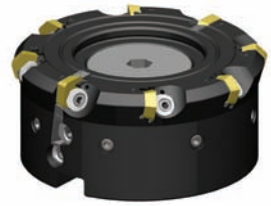


KCFM™ ASSEMBLY INSTRUCTION MANUAL



Safety Notes

Read all instructions	Wear eye protection	Inspect and tighten fasteners regularly	Warning: Cutting hazard	Warning: Hot surfaces	Do not exceed Max. RPM



Customer Information Sheet

Hexagon Insert Installation

A Position the differential screw in the pocket and turn it to approx. 2 to 3 turns with 3mm hex wrench.

B Place the wedge on the screw and fasten it into the cutter body.

C Push the insert into the pocket seat by hand in the direction shown.

D Tighten the screw with a clamping torque of 2 Nm (18 in/lbs). The differential screw must not stick out of wedge.

E Repeat steps A-D for all inserts. Max. axial and radial runout must be within 0.03mm (0.0012") and 0.035mm (0.0014").

Tighten all the differential screws with a clamping torque of 7 Nm (62 in/lbs).

NOTE: The cutter comes preloaded with screw and wedge. Steps A and B are only required when it is necessary to change the screw and/or clamp after wear and tear or an accident. Insert changing process starts at step C in normal circumstances.

Wiper Insert Installation

1 Mount the cartridge in its pocket, similar to steps A and B as shown previously.

2 Begin tightening the screw 2 of the cartridge locking wedge to clamp the cartridge with minimum torque.

3 Place the insert on the cartridge and begin tightening the screw 3 to clamp the insert with minimum torque.

4 Release the height adjusting screw 1 slightly and adjust the wiper insert's position so that it is 0.03mm (0.0012") above the highest semi-finishing insert.

5 The wiper inserts should be clamped in the same way as the hexagon inserts.

Tighten the insert screws 3 and cartridge screw 2 of wiper pockets to 2 Nm (18 in/lbs) and then to 7 Nm (62 in/lbs).

Axial runout measured at the highest point on wiper insert should be $\leq 0.003\text{mm}$.

NOTE: When the cutter comes preloaded with the screw, wedge, and cartridge, skip steps 1 and 2. To order a cartridge, use the following numbers:
#6210836 for finishing cartridge SD12.
#6210837 for semi-finishing cartridge HD07.
Number of cartridges will vary based on the diameter of the cutter.

KCFM Do's and Don'ts

1 $Ap1 \leq 1\text{mm}$ (0.039")

NOTE: $Ap1$ max (For wiper insert SDHN12)

$Ap1 > 1\text{mm}$ (0.039")

Do not exceed the depth of cut of 1mm (0.039") when the cutter is used with wiper insert.

2

Wedge/screw projecting out of the pocket would reduce the performance.