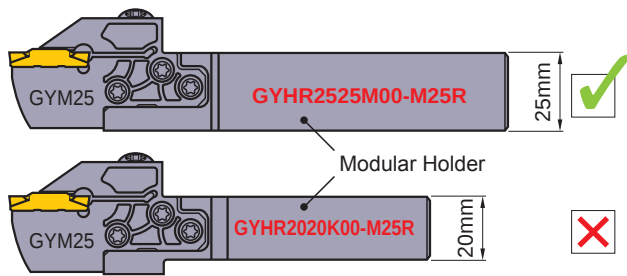


TOOL SELECTION

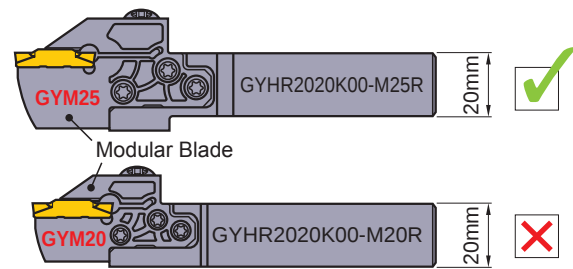
Notes when selecting the tool body

Modular holder



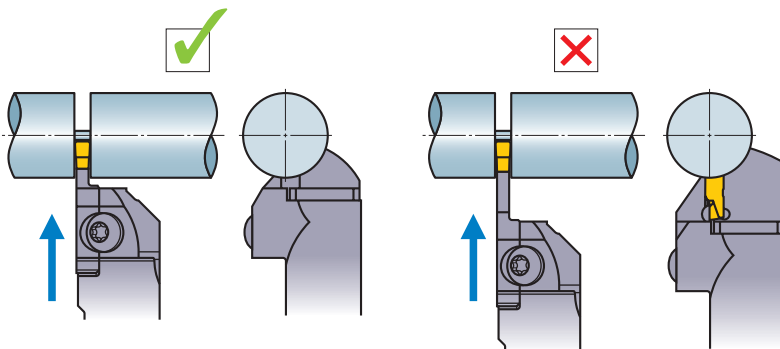
●To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

Modular blade (1)



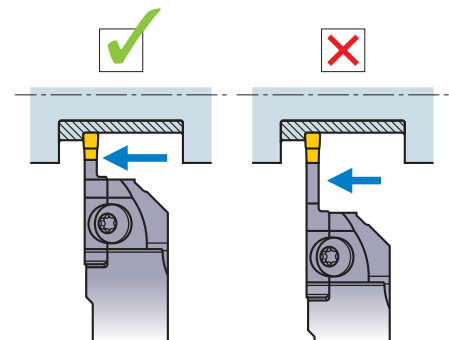
●If there is no restriction for use, select the largest modular blade for the same shank size.

Modular blade (2)



●Select the shortest possible blade suitable for the application.

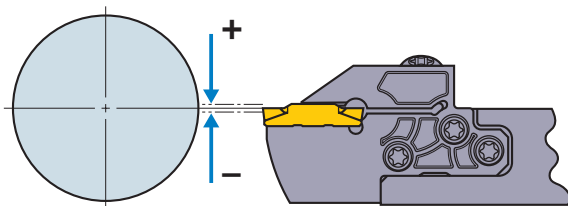
Modular blade (3)



●Select the shortest possible blade suitable for the application.

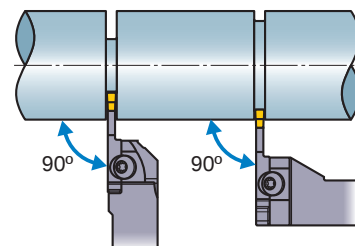
Notes when setting the tool

Setting of cutting edge height



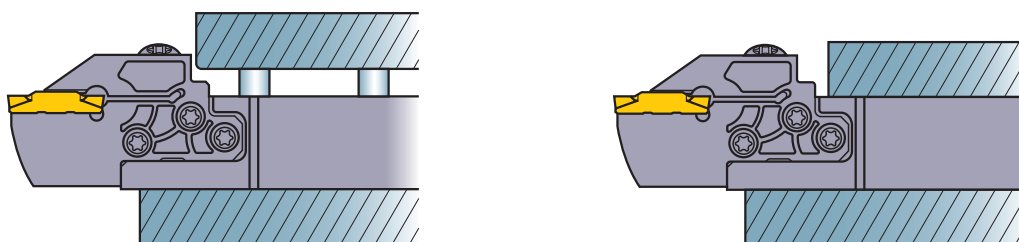
<Grooving/Cross-feed machining>
Set the cutting edge height to $\pm 0.1\text{mm}$ parallel to the central axis.
<Cutting off>
Set the cutting edge height to $0\text{--}+0.2\text{mm}$ parallel to the central axis.

Tool body setting angle



●Set the insert perpendicular to the central axis.

Overhang



●When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.