

# Points of Insert Replacement Procedure

Tools used



Special wrench



Diamond file



Gold brush

① With the insert attached to the cutter, apply a gold brush from the flank side toward the squeeze side.



### One-point advice

The tool is hot immediately after machining.

Wear hands when working.

Inserts may be removed,

It is easier to work with the cutter attached.

After the work, touch it with your finger to check the condition.

(Use caution when welding is left, as there is a risk of injury.)

If the weld cannot be removed with a gold brush,

use the edge of the diamond file and tilt the weld to

the squeeze face side.(Refer to the figure on the left.)

② Apply a diamond file to the squeeze plane.

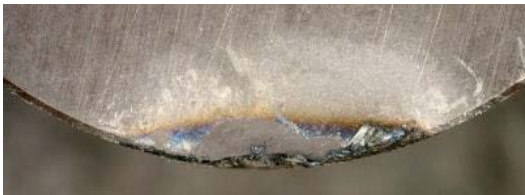


### One-point advice

In order to remove the welding protruding in the squeeze surface direction in the manufacturing process ①, confirm that there is no welding on the flank surface side.

If welding remains on the squid surface, the insert may float. Remove it properly.

Immediately after machining



After gold brushing



After diamond file processing



- ③ Remove the insert and clean the insert seating surface with an air blow.
- ④ Fit the insert firmly against the seating and restraining surfaces.



Recommended tightening torque: 5 N·m or more

### One-point advice

Fit the presser foot so that its tip clamps the center of the insert.

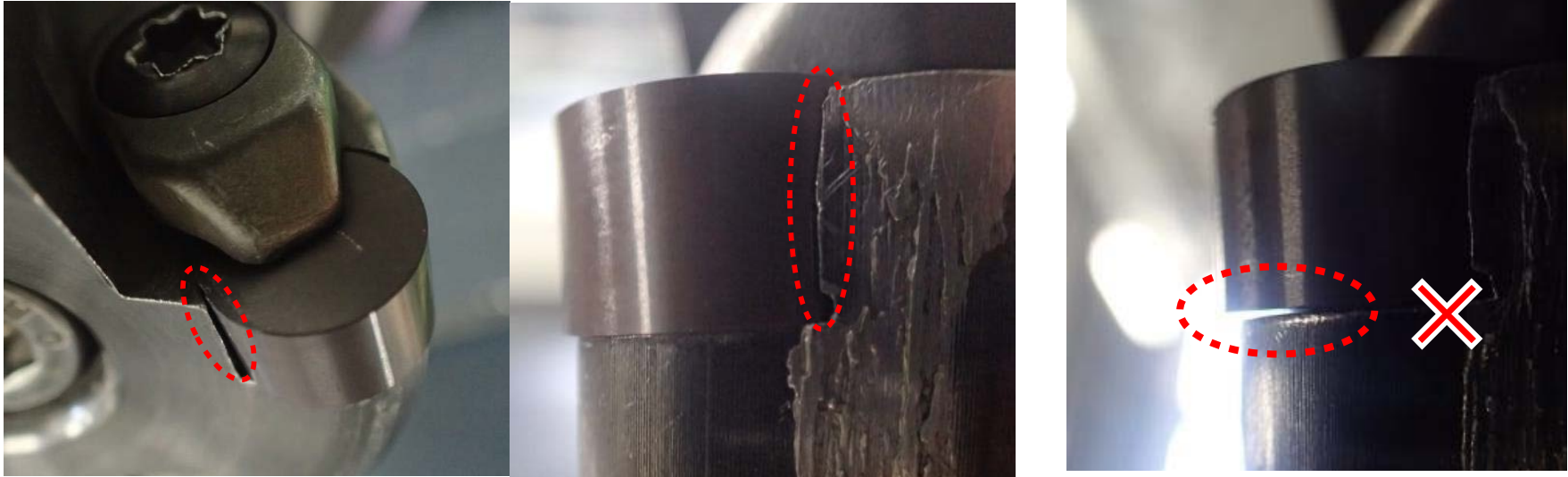
Hold by hand until the clamp is complete.

Insert the wrench perpendicular to the screw and tighten.



The use of a T-type wrench (sold separately) results in better workability.

⑤ Ensure that the inserts are in place without gaps.



### One-point advice

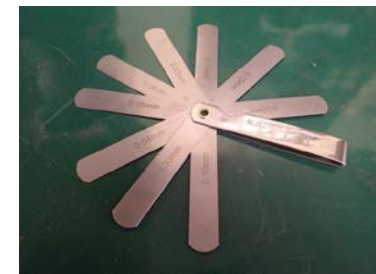
Gaps are easily visible when checked against a light background.

When machining in a state with a gap, there is a possibility that chatter and defects occur.

Since the holder is also a consumable part, the shape of the insert mounting part is lost.

Therefore, the holder should also be replaced periodically.

(The figure on the upper right is a bad example.)



For more accurate confirmation, shim sheets may be used.

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**CUTTING TOOLS**