для заказа - kyocera@kyocera-tools.ru

Setting the Insert

1. Completely eliminate chips from the insert mounting part. (see **Fig.1**)
2. Put the insert into the toolholder and push until it contacts the holder's surface for fixing the insert's back end. (see **Fig.2**, **Fig.3**)
3. Keeping the insert pushed against the toolholder's locating surface, tighten the insert clamp bolt at an appropriate torque.
4. Make sure there is no gap between the insert and the toolholder's locating surface and that the insert is set straight. (see **Fig.2**, **Fig.3**)

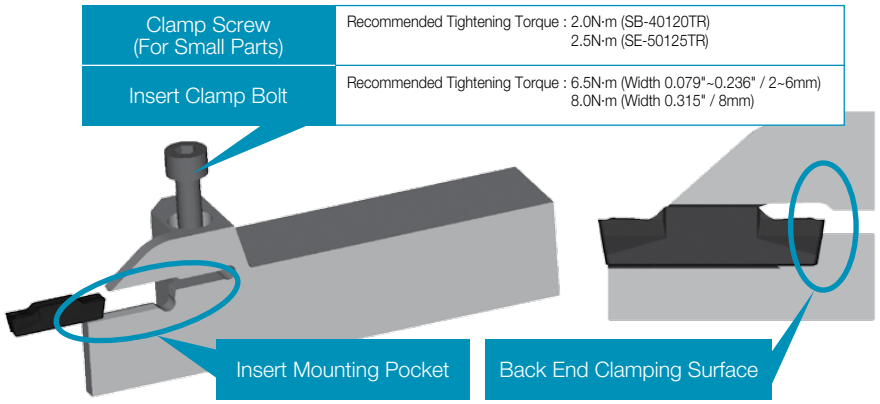


Fig.1 Fig.2

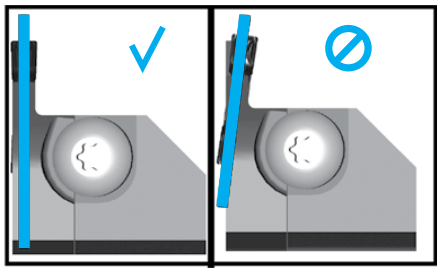


Fig.3

Setting the blade (SwitchBlade Type toolholder)

1. Use compressed air or other measures to remove chips and dust from the serration part. (see **Fig.1**)
2. Mate and fit the serrations of the blade and toolholder, and also fit the blade end to the toolholder. (see **Fig.2)**
3. Tighten the blade fixing screws at an appropriate torque. You can tighten them in any order. (see **Fig.2)**
   (Recommended tightening torque : 8N·m)
4. Set the insert after setting the blade.

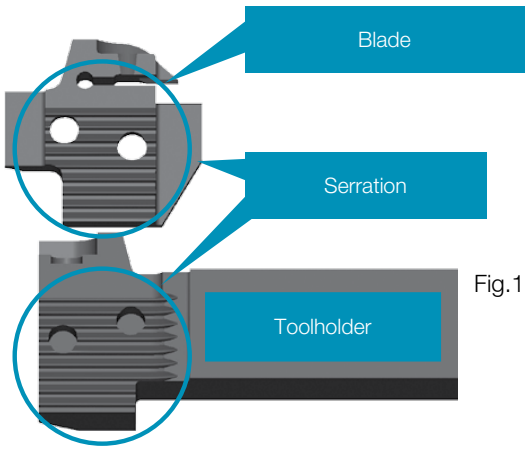


Fig.1

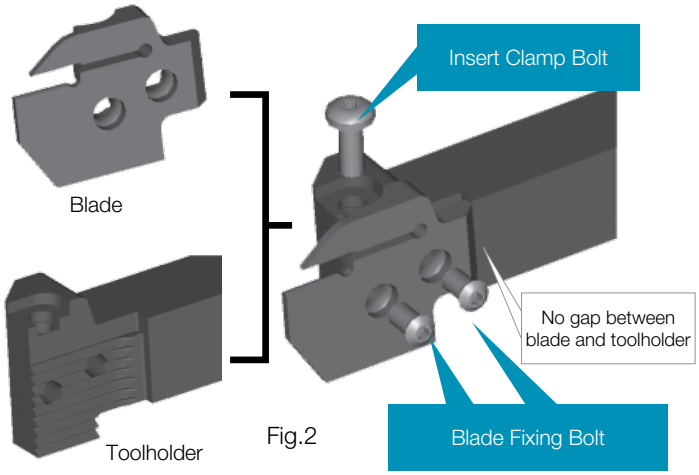
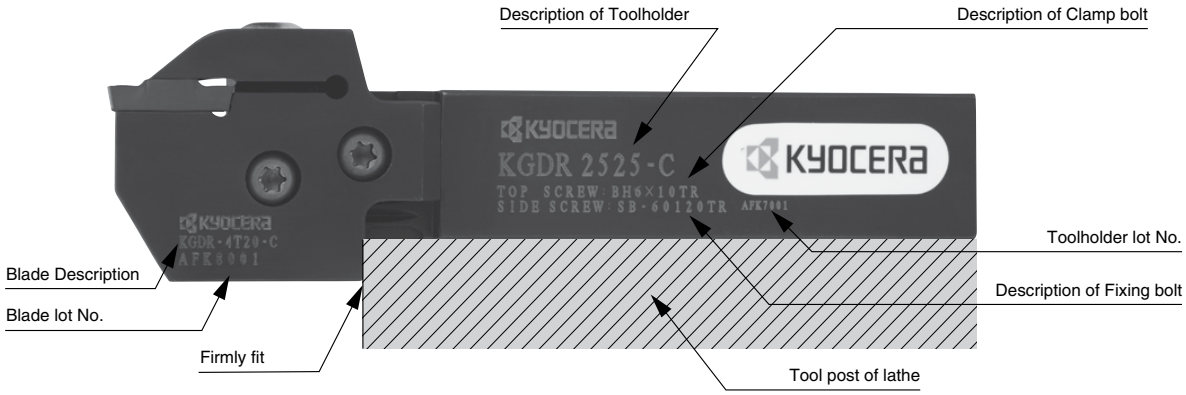


Fig.2

SwitchBlade Type Toolholder Identification System and Their Setting to Lathe

● Firmly fit the lower jaw to the tool post of the lathe.



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