

CERATIZIT

HSC milling tools: Clamping the insert



1
At the end of tool life remove the used tool from the machine spindle.



2
Clean with compressed air, taking care to protect eyes and exposed skin.



3
With the tool mounted in the presetting equipment or the assembly station, undo each insert screw and remove each insert.



4
Clean the insert seat and check for damage.



5
When indexing an insert to use the second edge, clean all location and support faces of the insert.



6
HSC machining: when mounting a new insert, always replace the old clamping screw with a **NEW** one.




7
Place insert in cleaned pocket pressing it onto the location faces with two fingers.



8
Keep pressing the insert onto the location faces while tightening the screw.



9
Clamp the insert using a preset torque key - see **CERATIZIT** literature for torque values. When reaching the torque setting the key clicks (do not attempt to tighten more than recommended torque values).

	Max. torque moment	
	lbs/in	Nm
XDHT 19	53.1	6.0
XDHX 19	44.3	5.0
XDHT 11	15.9	1.8
XDKT 11	14.2	1.6