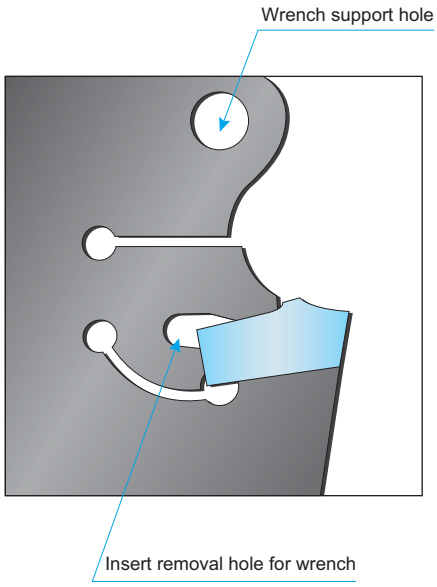
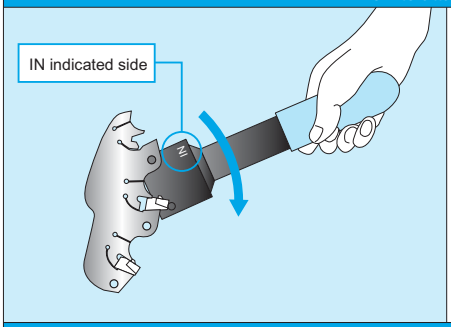
Set up

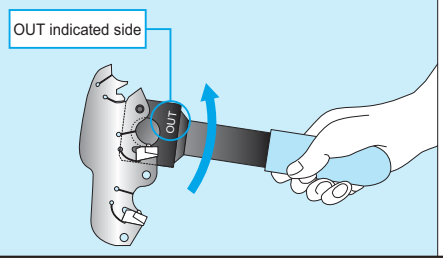


How to attach inserts



1. Put insert inside the slot mill.
2. Insert one of the pin on the wrench (on IN indicated side) into the wrench support hole.
3. Using the other pin, push the front relief surface of the insert.
4. Rotate the wrench until insert's back end makes contact with slot mill.

How to detach inserts



1. Insert one of the pin on the wrench (on OUT indicated side) into the wrench support hole, and insert other pin into the hole on releasing wrench.
2. Insert can be uninstalled by rotating the wrench counter clock wise. (A magnet is installed out side)

Note) Use appropriate wrench for set up.

Recommended Cutting Conditions

Workpiece Material		Hardness (HB)	Recommended Insert Grade (Cutting Speed Vc: m/min)		fz (mm/t)				Remarks
			CVD Coated Carbide	PVD Coated Carbide	Edge Width (mm)				
			CA0835	**PR0735**	1.6	2.2	3.0	4.0	
Low Carbon Steel	St42-2 C10E~C25	125	250-310	200-250	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	Coolant
Carbon Steel	C30~C60 (Annealed)	190	160-190	130-160	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	
	C30~C60 (Heat treated)	250	140-180	110-150	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	
Alloy Steel	34CrMo4 (Annealed)	180	140-180	110-150	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	
	34CrMo4 (Heat treated)	275	120-160	100-130	0.03-0.10	0.04-0.12	0.06-0.16	0.08-0.18	
High Carbon Carbide	X40CrMoV51, etc.	280	100-140	80-120	0.03-0.10	0.04-0.12	0.06-0.16	0.08-0.18	
Stainless Steel	X5CrNi1810, etc.	220	150-190	80-120	0.03-0.10	0.04-0.12	0.06-0.16	0.08-0.18	
	X10Cr13, etc.	300	140-180	60-80	0.03-0.10	0.04-0.12	0.06-0.16	0.08-0.18	
Gray Cast Iron	GG25~GG35	260	160-200	-	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	Dry
Nodular Cast Iron	GGG40~GGG50	160	130-160	-	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	
	GGG60~GGG80	250	110-140	-	0.03-0.12	0.04-0.14	0.06-0.18	0.08-0.20	

Note) 1. Use down-cut machining.
2. If ap is under 1/10 of Cutter Dia.(øD), it is possible to increase feed per tooth(fz) 40%.