

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 foreign particles on insert seats with compressed air.
- Wipe the side and back faces of the inserts thoroughly.
- Tighten the screw while lightly pressing the insert into its seat.
- Make sure that there is no gap between the insert and the insert seat.

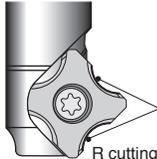


CAUTIONS

- Do not use other insert clamping screws than the original or genuine new ones.
- When exchanging an insert, be careful not to cut your hands with its edges.
- Periodically replace insert clamping screws and wrenches that are consumable.
- Do not use any wrenches or clamping screws that are damaged on their tips or holes.

ABOUT CUTTING CONDITION

- Refer to the catalogue of "General Catalog" for standard cutting conditions.
- Refer to the catalogue of "General Catalog" concerning the position of the R cutting edge for programming.
- Edges other than R cutting edges cannot be used for cutting .
- Dry cutting (including air blow) is recommended. However, if severe built-up edge occurs when machining aluminum and stainless steel, usage of coolant may result in longer tool life.
- When chamfering edges with large burrs, an insert may chip. Burrs should be removed as much as possible in advance.
- If chatter occurs, reduce the radial depth of cut, or lower cutting speed.



R cutting edges



CAUTIONS

- Do not apply inappropriate cutting conditions.
- Do not use any cutters that have collided and suffered a strong impact.
- A cutter becomes very hot during cutting. Touching a cutter directly by hand soon after cutting will lead to severe burns.
- Minimize projection length of the cutter and tool holder.
- Use machine tools with sufficient rigidity and horsepower.
- To prevent chips and broken tools from scattering, install a safety cover on the machine tool and use safety glasses.
- Do not use insoluble oil that may cause fire.
- Do not exceed the maximum rotational speed of 20,000min⁻¹.

INSERT&PARTS

Insert	Insert clamping screw set	Tightening torque N·m (lbf·ft)
RC06...	S2TS-T6	0.5 (0.37)
RC12...	S4S-T15	3.5 (2.6)

- Refer to the catalogue of "General Catalog" for insert selections.
- The insert clamping screw set contains 10 screws and 1 exclusive wrench.