

Mounting the Insert

- Be sure to remove dust and chips from the insert mounting pocket.
- Apply anti-seize compound on portion of taper and thread of clamp screw.
 - Attach the screw (magnetic head) to the front end of the wrench.
 - While lightly pressing the insert against the pocket walls, put the screw into the hole of the insert and tighten. (Ref. to Fig. 1.)
Align M3 screw slightly inclined.
(Ref. to Fig. 2.) surface of the insert.
- When tightening the screw, make sure that the wrench is parallel to the screw.
For recommended torque, Ref. to **M9**
- After tightening the screw, make sure that there is no clearance between the insert seat surface and the pocket floor of the holder or between the insert side surfaces and the pocket walls of the holder.
If there is any clearance, remove the insert and mount it again according to the above steps.

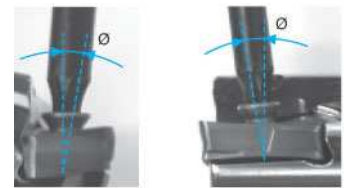
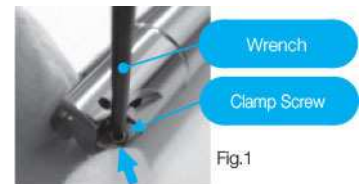


Fig.2

Recommended Cutting Conditions

Chipbreaker	Workpiece Material	Feed Rate fz (ipt)		Recommended Insert Grade Vc (sfm)			
		Toolholder Description		MEGACOAT NANO			CVD Coated Carbide
		MEW0625-MEW0750 MEW16-MEW18	MEW20	PR1535	PR1525	PR1510	CA6535
GM	Carbon Steel	0.002-0.004-0.008	0.003-0.006-0.010	390-590-820	400-600-825	-	-
	Alloy Steel	0.002-0.004-0.006	0.003-0.006-0.008	330-520-720	325-525-725	-	-
	Mold Steel	0.002-0.003-0.005	0.003-0.005-0.008	260-460-590	250-450-600	-	-
	Austenitic Stainless Steel	0.002-0.003-0.005	0.003-0.005-0.006	325-525-650	325-525-650	-	-
	Martensitic Stainless Steel	0.002-0.003-0.005	0.003-0.005-0.008	500-650-825	-	-	600-775-975
	Precipitation Hardened Stainless Steel	0.002-0.003-0.005	0.003-0.005-0.008	300-400-500	-	-	-
	Gray Cast Iron	0.002-0.004-0.007	0.003-0.007-0.010	-	-	400-600-825	-
	Nodular Cast Iron	0.002-0.003-0.005	0.003-0.006-0.008	-	-	325-500-650	-
	Ni-base Heat Resistant Alloy	0.002-0.003-0.005	0.003-0.005-0.006	250-325-500	-	-	75-100-150
	Titanium Alloys	0.002-0.003-0.005	0.003-0.006-0.008	125-200-250	-	100-150-225	-
SM	Carbon Steel	0.002-0.004-0.007	0.003-0.006-0.008	390-590-820	400-600-825	-	-
	Alloy Steel	0.002-0.003-0.005	0.003-0.005-0.007	330-520-720	325-525-725	-	-
	Mold Steel	0.002-0.003-0.005	0.003-0.004-0.006	260-460-590	250-450-600	-	-
	Austenitic Stainless Steel	0.002-0.003-0.005	0.003-0.004-0.006	325-525-650	325-525-650	-	-
	Martensitic Stainless Steel	0.002-0.003-0.005	0.003-0.004-0.006	500-650-825	-	-	600-775-975
	Precipitation Hardened Stainless Steel	0.002-0.003-0.005	0.003-0.004-0.006	300-400-500	-	-	-
	Ni-base Heat Resistant Alloy	0.002-0.003-0.004	0.003-0.004-0.005	75-100-150	-	-	75-100-150
	Titanium Alloys	0.002-0.003-0.005	0.003-0.005-0.006	125-200-250	-	100-150-225	-
GH	Carbon Steel	0.002-0.004-0.008	0.003-0.008-0.012	390-590-820	400-600-825	-	-
	Alloy Steel	0.002-0.004-0.006	0.003-0.008-0.010	330-520-720	325-525-725	-	-
	Mold Steel	0.002-0.003-0.005	0.003-0.006-0.009	260-460-590	250-450-600	-	-
	Austenitic Stainless Steel	0.002-0.003-0.005	0.003-0.005-0.006	325-525-650	325-500-650	-	-
	Martensitic Stainless Steel	0.002-0.003-0.005	0.003-0.005-0.008	500-650-825	-	-	590-790-980
	Precipitation Hardened Stainless Steel	0.002-0.003-0.005	0.003-0.005-0.008	300-400-500	-	-	-
	Gray Cast Iron	0.002-0.004-0.008	0.003-0.009-0.012	-	-	400-600-825	-
	Nodular Cast Iron	0.002-0.003-0.006	0.003-0.007-0.010	-	-	325-500-650	-
	Ni-base Heat Resistant Alloy	0.002-0.003-0.005	0.003-0.005-0.006	70-100-160	-	-	70-100-160
	Titanium Alloys	0.002-0.003-0.005	0.003-0.006-0.008	130-200-260	-	100-160-230	-

※ Machining with coolant is recommended for Titanium Alloy.

★ 1st Recommendation ☆ 2nd Recommendation

