



ADJUSTING GUIDELINE FACE MILLING CUTTER – PF1000

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)
- Aided by the supplied cylinder screw insert the adjustment unit into holder bore of the base 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 inner side, screw the spindle clockwise into the clamping wedge (Torx 25), grease the spindle thread and the contact surfaces of the spindle head beforehand with Molykote® assembly paste G-N Plus (fig. 4) **(don't use lubricant containing copper!)**.
- Assemble all inserts in the same way.

3. ASSEMBLY OF MILLING CUTTER HEAD TO MILLING ARBOR

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

- using the tightening screw (Guh. no. 3009 ...) / clamping disc (Guh. no. 3008 ...) screw the milling cutter head to the milling arbor observing tightening torques below:

Diameter ø [mm]	Wrench size [SW]	Tightening Torque Ma [Nm]	Diameter ø [mm]	Wrench size [SW]	Tightening Torque Ma [Nm]
ø 63	SW 28	Ma = 40 Nm	ø 80	SW 8	Ma = 70 Nm
ø 100	SW 10	Ma = 100 Nm	ø 125	SW 12	Ma = 160 Nm
ø 160	SW 10	Ma = 120 Nm	ø 200	SW 14	Ma = 200 Nm
ø 250	SW 14	Ma = 200 Nm			

- For screwing together ø 63 apply the hexagonal special insert #302921586, for other sizes our hexagonal inserts Guh. no. 4916.....
- Also grease the threads and the contact surfaces of the tightening / clamping screw head with the assembly paste;

4. ADJUSTING THE MILLING CUTTER INSERTS

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

- With all inserts in axially deepest 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 16 Nm.
- Adjust all inserts to setting measurement within max 0.004 mm.



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5. BALANCING THE MILLING CUTTER HEAD

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

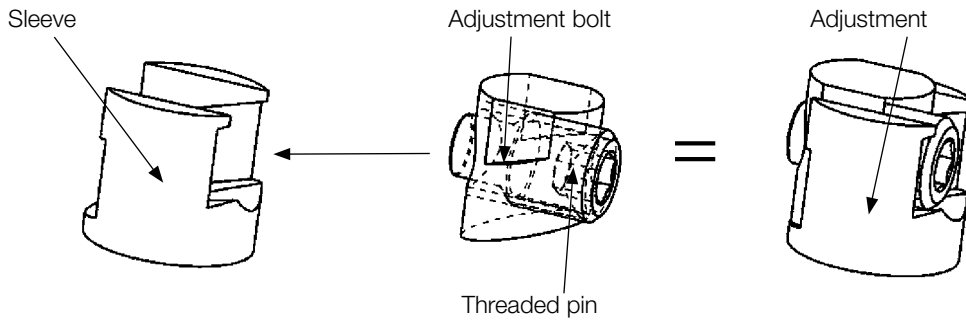


FIG. 1

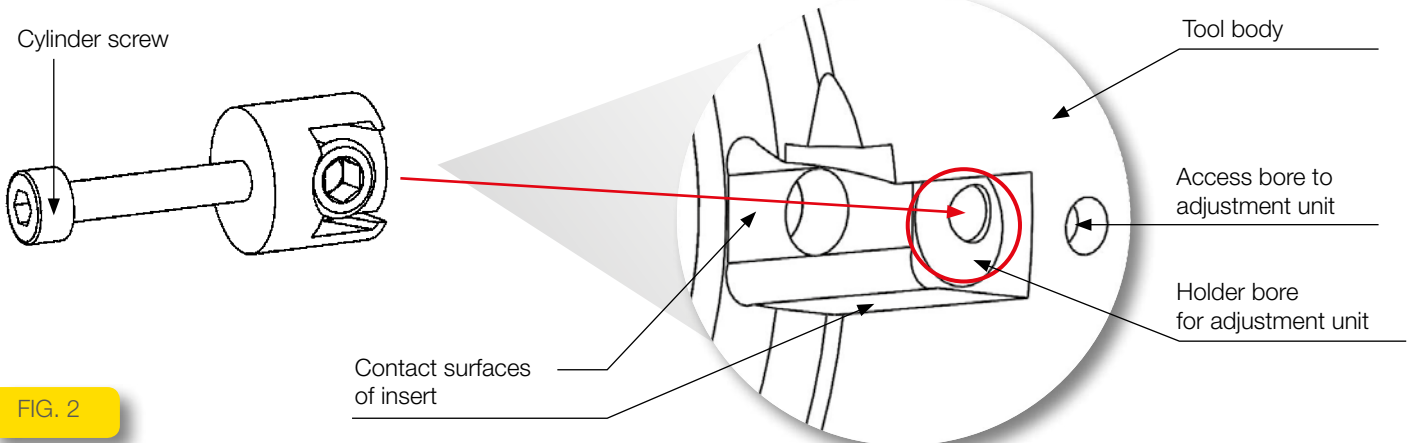


FIG. 2

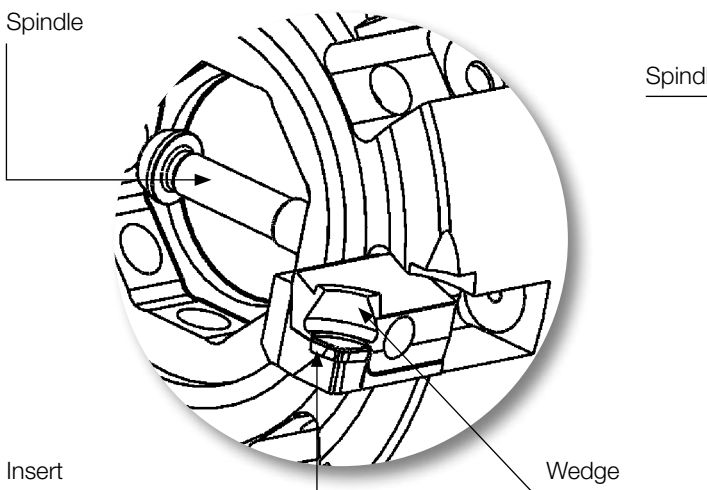


FIG. 3

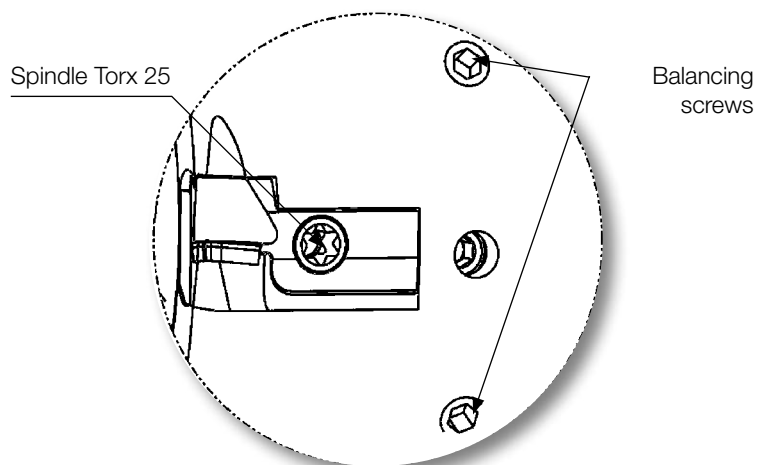


FIG. 4

VIEW IN DETAILS