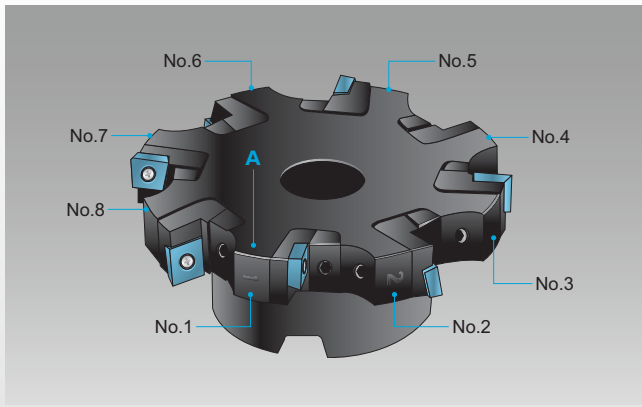
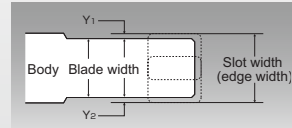


Slot width (edge width) adjustment of MSTC slot mills

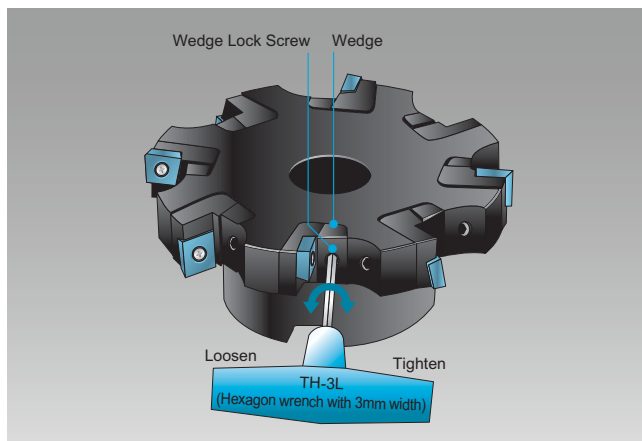
Slot width (edge width) measurement



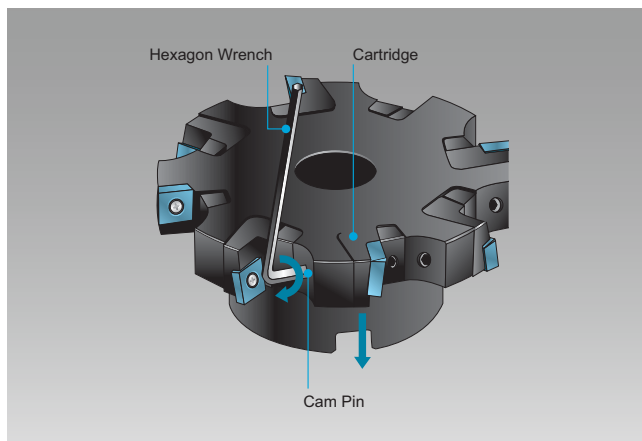
- 1) Please check slot mill edge location number.
(The edge location number is marked on the slot mill body.)
- 2) Set up the slot mill on length measuring equipment such as tool presettlers.
- 3) Place the point A of the slot mill body near the position No.1 to "0 (zero)" of the length measuring equipment.
- 4) Move the length measuring equipment to the insert corner part and measure the step (Y1) between the point A and the insert No.1.
- 5) Likewise, measure the step between the slot mill body and the insert, and you will obtain the slot width (edge width).



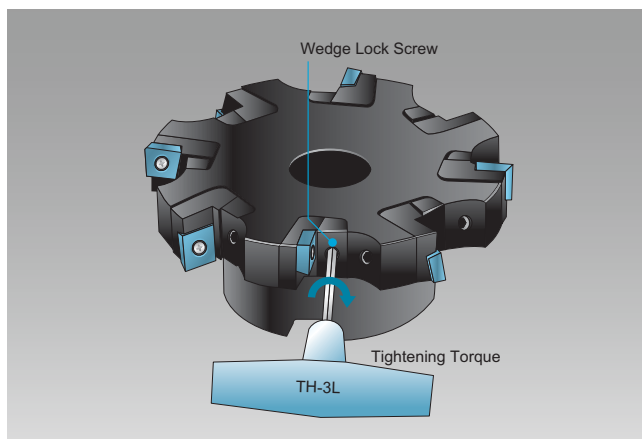
In the case of changing the slot width (edge width)



- 1) Set up the slot mill on length measuring equipment such as tool presettlers.
- 2) Insert a 3mm Hexagon wrench (TH-3L) into the wedge screw.
- 3) Turn TH-3L counterclockwise to loosen the Wedge.
- 4) Turn TH-3L clockwise by the torque of 1 Nm to tighten the wedge lightly and make the wedge to contact the cartridge and the slot mill body. In doing so, some resistance occurs against the cartridge.

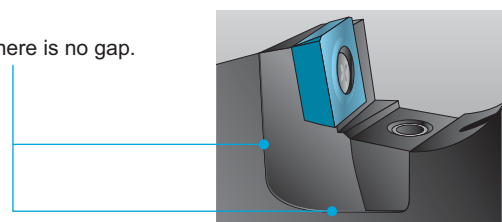


- 5) Insert a Hexagon wrench (LW-2.5 or LW-3) into the Cam Pin on the back of the cartridge.
- 6) Turn the wrench and adjust the position of the Cartridge.
- 7) To secure the adjustment, back the Cam Pin off and make sure that it does not touch the groove surface of the back of the Cartridge.
- 8) Remove the Hexagon wrench from the Cam Pin.



- 9) Insert TH-3L into the Wedge Screw.
- 10) Tighten the Wedge Screw by the torque of 5-6Nm.
(Use a torque wrench to get the correct torque.)
- 11) Make sure there is no gap between the Cartridge and the Slot Mill body.

Make sure there is no gap.



M



Milling