
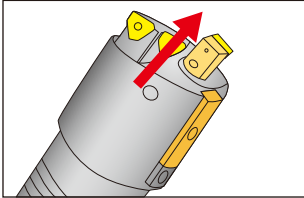


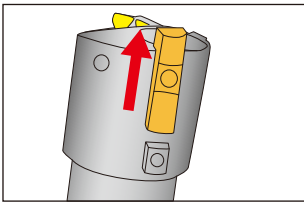
# UNIDEX Diameter Setting

The Drill Head diameter is set and inspected with a master insert in our final inspection. However, the inserts in the market have a tolerance fluctuation so each time you change or index the insert, the diameter must be adjusted as per the following method.

 When a corner change is made on the insert, it must be adjusted to correct size or a damage can be caused to the head body or a work piece material.



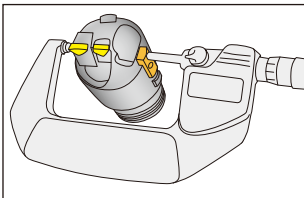
**1** Remove the inner cartridge to avoid interference with the guide screw.



**2** The dimensional guide pad must be slid forward to measure the diameter.

**2-1** Loosen the lock screw and slide the guide pad forward.

**2-2** Retighten the lock screw at the measuring position.

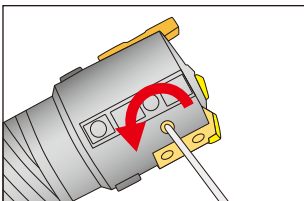


**3** Measure the diameter with a micrometer.

We recommend setting the tool diameter at  $h8$  tolerance to the cutting diameter.

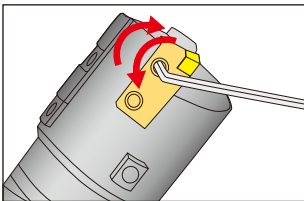
If the diameter is incorrect, go to below step **4**

If it's correct, go to below step **5**

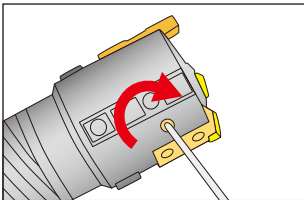


**4** Adjust the peripheral cartridge

**4-1** First loosen the lock screw of the peripheral cartridge and then tighten it slightly.




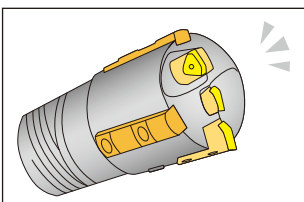
**4-2** Proceed to adjust the diameter, using the 2 adjust screws and measure with a micrometer.



**4-3** When set to the size, retighten the lock screw.


**4-4** Recheck the diameter with a micrometer. If it is still out of tolerance, repeat the procedure from the step **4-1**

 Please make sure to tighten the lock screw firmly before using. If loose, the cartridge may move and cause serious problems during machining.



**5** Slide the dimensional guide pad back to the original position and tighten the lock screw.

**6** Replace the inner cartridge and tighten the lock screw.

 Please check all the lock screws are firmly tightened as they may come loose if vibration occurs during drilling.