Setting instructions for HX single-bladed reamers
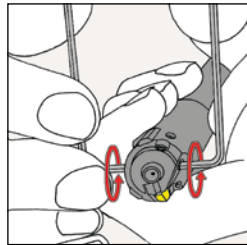

HX indexable insert — Threaded spindle
Clamping plate — Adjusting wedge
Threaded pin
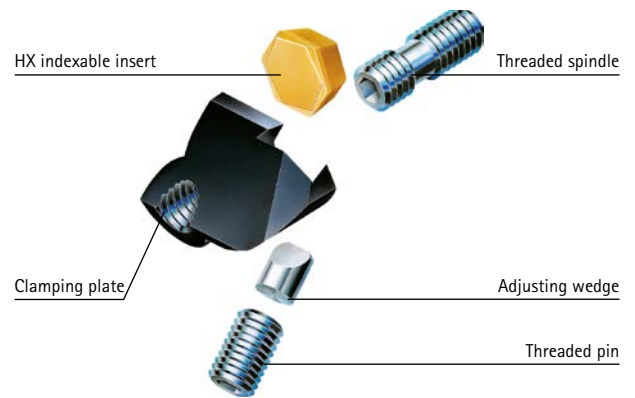
Accessories

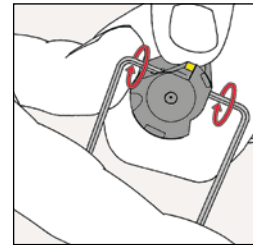| Indexable insert	Threaded spindle MN 618	Clamping plate	Threaded pin MN 620	Adjusting wedge MN 619
1 piece	1 piece	1 piece	1 piece	1 piece

Indexable insert change and setting
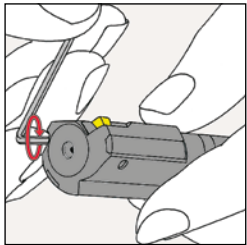
1. Turn the front and rear threaded pin half a turn counter-clockwise.


2. **Note**: Two wrenches must be used for undoing. To release the clamping plate turn the TORX® screw or the threaded spindle counter-clockwise from above and clockwise from underneath.
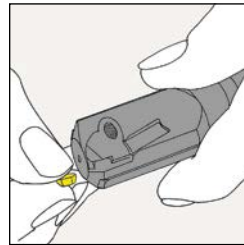

3. Remove the indexable insert. Clean the insert and the indexable insert seat (do not use compressed air, pay attention to adjusting wedge). Rotate the indexable insert by 60° or fit a new indexable insert.

4. **Note**: Two wrenches must be used for tightening. Press the indexable insert firmly into the indexable insert seat. To tighten the clamping plate turn the TORX® screw or the threaded spindle clockwise from above and counter-clockwise from underneath and tighten.
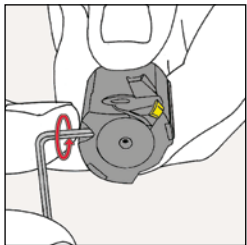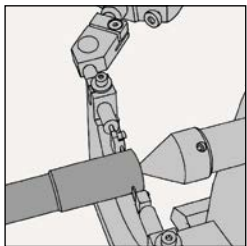

5. For coarse setting, turn again the threaded pin one quarter of a turn clockwise.
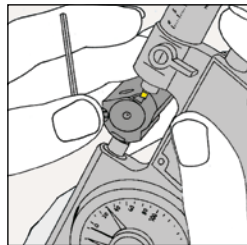
6. **Note:** We recommend using a precision pointer micrometer for measuring and fine setting. Set the required setting dimension by turning the threaded pin clockwise.
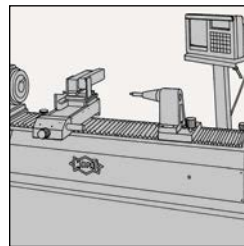
For straightforward handling and guaranteed reliable setting we recommend the usage of a MAPAL setting fixture.

7. Calibrate the MAPAL MASTERSET using a setting gauge (must be ordered separately). The setting gauge is the smallest dimension of the bore.
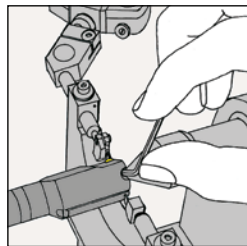
8. Set the required setting dimension by turning the threaded pin clockwise.

9. MAPAL UNISET: For conveniently setting the reamers, MAPAL offers electronic setting fixtures of vertical and horizontal design. You will find more information in the catalogue "SETTING | MEASURING | DISPENSING".

You will find detailed setting instructions in the operating manual for the fixture.

Note:
For setting using the radial distance method, see setting instructions for WP twin-bladed reamers on page 424.