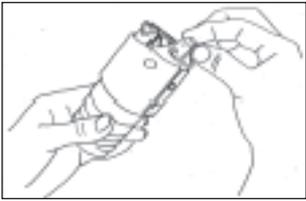
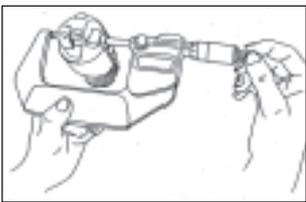
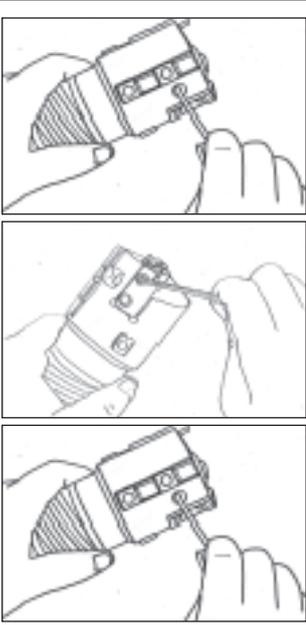
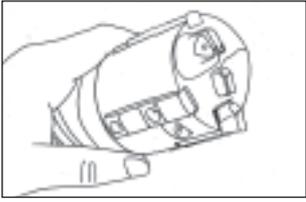


Cartridge style Drill Head diameter setting

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.

—☞ Note: 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.

	<p>1. Remove the inner cartridge to avoid interference with the guide screw.</p>
	<p>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.</p>
	<p>3. Measure the diameter with a micrometer. We recommend setting the tool diameter at h8 tolerance to the cutting diameter.</p> <p>▶ If the diameter is incorrect, go to below step 4. ▶ If it's correct, go to below step 5.</p>
	<p>4. Adjust the outer cartridge</p> <p>4-1. First loosen the lock screw of the outer cartridge and then tighten it slightly.</p> <p>4-2. Proceed to adjust the diameter, using the 2 adjust screws and measure with a micrometer.</p> <p>4-3. When set to the size, retighten the lock screw.</p> <p>4-4. Recheck the diameter with a micrometer. If it is still out of tolerance, repeat the procedure from the step (4-1).</p> <p>—☞ Note : Please make sure to tighten the lock screw firmly before using. If loose, the cartridge may move and cause serious problems during machining.</p>
	<p>5. Slide the dimensional guide pad back to the original position and tighten the lock screw.</p> <p>6. Replace the inner cartridge and tighten the lock screw.</p> <p>—☞ Note : Please check all the lock screws are firmly tightened as they may come loose if vibration occurs during drilling.</p>