

ROTATING TOOLS

INSTRUCTIONS FOR USE OF WIPER INSERTS



Fig.1



Fig.2

- Wiper inserts for ASX445 are single-cornered.
- When installing the wiper insert, place the insert so that the cutting edge is located as shown Fig.1. Do not install the wiper insert as Fig.2
- Recommended depth of cut is $a_p = 0.2-0.5(\text{mm})$.
(Be aware of cutting load if the depth of cut is over the recommendation.)
- The major cutting edge of a wiper insert should be set inside as shown. This is to prevent heavy loads on the wiper and ensure the regular insert after the wiper takes the cutting load. To prevent fracture, set the feed under 0.2mm/tooth .
- Excellent finished surfaces can be achieved with one wiper.
- Set more than 2 wiper inserts, equally spaced, when the feed per revolution is larger than the width of the wiper edge.

RECOMMENDED CUTTING CONDITIONS WHEN USING A WIPER INSERT

Work Material	Grade	Cutting Speed (m/min)
P	VP25N	200 (80—250)
	VP15TF	180 (80—250)
M	VP15TF	120—270
K	MC5020	130—250
	VP15TF	
S	VP15TF	20—50
H	VP15TF	40—80

- Recommended depth of cut (a_p) is $0.2\text{mm}-0.5\text{mm}$, and feed per tooth (f_z) is up to 0.2mm/t .