

Handling notes for HPR400

The HPR400 offers a system in which the tool can be re-tipped quickly and cost-effectively directly by the customer. The replaceable inserts are pushed axially into the insert seat and robustly fixed in the tool body using a TORX® screw. The familiar machining quality to the μ is always provided.

Changing the inserts

Note:

On changing the inserts, all inserts must be changed!

Note:

Only for trained personnel.



1. Clean the HPR400 using compressed air and cloth. Undo the TORX® screw, for this purpose turn the TORX® screw counter-clockwise using a suitable TORX® screwdriver. After undoing, remove the TORX® screw.



2. Carefully push the insert out of the insert seat in the axial direction and remove. Remove the remaining inserts, for this purpose repeat steps 1 and 2.

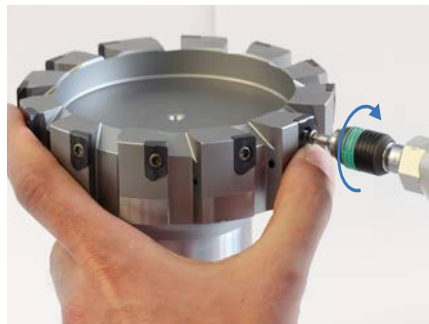


3. **Note:** Clean the contact faces for the inserts if they are soiled.

Clean insert seats using compressed air. Then clean the insert seats properly using alcohol.



4. Fit the new insert half-way into the insert seat. Then press the insert gently into the insert seat using your thumb and at the same time push the insert axially downward to the final position. To prevent the insert falling out, fix the insert using the TORX® screw.



5. **Note:** Only tighten the TORX® screws using a suitable torque wrench.

Tighten the TORX® screw to a tightening torque of 2.8 Nm.

Result:

The inserts have been completely changed and the HPR400 is ready for use.