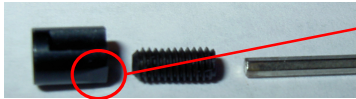


Assembly instructions and user guide adjustment pin

Individual components adjustment pin (pict. 1).



wedge surface 7° / 11°

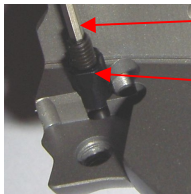
no exit of allen set screw



Pict. 1: left to right: adjustment pin K4-7° / K4-11°, set screw M2,5, allen set key SW 1,3

Pict. 2: adjustment pin assembled

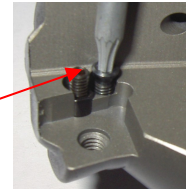
Insertion of the adjustment pin into the tool. Wedge surface have to be aligned in the direction of the cutting edge (pict. 3). Locking screw have to fit into the radial area of adjustment pin. Turn the locking screw **until the limit stop** by torx-key size 7 (pict. 4).



allen set key SW 1,3

preassembled adjustment pin

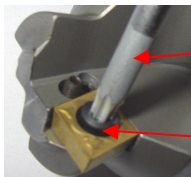
Fitting of the locking screw to the radial area of adjustment pin



Pict. 3: build in of an adjustment pin

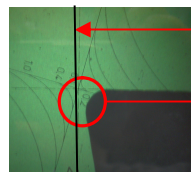
Pict. 4: Screw in of locking screw

Apply the insert CCMT / CPMT (pict. 5) and screw in the fixing screw hand-tight. Take the tool to a presetting device. Clearance without radial tension ca. 0,1mm (see example Ø25,53 pict. 6+7).



torx-key size 15 / 7 / 6

fixing screw M3,5 / M2,5 / M2,2



required-Ø25,53 mm = vertical line

clearance radial ca. 0,1mm

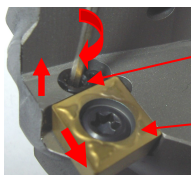


Pict. 5: assembly of carbide insert

Pict. 6: view presetting device

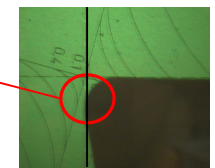
Pict. 7: required diameter of fitting

Screw in adjustment pin with allen set key SW1,3 until the required dimension is reached (pict. 9)



adjustment pin will be pushed up by screwing of the set screw
carbide insert will be radially moved because of the wedge surface on the pin

No clearance. The insert is adjusted on the required diameter of Ø25,53 mm.



Pict. 8: fine adjustment of the insert

Pict. 9: adjusted cutting edge

Tighten mounting screw M2,2 / M2,5 / M3,5 of the insert (pict. 10). The tool can be used now (pict. 11). Recommended torque: **M2,2 = 0,6Nm / M2,5 = 1,3 Nm / M3,5 = 3,0Nm**



Pict. 10: Tighten of mounting screw



Pict. 11: Adjusted insert

If diameter is too **large**, the mounting screw of the adjusted insert must be released and the set screw M2,5 must be unscrewed of the adjustment pin. The initial situation is reached again (pict. 5). Repeat step 5 – step 10.

If diameter is too **small**, the mounting screw must be released until it's hand-tight. Take the allen set key SW1,3 and screw in the set screw M2,5 until the required dimension is reached. Tighten the mounting screw again.