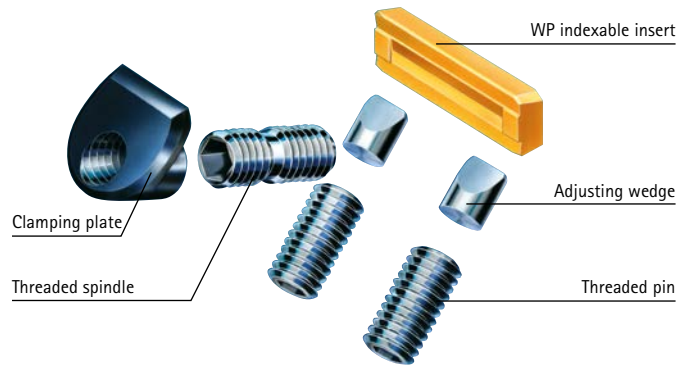


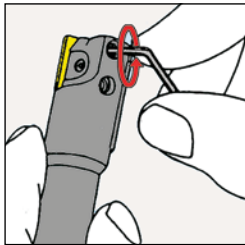
Setting instructions for WP single-bladed reamers



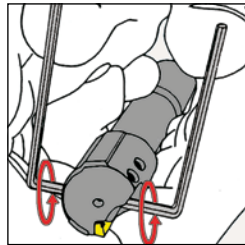
Accessories

Indexable insert	Torx screw/ threaded spindle MN 618	Clamping plate	Threaded pin MN 620	Adjusting wedge MN 619
1 piece	1 piece	1 piece	2 pieces	2 pieces

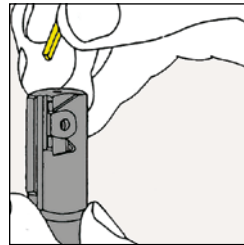
Indexable insert change and setting



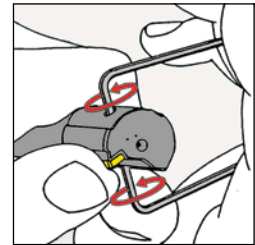
1. Turn the front and rear threaded pin half a turn counter-clockwise.



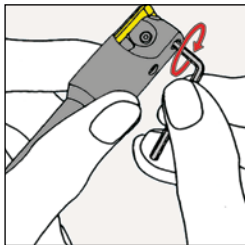
2. **Note:** Two wrenches must be used for undoing. To release the clamping plate turn the TORX® screw or the threaded spindle counter-clockwise from above and clockwise from underneath.



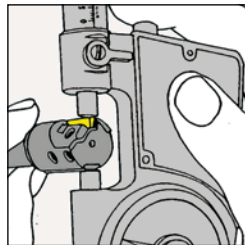
3. Remove the indexable insert. Clean the indexable insert and the indexable insert seat (do not use compressed air, pay attention to adjusting wedge). Rotate the indexable insert or fit a new indexable insert.



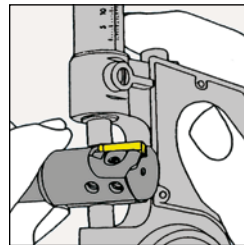
4. **Note:** Two wrenches must be used for tightening. Press the indexable insert against the rear stop and the adjusting wedge. To tighten the clamping plate turn the TORX® screw or the threaded spindle clockwise from above and counter-clockwise from underneath and tighten.



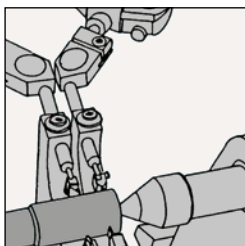
5. For coarse setting, turn the front and rear threaded pin one quarter of a turn clockwise.



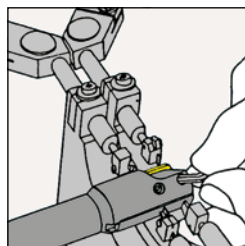
6. **Note:** We recommend using a precision pointer micrometer for measuring and fine setting. Set the front and rear setting dimension alternately using the threaded pins. The back taper is approx. 0.01 to 0.015 mm.



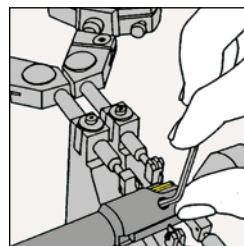
For straightforward handling and guaranteed reliable setting we recommend the usage of a MAPAL setting fixture.



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. 0.01 to 0.015 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.