

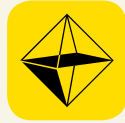
## ADJUSTING GUIDELINE THREADED WEDGE ADJUSTMENT (TWA) INDEXABLE INSERTS INSTALLATION

### 1. ASSEMBLY

- 1.1 Lightly lubricate the bottom and the walls of the location bore of the TWA as well as the thread of the setting screw with MOS2 assembly paste.
- 1.2 Locate the hexagonal key through the wedge into the setting screw and insert together into the base of the location bore of the adjustment unit (fig. 1).
- 1.3 Using the hexagonal key push the setting screw into the radial recess at the base of the bore and screw-in the wedge anticlockwise. When doing this the indexable insert contact surface on the wedge must be positioned towards the indexable insert seat (push the wedge from above onto the setting screw, so that the thread of the wedge can locate onto the setting screw). If when screwing in the wedge the collar of the setting screw “jams” in the location bore (noticeable through the setting screw being difficult to turn), push the entire adjustment unit fully into the location bore with the hexagonal key, if necessary resolve “jam” via clockwise rotation (fig. 2).
- 1.4 Lightly lubricate the indexable insert contact surface on the wedge with MOS2 assembly paste and screw in indexable insert in clockwise direction into the indexable insert seat with indexable insert clamping screw (lightly lubricate thread).
- 1.5 The disassembly is carried out in the reverse order

### 2. OPERATION

- 2.1 Using a Torx key lightly tighten the indexable insert clamping screw in a clockwise direction to the smallest diameter setting (wedge and setting screw).
- 2.2 Adjust indexable insert to 0.05 mm of diameter before the final dimension: Insert the hexagonal key in the setting screw and adjust the diameter in clockwise direction (fig. 3). Then tighten the indexable insert clamping screw to the specified tightening torque.
- 2.3 Adjust the indexable insert to the final dimension.
- 2.4 If the diameter has already been exceeded, loosen the adjustment in anti-clockwise direction until the wedge noticeably loosens and re-adjust in clockwise direction. To do this the indexable insert clamping screw does not require loosening.
- 2.5 When replacing the indexable insert or when required lubricate the contact surfaces and the thread of the TWA adjustment unit with MOS2 assembly paste.



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### 3. TIGHTENING TORQUE INDEXABLE INSERT CLAMPING SCREW:

Thread size	Torx size	Tightening torque [Ncm]
M4 / M4 x 0.5	15	515
3.5	15	345
M 2.5	8	128
M2.5 / M2.2	7	101

### 4. KEY SIZES OF THE TWA ADJUSTMENT UNITS AND THE ADJUSTMENT TRAVEL OF THE INDEXABLE INSERTS:

Insert Size	Socket	in radius (at ¼ rotation of setting screw)
0602..	SW 1.5	0.015 mm with indexable insert with 7° clearance angle or 0.024 with indexable insert with 11° clearance angle
09T3..	SW 2.5	
1204..	SW 3.0	

FIG. 1: Assembly (s. No. 1.2)

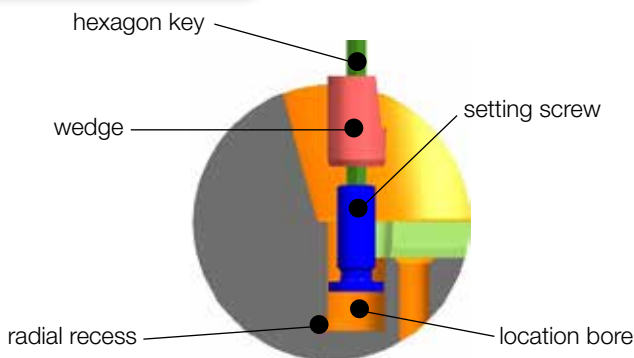


FIG. 2: Assembly (s. No. 1.3)

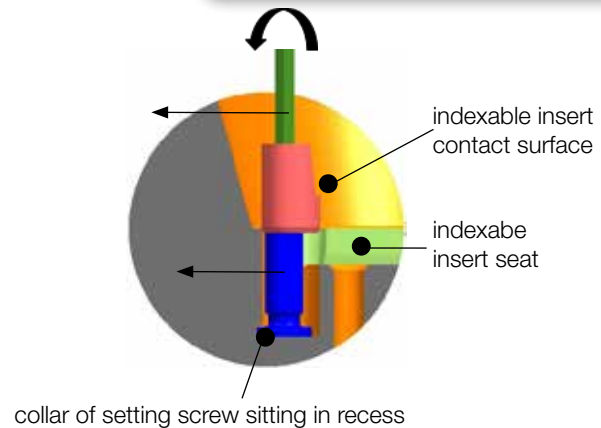


FIG. 3: Operation (s. No. 2.1)

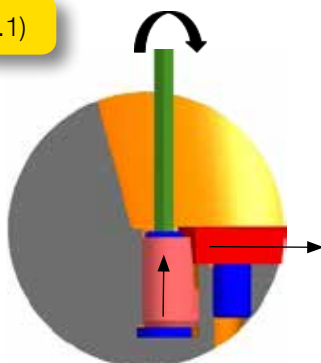


FIG. 4: Operation (s. No. 2.2)

