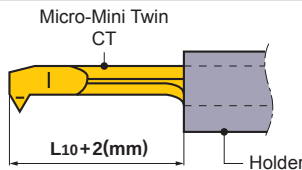


RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Recommended Tool Overhang (mm)
P	Carbon Steel Alloy Steel	50 (30—80)	
M	Stainless Steel	50 (30—80)	
K	Cast Iron	50 (30—80)	
N	Non-Ferrous Metal	80 (50—100)	

(Note 1) Wet cutting is recommended.

(Note 2) Pay special attention to machining of small diameters at high revolutions as the feed rate cannot keep up with the speed.

PRECAUTIONS WHEN USING THE MICRO-MINI TWIN

● When using a holder for general purpose / small automatic lathe:

① To avoid chipping of the 2nd cutting edge take care when inserting the boring bar into the holder. Refer to fig.1. If the 2nd edge contacts the internal face of the holder there is a possibility that it may chip.

② When using this type of holder, there is a possibility that damage to the shank and the 2nd cutting edge can occur. Make sure that the clamping screws are tightened to the set torque value. Additionally make sure that there is no clamping screw near the 2nd cutting edge as this can break the boring bar.

◎ When using Mitsubishi holders

When using holders with a tool overhang of recommended quantity, ensure that the 3rd clamping screw is removed prior to machining. The set torque value for the clamping screw is 2.0 N • m.

● When using a square type holder:

① When installing the boring bar into the holder, tighten the clamp screws after ensuring the flats on the tool holder are parallel to the reference flats on the micro-mini bar. Refer to fig.3.

② Make sure that the clamping screws are tightened to the recommended values.

③ Do not tighten the clamp screw without a bar in place, otherwise the bridge will be deformed.

