



## ADJUSTING GUIDELINE VARIABLE CLAMPING COMPONENT – GP100

### IN GENERAL

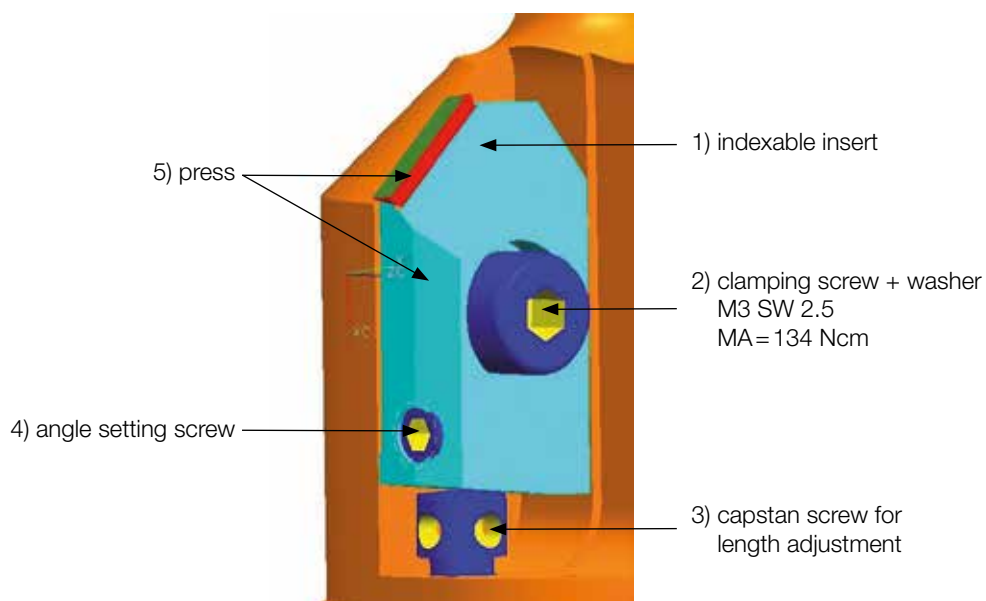
The angle to the center axis is manufactured  $0.5^\circ$  smaller than the corresponding nominal dimension and possesses a  $+1^\circ$  adjustment range.

The clamping claw is adjustable in length by  $\pm 0.2$  mm from the nominal dimension.  
Tools are supplied pre-set.

### SET-UP/FITTING

When replacing the indexable insert (1) proceed as follows:

- Loosen length setting screw (4) and angle setting screw by half a turn.
- Loosen / dismantle clamping screw (2).
- Clean and assemble components, lightly oil clamping screw (2).
- Gently tighten clamping screw (2) (approx. 20 Ncm). While doing so, press indexable insert and clamping claw in direction of arrow with thumb and index finger.
- Angle setting to  $0.1^\circ$  ahead of nominal dimension.
- Length setting to 0.05 less than nominal dimension.
- Angle setting screw (4) to nominal dimension.
- Length setting (3) to nominal dimension.
- Tightening clamping screw (2) to 134 Ncm.



Graphic: GP100  
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