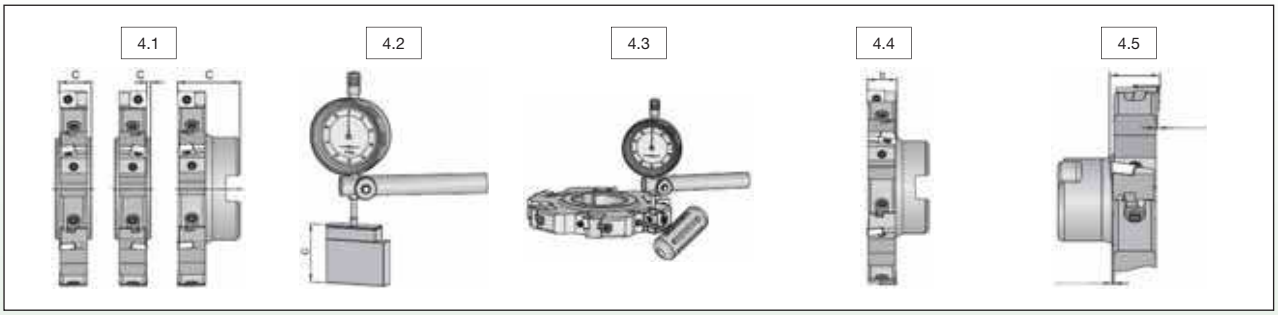
4. Setting the Runout for Milling Cutters with 2–3 Cutting Edges



4.1 Possible interpretations of the measuring dimension C.

4.2 Set gage to desired measurement C using gage blocks set to 0.

4.3 Set cartridge to ~0,1mm before final measurement. Clamping wedge is tightened with torque MApre = 1 Nm. Then briefly loosen clamping wedge and tighten again.

4.4 Set cartridge to 0,02mm before final measurement. Then briefly loosen clamping wedge so that the contact surfaces can level out. Tighten clamping.

4.4 Wedge again with torque MApre = 1 Nm.

4.5 Adjust cartridge to final measurement. Tighten clamping wedge with torque MA = 4 Nm. Check runout of the fully adjusted milling cutter.

5. Setting the Runout for Milling Cutters with 3 Cutting Edges

The cutting widths for milling cutters with three cutting edges are set using purpose-designed optical tool presetting equipment. Note that the projection of the cartridges from the mill body must be almost exactly the same on both sides. The sequence of steps required for setting the cartridge is identical to those for tools with two cutting edges.

ATTENTION:

At each tool adjustment, the body, cartridges, indexable inserts, and spare parts must be checked and replaced if necessary. Before each tool use, the clamping and double threaded screws must be tightened with the specified torque. The tools must only be used in accordance with their function. We accept no liability for their improper use. Changes of any kind and/or printing errors are not valid grounds for claims.