

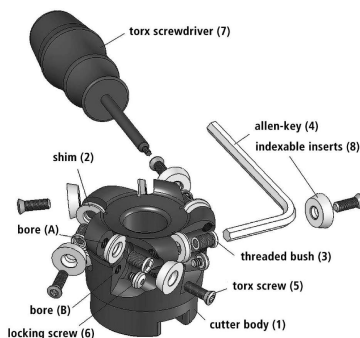
ASSEMBLING INSTRUCTIONS

For Milling Cutter Bodies with round inserts and shim

In order to maintain optimum and safe use of these tools, you should pay attention to following notice:

Step 1: Assembling Indexable Inserts

- 1.1 Remove Torx-screw (5) from cutter body (1) with Torx-screwdriver (7) and check correct fit of threaded bush (3) in threaded bore (A), using provided Allen-key (4).
- 1.2 Pay attention, that the shoulder of the threaded bush (3) sinks completely into the recess of the shim (2). If not, please fix it with the Allen-key (4).
- 1.3 Assemble indexable inserts (8) first by means of Torx-screw (5), using Torx-screwdriver (7) and fasten finally with the locking screw (6) in threaded bore (B).



Step 2: Replace Shim

- 2.1 For replacing shim, please prepare for Torx-screwdriver (7) and Allen-key (4).
- 2.2 Unscrew locking screw (6) in threaded bore (B) and after that Torx-screws (5) fixing inserts (8) with Torx-screwdriver (7).
- 2.3 Using Allen-key (4), unscrew and remove threaded bush (3) from threaded bore (A). Remove shim (2) from cutter body (1). Clean insert seat from swarf and grease, before you put new shims back to cutter body.
- 2.4 Put new shims (2) into insert seats and fix it into threaded bore (A) with threaded bush (3) using Allen-key (4) and copper paste from our accessories selection. Pay attention, that the shoulder of the threaded bush (3) sinks completely into the recess of the shims (2).
- 2.5 Now, indexable inserts (8) can be fixed as usually, using Torx-screws (5) and Torx-screwdriver (7). Finally, fasten locking screw (6) for secure insert fixing into threaded bore (B).

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