

Handling notes for replaceable milling heads CPMill

The universal replaceable milling heads in the CPMill series feature a long tool life with constantly high machining quality. The CFS connection ensures the straightforward, fast changing of the milling heads with high accuracy of repetition. At the same time perfect retention with maximum stability and rigidity is achieved.

The replaceable milling head is tightened to the stipulated tightening torque and produces a joint with force and form fit. The key features of this system are high radial run-out accuracy in conjunction with very good rigidity.

Assembly of the replaceable milling heads CPMill

Note:

To minimise the risk of injuries, it is recommended to wear gloves.

Note:

Only for trained personnel.



1. Clean the taper, thread and face surface on the replaceable milling head using compressed air and a cloth.



2. Clean the taper, thread and face surface on the replaceable head holder using compressed air and a cloth.



3. Screw the replaceable milling head clockwise into the replaceable head holder so it is hand-tight. Then clamp the replaceable head holder with the tool in the machine holder.



4. Place the torque wrench on the replaceable milling head so it is as horizontal as possible; do not tilt the faces of the spanner.



5. **Note:** Place your free hand on the replaceable milling head to be able to adjust it sensitively. In this way the tightening torque can be set more accurately.

Tighten the replaceable milling head to the stated tightening torque with the aid of the torque wrench and the appropriate open-ended spanner attachment (see table "Tightening torques for the replaceable milling heads").



Result: The gap between the replaceable milling head and replaceable head holder is closed and a joint with a force and form fit is formed. The replaceable milling head CPMill is now ready for use.

Tightening torques for replaceable milling heads

| Connection size CFS | Tightening torque [Nm] |
|---------------------|------------------------|
| 6 | 5 |
| 8 | 12,5 |
| 10 | 15 |
| 12 | 20 |
| 16 | 25 |
| 20 | 30 |