

- **Before being used for the first time**, the milling cutter must be carefully cleaned of anti-corrosive materials, dust, etc.
- The milling cutter should only be washed when all components have been dismantled.
- Only the double-threaded screws of the clamping or adjusting wedge should be lubricated with copper grease; all other components must have clean metallic surfaces.
- A torque wrench is recommended to tighten the double-threaded screws.
- When fitting indexable inserts on the milling cutter, ensure that they are inserted in the correct position in a clean insert seat, and that they are held in position during clamping.

**For 45° roughing mills** without anvils, the following rules must be observed:

- The double-threaded screws on the clamping wedges for the indexable inserts are first pre-tightened to approximately 2 Nm (18 in.-lbs.) and then tightened to a final torque of 7 Nm (62 in.-lbs.).

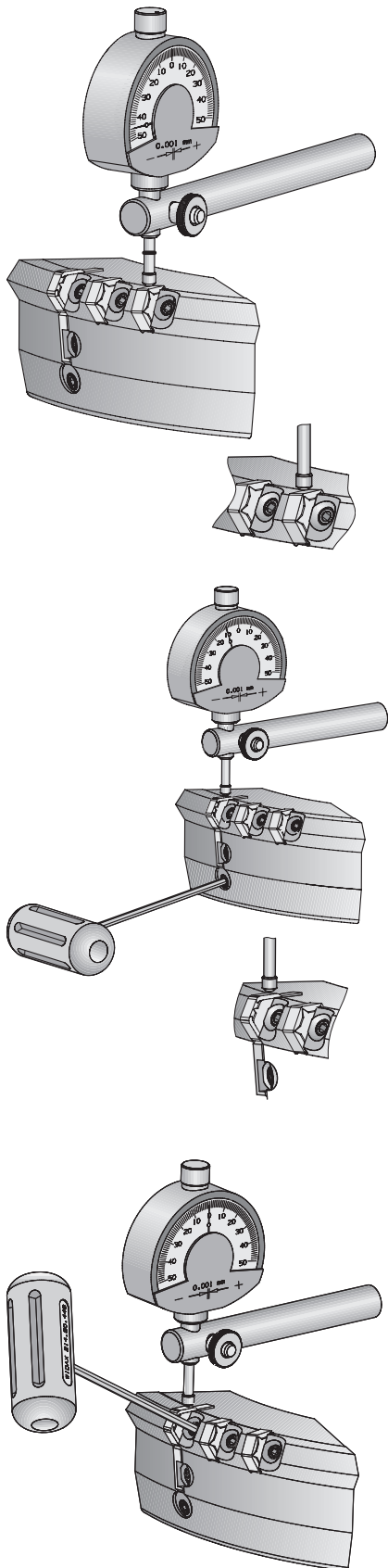
**Attention:**

**At each tool adjustment** the body, indexable inserts, and spare parts must be checked and replaced, if necessary.

**Before each tool use** the double-threaded screws of the indexable inserts and the stops must be tightened in the specified order to a torque of 7 Nm (62 in.-lbs.) In addition, even if the anvils have not been adjusted, the double-threaded screws of the adjusting wedges must be checked to see if these have been tightened to a torque of 3 Nm (26 in.-lbs.). If not, they must be re-tightened to this torque.

**The tools must be used only in accordance with their intended function. Kennametal accepts no liability for the improper use of tools or for their proper use in improper applications.**

**Kennametal accepts no liability for issues arising out of changes of any kind or printing errors that are not within Kennametal's control.**



This procedure is to be used on all 30° lead roughing/finishing mills using the unmarked roughing anvil, the finishing anvil (marked ●), and the corrected edge anvil (marked ■). These steps must be followed when adjusting the cutters for finishing inserts.

- 1.) Clean all insert pockets.
- 2.) Install all wedges and anvils. Torque the anvil lock wedge screw to 3 Nm (26 in.-lbs.).
- 3.) Install all inserts, making sure they are seated properly in the pocket, and torque the insert lock wedge screws to 3 Nm (26 in.-lbs.).
- 4.) Torque the wedge screws for all fixed pocket inserts to 7 Nm (62 in.-lbs.).
- 5.) Loosen the anvil insert wedge screw and the anvil lock wedge screw.
- 6.) Pressing the insert into the anvil pocket, adjust the anvil to 0,20-0,30 mm (.008 in. - .012 in.) below the fixed pocket inserts.
- 7.) Torque the insert lock wedge screw and the anvil lock wedge screw to 3 Nm (26 in.-lbs.).
- 8.) Adjust the axial position to 0,03-0,04 mm (.0010 in. - .0015 in.) above the fixed pocket inserts.
- 9.) Loosen the anvil insert lock wedge screws and then re-torque to 3 Nm (26 in.-lbs.).
- 10.) Adjust the axial position to the final dimension, 0,04-0,05 mm (.0015 in. - .0020 in.) above the highest fixed pocket insert.
- 11.) Torque the insert lock wedge screws and the anvil lock wedge screws to 7 Nm (62 in.-lbs.).
- 12.) Conduct a final check of the axial run-out and position.