

NOTES ON USE

INSERT INSTALLATION

- Before inserting the insert into the holder, ensure that there are no foreign objects or dirt in the holder slot or slit. Clean using compressed air if necessary.
- Use the wrench provided to loosen the inner screw to open the tip of the holder, then place the insert into the holder slot as shown in figure 1.
★Ensure that the wrench is firmly in contact with the base of the inner screw head when tightening.
- After the insert has been set in the holder slot, tighten the inner screw while pushing the insert lightly into the pocket as shown in figure 2 to securely clamp and locate the insert.
★Ensure that the wrench is firmly in contact with the base of the inner screw head when tightening.

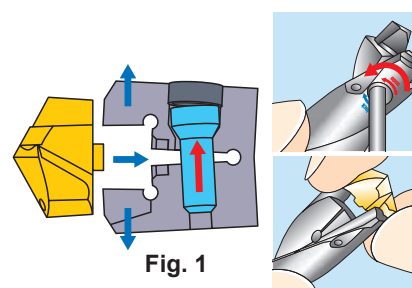
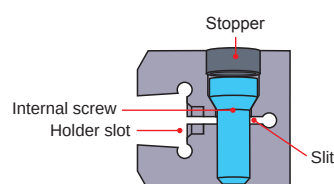


Fig. 1

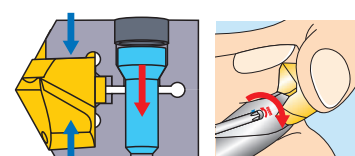
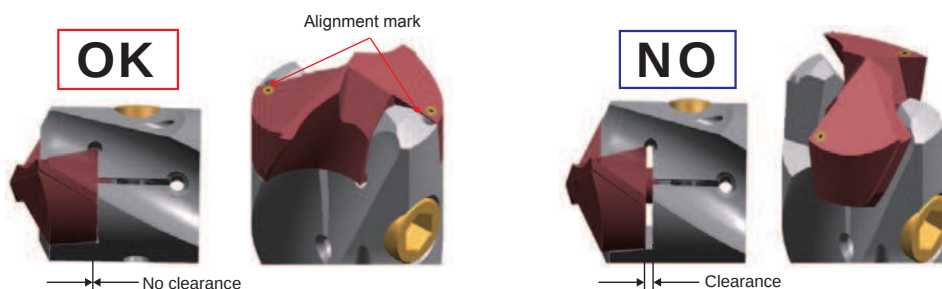


Fig. 2

Tighten the clamp screw according to the torque below.

Drill Dia. (mm)	Torque N·m
10 —12.9	1
13 —15.4	2
15.5 —18.4	2.5

- Check there is no gap between the bottom of the insert and holder slot.



(Note) Poor or incorrect clamping of inserts can cause poor drilling performance and/or drill breakage. Therefore ensure that the alignment marks on both the body and insert are aligned when setting. When machining, use safety guards and goggles.

SPARE PARTS

Applicable Holder	Pack Order Number (Internal screw & stopper)		
		Internal screw	Stopper
STAWSS/SN/MN/LN1000S16	WS203107TPS-35LH	WS203107TPS	WS35LH
STAWSS/SN/MN/LN1050S16	WS203107TPS-35LH	WS203107TPS	WS35LH
STAWSS/SN/MN/LN1100S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1150S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1200S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1250S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1300S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1350S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1400S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1450S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1500S20	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1600S20	WS304912TPS-55LH	WS304912TPS	WS55LH
STAWSS/SN/MN/LN1700S20	WS304912TPS-55LH	WS304912TPS	WS55LH
STAWSS/SN/MN/LN1800S20	WS304912TPS-55LH	WS304912TPS	WS55LH

(Note) The parts are packaged internal screw, stopper and operation manual. Please replace the parts in accordance with the operation manual.