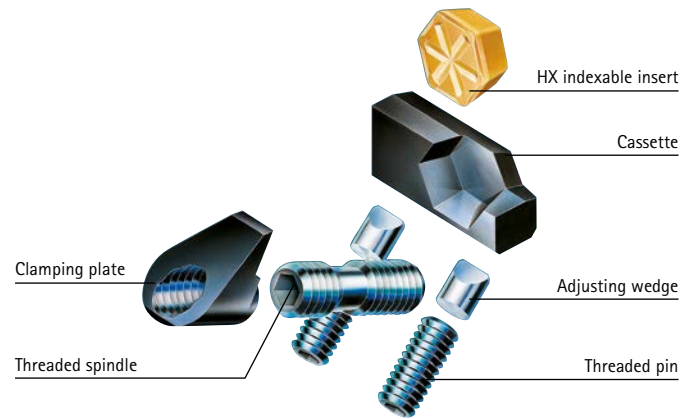


Setting instructions for HX single-bladed reamers

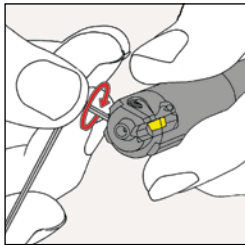
Size 2 and size 3



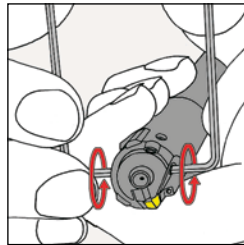
Accessories

Indexable insert	Cassette	Threaded spindle MN 618	Clamping plate	Threaded pin MN 620	Adjusting wedge MN 619
1 piece	1 piece	1 piece	1 piece	2 pieces	2 pieces

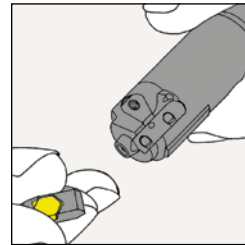
Indexable insert change and setting



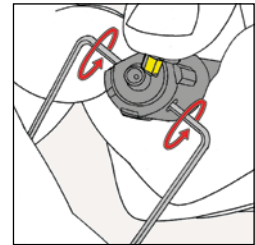
1. Turn the front and rear threaded pin half a turn counter-clockwise.



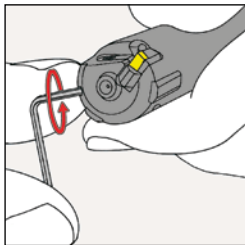
2. **Note:** Two wrenches must be used for undoing. To release the clamping plate and the cassette turn the TORX® screw counter-clockwise from above and clockwise from underneath.



3. Remove the indexable insert and the cassette. Clean the indexable insert, the cassette 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 in the cassette. Re-fit the cassette.

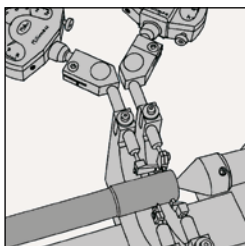


4. **Note:** Two wrenches must be used for tightening. Press the indexable insert and the cassette against the rear stop and the adjusting wedge. Tighten the TORX® screw clockwise from above and counter-clockwise from underneath and tighten.

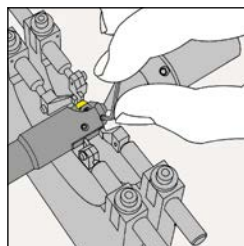


5. For coarse setting, turn the front and rear threaded pin one quarter of a turn clockwise.

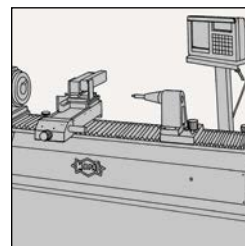
For straightforward handling and guaranteed reliable setting we recommend the usage of a MAPAL setting fixture.



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 front and rear setting dimension alternately using the threaded pins. The back taper is approx. 0.005 to 0.010 mm.



9. MAPAL UNISSET: 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.