

Abb. 4: Plattensitz reinigen

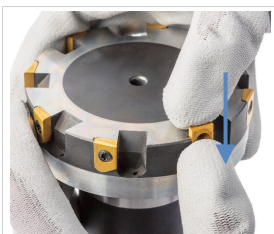


Abb. 5: Neue Schneidplatte einsetzen



Abb. 6: Spannschraube anziehen

6. Reinigen Sie den Plattensitz mit Druckluft.
7. Reinigen Sie unter sachgemäßer Verwendung von Reinigungsalkohol den Plattensitz.

INFORMATION



Reinigen Sie die Anlageflächen der Schneidplatte bei Verschmutzung.

8. Legen Sie die neue Schneidplatte bis zur Hälfte in den Plattensitz.
9. Drücken Sie die Schneidplatte mit dem Daumen leicht in den Plattensitz und schieben Sie die Schneidplatte gleichzeitig axial nach unten in die Endposition.
10. Fixieren Sie die Schneidplatte mit der Spannschraube, um das Herausfallen der Schneidplatte zu verhindern.

INFORMATION



Die Spannschraube nur mit einem passenden TORX®-Drehmoment-schlüssel anziehen.

11. Ziehen Sie die Spannschraube mit einem Anzugsdrehmoment von **3,1 Nm** an.
12. Wiederholen Sie den Schneidplattenwechsel für die restlichen Schneidplatten.

ERGEBNIS



Die Schneidplatten sind vollständig gewechselt.

6 Pflege und Wartung

- Schützen Sie die Hochleistungsreibahle HPR400 bei der Lagerung vor Korrosion.
- Reparaturen dürfen ausschließlich im Hause MAPAL durchgeführt werden.

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7 Entsorgung

Nachdem das Gebrauchsende der Hochleistungsreibahle HPR400 erreicht ist, muss sie einer umweltgerechten Entsorgung zugeführt werden. Die Hochleistungsreibahle HPR400 kann zur fachgerechten Entsorgung auch an MAPAL gesendet werden.

Table of contents

1	Purpose of the Installation and Operating Instructions.....	12
2	Contact.....	12
3	Safety.....	13
3.1	Target group.....	13
3.2	Correct use.....	13
3.3	Incorrect use.....	13
3.4	Warranty.....	14
3.5	General warnings and safety instructions.....	14
4	General information.....	15
4.1	Illustration of a HPR400.....	15
4.2	Tools and materials required.....	16
5	Changing the indexable inserts.....	16
6	Care and maintenance.....	18
7	Disposal.....	18

1 Purpose of the Installation and Operating Instructions

These installation and operating instructions describe the proper operation of the high-performance reamer HPR400. You will find detailed information on how to change and mount the inserts. In addition, the most important safety instructions on handling the high-performance reamer HPR400 explained (also referred to as the "tool" below).

In *section 5* in the following you will find a detailed description of the individual functions and steps necessary to successfully change the inserts.

The installation and operating instructions form an integral part of the high-performance reamer and must be kept in the immediate vicinity and be accessible to personnel at all times. A basic precondition for safe working is compliance with all the safety precautions and instructions for working given in these installation and operating instructions.

The local safety at work regulations and the general safety regulations for the field of application of the tool must also be observed. Illustrations in these installation and operating instructions are provided for general understanding and may differ from the actual design.

2 Contact

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3 Safety

3.1 Target group

The tool may only be used by trained, authorised and dependable specialist personnel. The specialist personnel must be able to recognise and avoid hazards and must therefore have read this document before using the high-performance reamer HPR400.

The specialist personnel are familiar with the accident prevention regulations, safety stipulations and instructions from the machine manufacturer which must be followed and observed during operation of the tool.

3.2 Correct use

- The high-performance reamer HPR400 and its components are intended only for cutting operations during manufacturing on machine tools in industrial applications.
- The high-performance reamer HPR400 and its components may only be used when observance of all the instructions given in these operating instructions is assured.
- If there is a maximum operating speed indicated on the tool, it must not be exceeded.
- Failure to observe these instruction can result in injuries or damage to machines and accessories for which MAPAL assumes no liability.

3.3 Incorrect use

- The tool or the tool assembly and additional components may only be used in accordance with the official specifications, and the maximum operating speed must not be exceeded.
- The high-performance reamer HPR400 and associated components must not be modified or used for any other applications.
- Unauthorised modifications to the high-performance reamer HPR400 and its components or use for other than the intended purpose will void all warranty claims against MAPAL.
- The manufacturer assumes no liability for accidents or damage resulting from use for other than the correct use.

3.4 Warranty

The warranty period is **24 months** from the date of delivery ex works on condition of use for the correct use and observance of the contents of the installation and operating instructions.

The tool, including all associated components, must not be modified or used for non-authorized applications. Any modification to the tool or any unauthorised use will void all warranty claims against MAPAL.

MAPAL expressly declines any liability for accidents or damage resulting from the use of damaged tools or damaged machine parts. Wear parts are not covered by the warranty.

3.5 General warnings and safety instructions



WARNING

Danger from use by untrained and unauthorised personnel

The clamping of tools and their installation on a machine tool by untrained and unauthorised personnel can lead to hazardous situations.

- Only trained, authorised and dependable specialist personnel may clamp tools and install them on a machine tool.
- The technical data on the machine connection must be observed by the specialist personnel.
- The specialist personnel must be able to recognise and avoid hazards.



CAUTION



Sharp cutting edges on the tool!

Sharp cutting edges may cause cutting injuries.

- Wear protective gloves when changing inserts.

NOTE

Damage to the tool inserts!

If the tool is set down with the connection facing up, the tool inserts may be damaged.

- Do not set the tool down on the tool inserts.


NOTICE

Wear due to use of a power screwdriver for tightening the clamping screw!

Use of a power screwdriver for tightening the clamping screw will result in increased wear of the clamping set.

→ Tighten the clamping screw only manually.

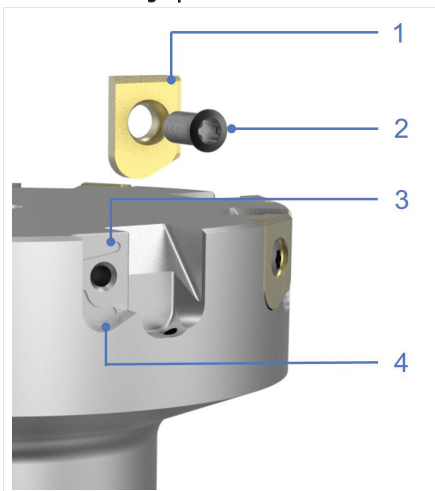
INFORMATION

 Only trained personnel are permitted to change the inserts!

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4 General information

4.1 Illustration of a high-performance reamer HPR400



Legend

- 1 | Insert
- 2 | Clamping screw (TORX®)
- 3 | Wiper pocket
- 4 | Insert pocket

Fig. 1: Individual components

4.2 Tools and materials required

- TORX®-screw driver IP15
- TORX® torque wrench IP15
- Protective gloves
- Compressed air blow gun

5 Changing the indexable inserts

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CAUTION



Sharp cutting edges on the tool!

Sharp cutting edges may cause cutting injuries.

→ Wear protective gloves when changing inserts.



Fig. 2: Releasing the clamping screw

1. Clean the tool before beginning to change the inserts.
2. Release the clamping screw with the suitable TORX®-screw driver, to do this rotate the screw anti-clockwise.
3. Remove the clamping screw.

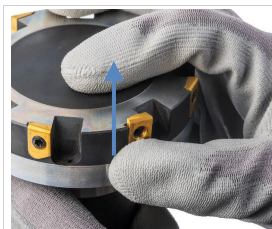


Fig. 3: Removing the insert

4. Carefully slide the insert up the insert pocket and remove the insert.

INFORMATION



When exchanging an insert all inserts must be exchanged!

5. Remove the remaining inserts.

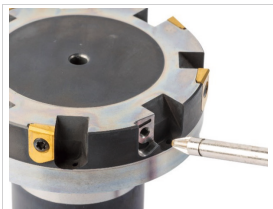


Fig. 4: Cleaning the insert pocket

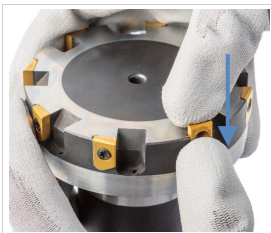



Fig. 5: Fitting a new insert



Fig. 6: Tightening the clamping screw

6. Clean the insert pocket using compressed air.
7. Clean the insert pocket with proper use of cleaning spirit.


INFORMATION

-  Clean the contact areas of the insert if they are soiled.

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8. Place the new insert half the way into the insert pocket.
9. Press the insert gently into the insert pocket, at the same time slide the insert axially down into the end position.
10. Secure the insert with the clamping screw.

INFORMATION

-  Tighten the clamping screw only with a suitable TORX® torque wrench.

11. Tighten the clamping screw with a tightening torque of **3,1 Nm**.
12. Repeat the insert change for the remaining inserts.

RESULT

-  The inserts have been replaced and the tool is ready for service.

6 Care and maintenance

- Protect the high-performance reamer HPR400 against corrosion when stored.
- Repairs must only be performed at MAPAL.

7 Disposal

Once the high-performance reamer HPR400 reaches the end of its service life, it must be disposed of with due care for the protection of the environment. The high-performance reamer HPR400 can also be sent to MAPAL for proper disposal.



KAL-HPR400-D/E-0522

Bestellnummer / Order number:
10143283

Montage- und Betriebsanleitung | Hochleistungsreibahle HPR400
Installation and Operating Instructions | High-Performance Reamer HPR400
MAPAL Dr. Kress KG, Aalen

Gültig für: / Applies for:

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Technische Änderungen vorbehalten. /

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