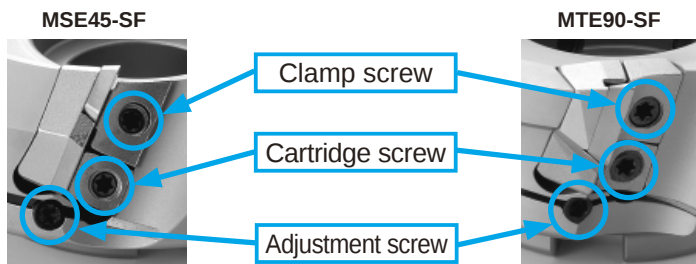


How to adjust cutting edge height

● Screw names:



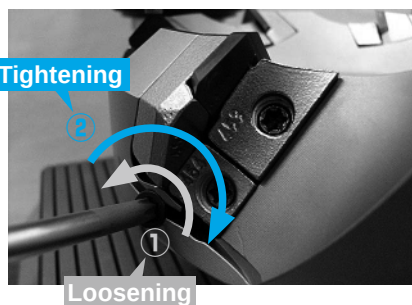
● Adjustable height for the cutting edge

- For model MSE45-SF: approx. 20μm
- For model MTE90-SF: approx. 50μm
- (The difference in adjustable heights varies because of the difference in corner angles.)

*For the explanations below, refer to the screw names indicated above. Milling Cutter shown here is model MSE45-SF.

1) Partial adjustment of the adjustment screw

- ① Loosen the edge adjustment screw
- ② Tighten as much as the edge adjustment screw is tensioned



2) Partial tightening of the clamp screw and cartridge screw

- ① Partial tighten the cartridge screw. (Note)
- ② Partial tighten the cartridge screw. (Note)



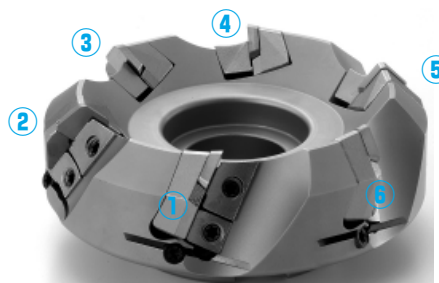
*Perform work with all inserts attached in their correct positions.

Note) Partial tightening: Tighten the adjustment screw only partially, so that further adjustment is still possible.

3) Measuring the cutting edge fluctuation



Example: Measuring the front cutting edge fluctuation



No.	Measurement results	Results	Edge fluctuation
①	0.263mm		-6μm
②	0.258mm		-11μm
③	0.254mm		-15μm
④	0.269mm	Max.	0μm
⑤	0.261mm		-8μm
⑥	0.250mm	Min.	-19μm

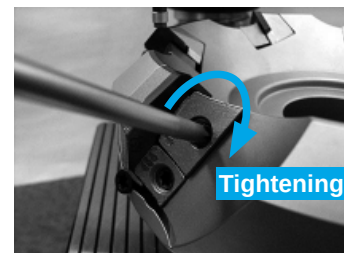
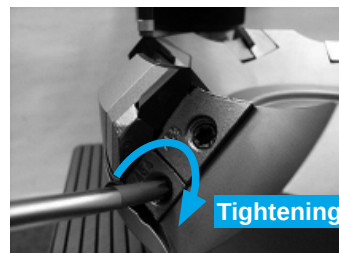
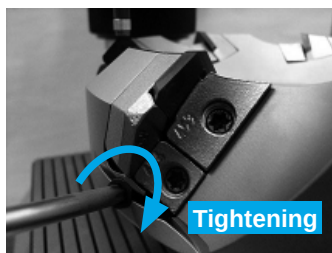
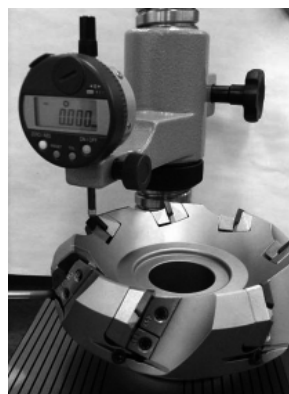
Current fluctuation: 19μm

(Number ① ~ ⑥ are not indicated on Milling Cutter)

*With each of these screws partial tightened: cartridge screw, clamp screw, adjustment screw, measure the cutting edge fluctuation.

4) Correcting the fluctuation

Based on the measurement results, correct the fluctuation.



Using the measured amount of fluctuation, adjust so that the fluctuation is corrected at the highest corner of the cutting edge, then fully tighten the adjusting screw.