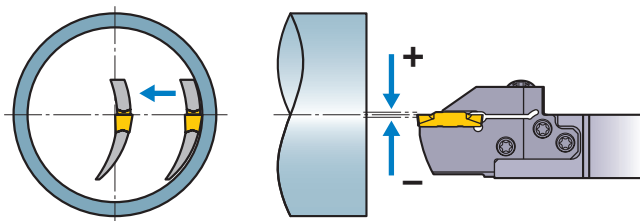


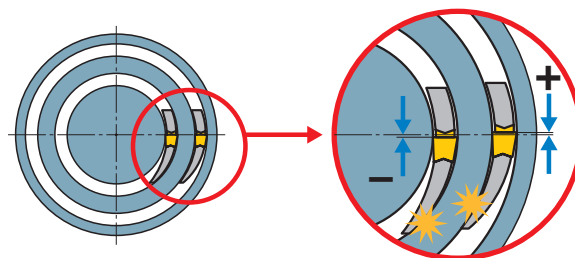
● Notes when setting the tool

Setting the cutting edge height



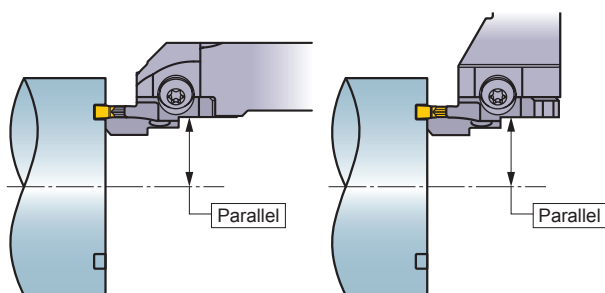
- Set the cutting edge height to $\pm 0.1\text{mm}$ parallel to the central axis.
- Cutting edge centre height check should be done by traverse machining towards the centre with a very small depth of cut and ensure that an even surface and no material remains at the centre point afterwards.

When interfering the wall of groove and the Modular blade



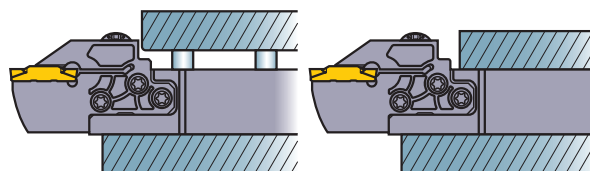
- If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.
 - When interference occurs on the inner side of the blade, the cutting edge height is set too high.
 - When interference occurs on the outer side of the blade, the cutting edge height is set too low.

Setting the tool



- Set the insert parallel to the central axis.

Tool overhang



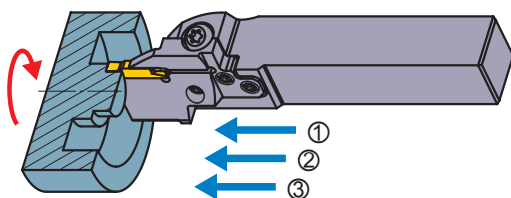
- When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

● Notes when face grooving (1)

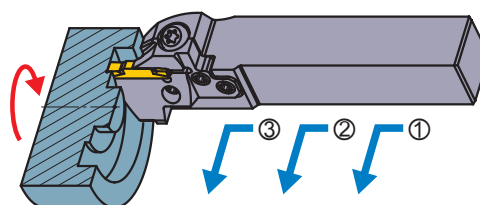
- Always machine from the outer diameter towards the centre.

Machining narrow grooves



- Plunging in several passes is recommended.

Machining wide grooves



- Cross feed machining is recommended.