

Please read these instructions before use and keep them where the operator may refer to them whenever necessary.

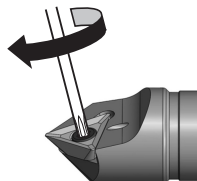
OPERATION MANUAL DOWNLOAD SITE
http://big-daishowa.com/manual_index.php



HOW TO ATTACH INSERTS

- Before attaching inserts, remove any alien particles on the insert seat with air blowing.
- Wipe the side and back faces of inserts with a waste thoroughly.
- Tighten the screw while lightly pressing of the insert.
- Do not tighten a insert clamping screw with more clamping torque than those in the figure shown right. Otherwise, an insert, may come to be broken.
- Ensure that there is no space between the insert and the insert seat.

Insert	Clamping torque (N·m)
CN0406	0.5
CN0606	1.0
CN0906	3.5



(INSERT AND PARTS)

Insert	Insert clamping screw set
CN0406	S2S-6IP
CN0606	S2.5S-8IP
CN0906	S4S-15IP

- The insert clamping screw set includes 10 screws and 1 exclusive wrench.



CAUTIONS

- Do not use other insert clamping screw than the accessory or genuine.
- Be careful not to cut yourself when exchanging inserts.
- Replace the screw periodically since they are consumption parts.
- Do not use the wrench whose tip is damaged and the clamping screw whose hole is damaged.

ABOUT CUTTING CONDITION

- Refer to the catalogue for the standard cutting condition.
 - For centering, always use soluble oil.
 - For chamfering, dry cutting (including air blowing) is basically recommended. However, in case that severe built-up edge occurs for cutting aluminum, use soluble oil.
 - When large centering is needed, lower cutting condition and/or add step feed.
 - If large chamfer is needed, increase No. of cuts (# of pecking for chamfering a bore), or decrease a cutting speed.
 - If edges with large burrs left are chamfered, an insert comes to be chipped. Burrs should be removed as much as possible e.g. by changing a cutting tool earlier.
 - Retain as short projection length of the tool as possible.
 - Hand feed is not recommended.
 - Do not exceed a cutting condition in the catalogue or the maximum rotational speed of 20,000min⁻¹.
- ※Centering can not be done by multiple cutting edge cutters.



CAUTIONS

- Do not cut under inappropriate cutting condition.
- Do not use after the body is bumped and strongly shocked.
- The tool is in the state of high temperature during cutting. There is a danger of a burn, if it is touched soon after cutting is done.
- Minimize the overhang of the tool for use.
- Use the machine tool with sufficient rigidity and horsepower.
- Use a cover on a machine tool and a protector such as glasses against shattering chips and broken tools due to misuse.
- Do not use insoluble oil, because there is a danger of causing fire.