

## Adjusting and handling instructions for HFC

### Operational procedure

1. Loosen the axial adjustment screw
2. Install the inserts (initially tighten)
3. Clean the inserts
4. Adjust height of inserts (initial)
5. Tighten the wedge set screw
6. Adjust height of inserts (final)

#### Tools for set up

- Tool presetter
- Air blower
- Clay
- 4.0mm Hex wrench
- 2.5mm Hex torque-wrench

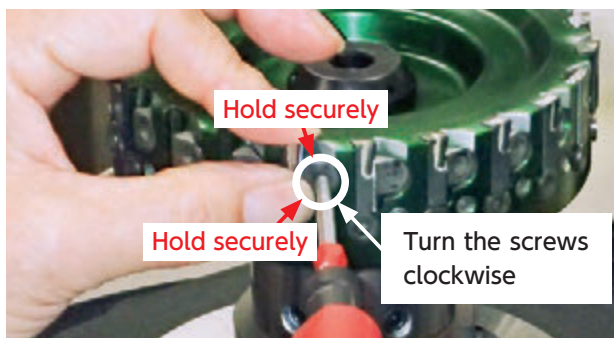


### 1. Loosen the axial adjustment screw



Loosen axial set screw until the screw head is 1 to 2 mm from cutter body. Clean up insert pocket using air.

### 2. Install the inserts (initially tighten)



Install the insert to cutter pocket. Tighten wedge set screw with 1Nm torque while pushing insert to cutter center using two fingers. (do not overtighten)

### 3. Clean the inserts



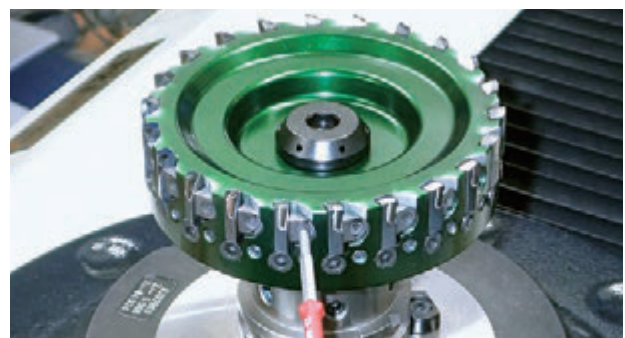
Clean up insert edges using clay.

### 4. Adjust height of inserts (initial)



Tighten axial set screw of each insert until you reach around 44.980 mm height dimension. Adjust other inserts within 0.01mm range.

### 5. Tighten the wedge set screw



Tighten wedge set screws with 4Nm torque.

### 6. Adjust height of inserts (final)



Tighten axial set screws to get 45.000 mm height dimension. Adjust other inserts within +/- 0.002 mm range.