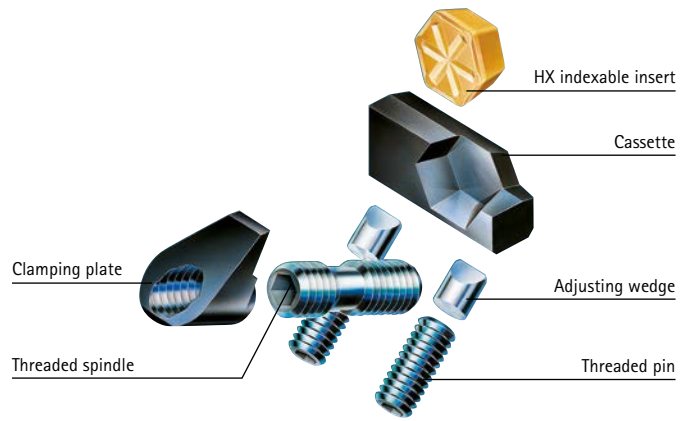


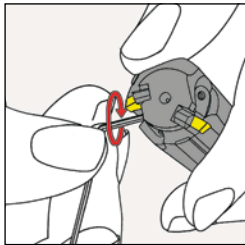
Setting instructions for HX twin-bladed reamers



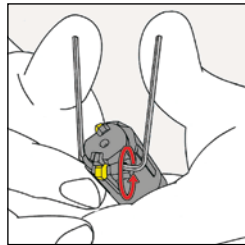
Accessories

Indexable insert	Cassette	Torx screw/ threaded spindle MN 618	Clamping plate	Threaded pin MN 620	Adjusting wedge MN 619
2 pieces	2 pieces	2 pieces	2 pieces	4 pieces	4 pieces

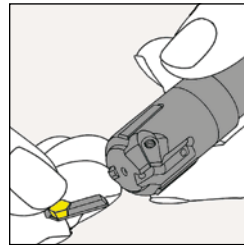
Indexable insert change and setting



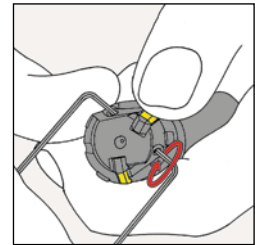
1. Turn the front and rear threaded pin half a turn counter-clockwise.



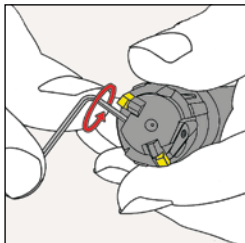
2. **Note:** Two wrenches must be used for undoing. To release the clamping plate and the cassette turn the TORX® screw or the threaded spindle counter-clockwise from above and clockwise from underneath.



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 or the threaded spindle clockwise from above and counter-clockwise from underneath and tighten.

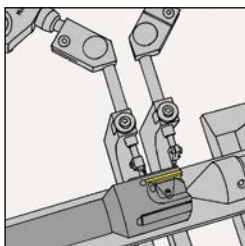


5. For coarse setting, turn the front and rear threaded pin one quarter of a turn clockwise.

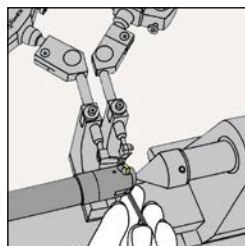
Note:
The procedure (Figure 1 to 5) also applies to the second insert.

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

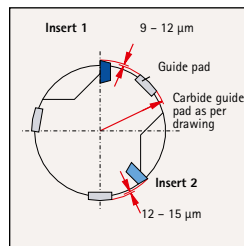
For straightforward handling and guaranteed reliable setting we recommend the usage of a MAPAL setting fixture.



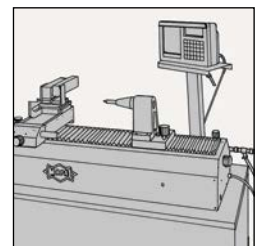
7. The MAPAL MASTERSSET: Set the distance between the measuring probes to the indexable insert length. Zero the dial gauges on the guide pad after the indexable insert.



8. **Set insert 1:** Set front and rear setting dimension alternately using the threaded pins. Setting dimension = radial distance of the indexable insert above the following guide pad as per setting instructions Figure 8b. Back taper is approx. 0.005 to 0.010 mm.
Set insert 2: Set front and rear setting dimension alternately using the threaded pins. Setting dimension = radial distance of the indexable insert below the following guide pad as per setting instructions Figure 8b. Back taper is approx. 0.005 to 0.010 mm.



8b



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".