

● **Applicable Chipbreaker**

Cutter Type	Chipbreaker		
	GM	SM(GL)	GH
Coarse Pitch (with shim)	○	○	○
Fine Pitch (without shim)	○	○	△ (Feed rate is recommended under fz = 0.0157 ipt)
Extra Fine Pitch (without shim)	○	○	Not recommended

■ **Usage Precautions (How to mount an insert)**

1. Be sure to remove dust and chips from the insert mounting pocket.
2. After applying anti-seize compound on portion of taper and thread, while pressing the insert against the constraint surfaces, put the screw into the hole of the insert and tighten the screw with appropriate torque. Ref. to Fig. 1 and Fig.2.
Recommended tightening torque ➔ The torque for coarse pitch (using M5 screw) is 4.2 N·m
The torque for extra fine pitch (using M4 screw) is 3.5 N·m.
3. After tightening the screw, make sure that there is no clearance between the insert seat surface and the bearing surface of the toolholder and between the insert side surfaces and the pocket wall of the toolholder.
4. **To change the cutting edge of the insert, turn the insert counterclockwise** (ref. to Fig. 3).
Insert corner identification number is stamped on the top surface of insert (Fig. 4). To protect the wiper edge, use the corners of insert in the sequence of corner numbers.



Fig.1



Fig.2



Fig.3

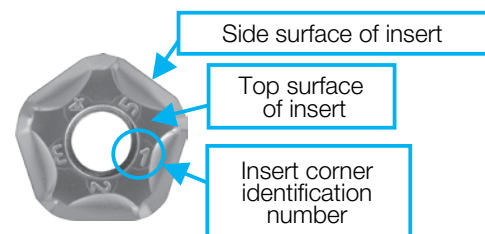


Fig.4

■ **How to Replace the Shim (Coarse Pitch)**

1. Be sure to remove dust and chips from the insert mounting pocket.
2. The shim must be mounted in the proper direction. While aligning the surface of the shim with the mark on it to the corresponding pocket wall (ref. to Fig. 5) and lightly pressing the shim toward the constraint surface, insert the screw into the hole of the shim and tighten it (ref. to Fig. 6).
When tightening the screw, make sure that the screw is vertical to the bearing surface. Recommended tightening torque is 6.0N·m.
3. After tightening the screw, make sure that there is no clearance between the shim seat surface and the bearing surface. If there is any clearance, remove the insert and mount it again according to the above steps.

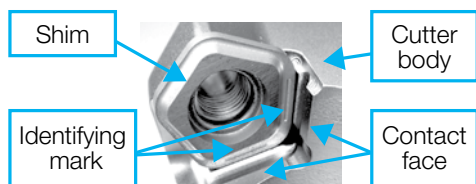


Fig.5



Fig.6

GRADES	A
LINEUP / INSERTS	B
45° / 70° LEAD	C
75° LEAD	D
90° LEAD	E
HIGH FEED	F
MULTI-FUNCTION	G
SLOT MILLS	H
RADIUS / BALL-NOSE	J
OTHER APPLICATIONS	K
TOOL HOLDING	O
SPARE PARTS	P
TECHNICAL	R
INDEX	T