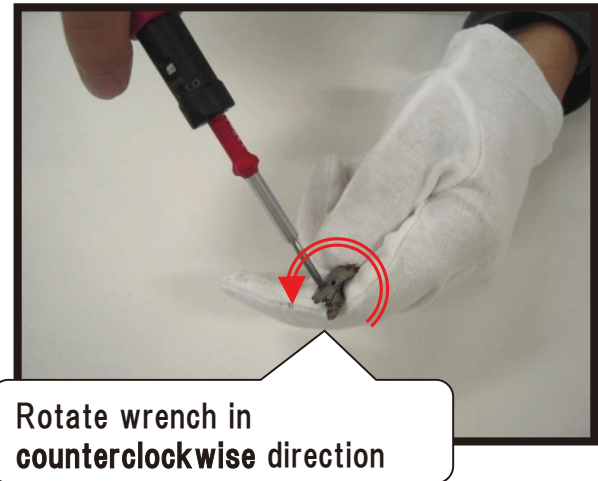
Rotate the wrench in **clockwise** direction with the wrench fitted in the inner screw dimple.
Insert the inner screw until the screw is at the bottom of hole.



Operation procedure4. Fix new stopper with appropriate torque.

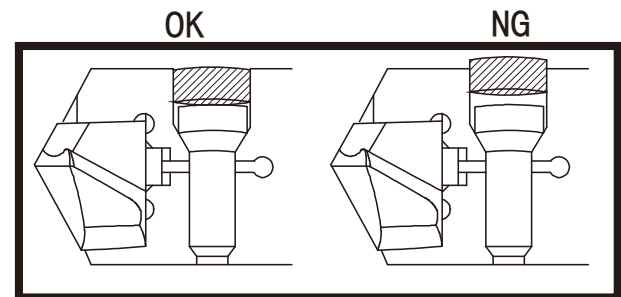
Rotate the torque wrench in **counterclockwise** direction with appropriate torque.

Holder order number			Torque wrench *1
	Metric	Inch	
STAWSS STAWSN STAWMN STAWLN	1000S16	0026	2859H2.0 <u>Torque reference value :</u> 1.2 N·m 10.62 lbf·in
	1050S16	0027	
	1100S16	0028	
	1150S16	0030	
	1200S16	0031	
	1250S16	0032	
	1300S16	0034	2859H2.5 <u>Torque reference value :</u> 2.0 N·m 17.70 lbf·in
	1350S16	0035	
	1400S16	0036	
	1450S16	0037	
	1500S20	0039	
	1600S20	0041	
	1700S20	0044	
	1800S20	0046	



Operation procedure5. Check the position of the stopper.

(NG: the overhang of stopper against body)



Operation procedure6. Check whether you can clamp and unclamp the new insert.

