

# DUO-LOCK® ASSEMBLY INSTRUCTION MANUAL



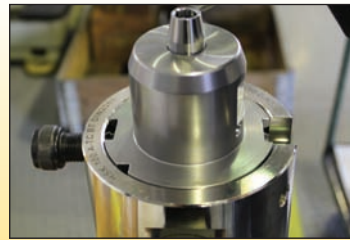
## Assembly

Please wear sufficient personal safety equipment such as gloves and eye protection during assembly.

- 1** >> Clean the Duo-Lock™ cutting insert and shank coupling.



- 2** >> Mount the Duo-Lock™ adaptor in a mounting block with a clamping chuck sufficient to enable torque transmission.



- 3** >> Screw the Duo-Lock™ cutting tip into adaptor by hand.

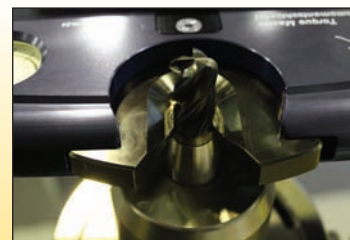
**Attention: Use of protective gloves is mandatory!**



- 4** >> A gap of approx. 0,15–0,3mm should be visible.



- 5** >> Apply the torque shown in the table. Use of a high quality common torque wrench is mandatory. The ERICKSON™ Torque Master wrench is recommended.



Duo-Lock™ Size	Torque Nm
DL 10	20
DL 12	30
DL 16	60
DL 20	80
DL 25	100
DL 32	130