



## ADJUSTING GUIDELINE FACE MILLING CUTTER – PF1000 / ø 63

### 1. ASSEMBLY OF ADJUSTMENT UNIT

- Grease thread and functional areas with Molykote® assembly paste G-N Plus.
- Screw the threaded pin into the adjustment bolt (from flat side) and insert into the sleeve (note correct side) (fig. 1).
- Using the supplied cylinder screw insert the adjustment unit into holder bore of the tool body (if necessary turn threaded pin forwards or backwards) ensure the threaded pin is correctly aligned with the access bore.
- engage the hexagon (SW3) of the threaded pin via the access bore and unscrew anti-clockwise to the stop (fig. 2).

### 2. ASSEMBLY OF MILLING CUTTER INSERTS

- Insert cutter together with clamping wedge into the slot on the base body, to prevent misalignment of both components they must be pressed against the contact surfaces of the base body (fig. 3).
- From the outer side, screw the spindle (lightly grease both threads with Molykote® assembly paste G-N Plus) anti-clockwise into the clamping wedge (fig. 4) until the spindle projects into the inside of the milling head base body by approx. 2 threads (fig. 5). Position the nut on this thread and screw the nut on by turning the spindle clockwise. Now screw the spindle in further anti-clockwise, whilst constantly re-positioning the nut clockwise (screwing onto the spindle) until the spindle towards the centre is level with the nut (the re-positioning of the nut can be simplified via the bores on the external diameter of the nut with the help of a small pen key or similar).
- Now lightly tighten the spindle clockwise. Assemble all inserts in the same way. When assembled correctly there must still be play between the nuts (fig. 6). The tightening screw Guh. no. 3009 63,000 must be able to be guided centrally between the nuts without exerting force. Also the spindle on the outer side of the milling head must not protrude out of the clamping wedge.

### 3. ASSEMBLY OF MILLING CUTTER HEAD TO MILLING ARBOR

#### (for tightening torques apply our torque wrench Guh. no. 4915)

- Using the tightening screw, screw the milling cutter head onto the milling arbor, whilst observing the tightening torque: SW 28 → Ma = 40 Nm.
- Apply the hexagonal special insert #302921586 for the tightening screw.
- Also grease the threads and the contact surfaces of the tightening / clamping screw head with the assembly paste.



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### 4. ADJUSTING THE MILLING CUTTER INSERTS

(for tightening torques apply our torque wrench **Guh. no. 4915**)

- With all inserts in deepest axial position, tighten spindle to approx. 3-4 Nm (**spindleTorx 25, apply Torx insert Guh. no. 4917 25,000**).
- Adjust all inserts using angle screwdriver SW 3 (**Guh. no. 4921**) by turning the threaded pin of the adjustment unit clockwise to 0.02 mm before the setting measurement.
- Tighten all inserts in turn to 11 Nm.
- Adjust all inserts to setting measurement within max 0.004 mm.

### 5. DISASSEMBLY OF INSERTS

- Loosen tightening screw Guh. no. 3009 63,000 anti-clockwise and unscrew.
- Loosen spindle screw connection (Torx 25) anti-clockwise, now unscrew the nut anti-clockwise (with the pen key) towards the centre of the spindle, whilst constantly re-positioning the spindle in clockwise direction (unscrewing from the clamping wedge).

### 6. BALANCING THE MILLING CUTTER HEAD

- It is generally recommended to balance the milling arbor individually.
- Fine balance complete milling assembly with supplied balancing screws.

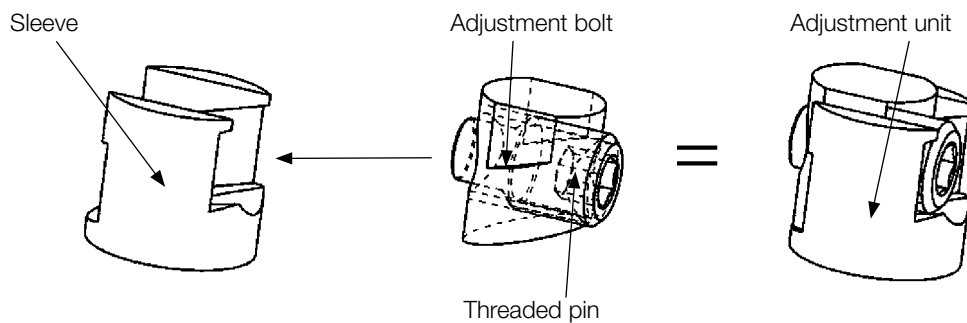


FIG. 1

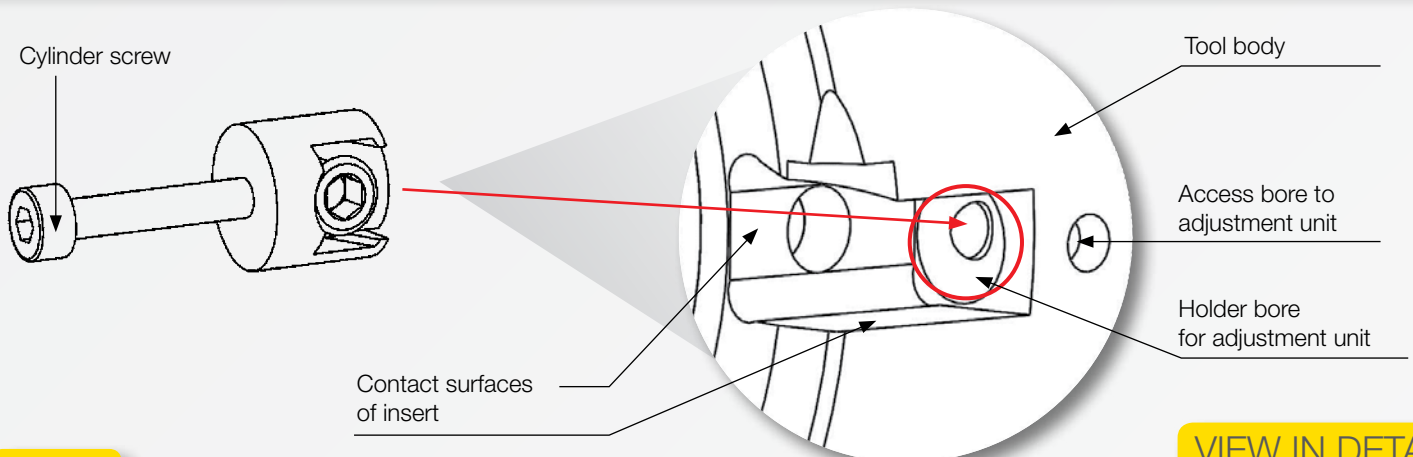


FIG. 2

VIEW IN DETAIL



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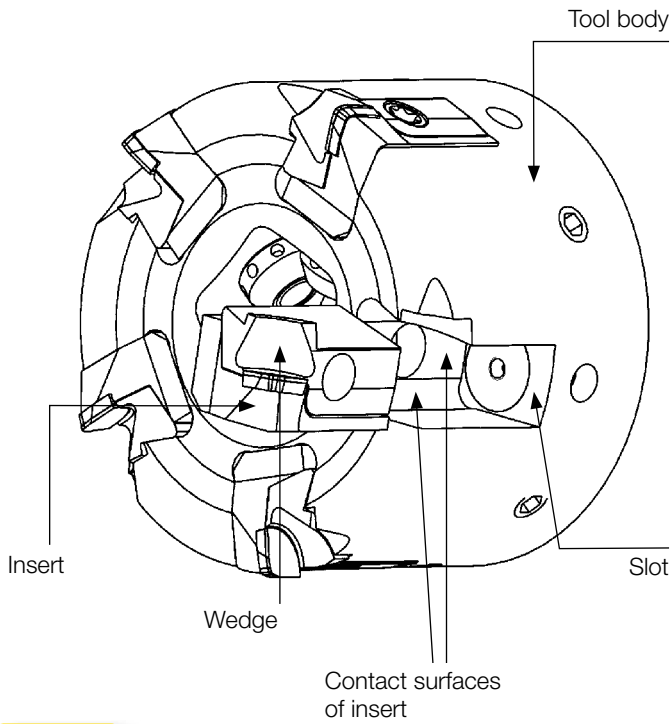


FIG. 3

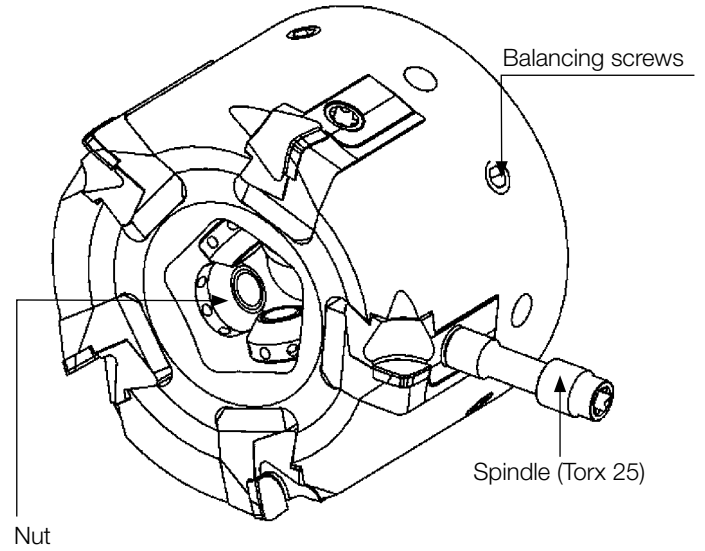


FIG. 4

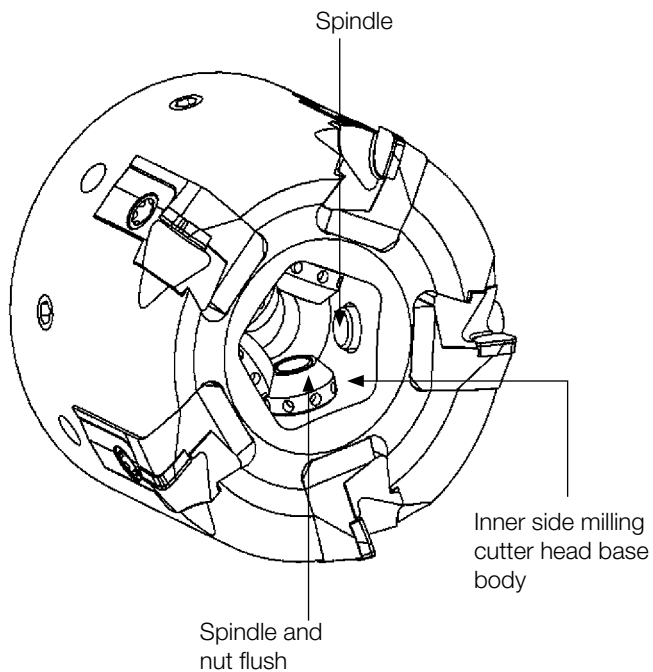


FIG. 5

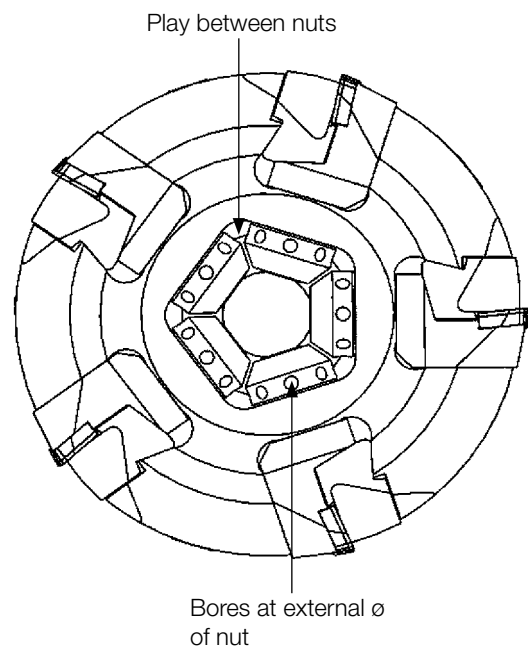


FIG. 6