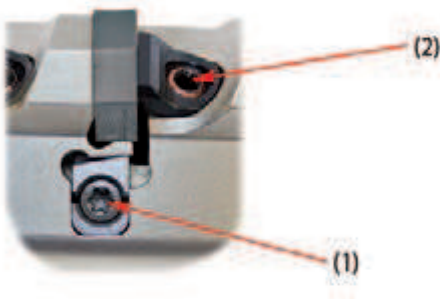


MaxiMill 273 system

Assembly procedures

Precision setting procedure



1. Mount the setting wedges in the cutter (as supplied) and tighten the setting screw (1), to lightly hold the wedge without deforming it.
 2. Mount inserts and tighten clamping screws (2) with 1.0 Nm.
 3. Mark 'highest cutting edge' using a presetting device.
 4. Change position of PCD insert by 0.02 mm turning the setting screw (1) clockwise.
For this purpose use the TORX key (8095018900 / WS-L-T15-136mm).
 5. Set the other cutting edges to this level, maximum deviation of 0.005 mm.
- Maximum adjustment = 0.10 mm.
6. Tighten all clamping screws (2) with 4.0 Nm (273-06).
 7. Check axial run-out of all inserts
→ target < 0.005 mm.



When changing the insert, first remove the setting screw (1), turning it counter-clockwise. After the mounting procedure is completed, the setting procedure starts again at point 1.