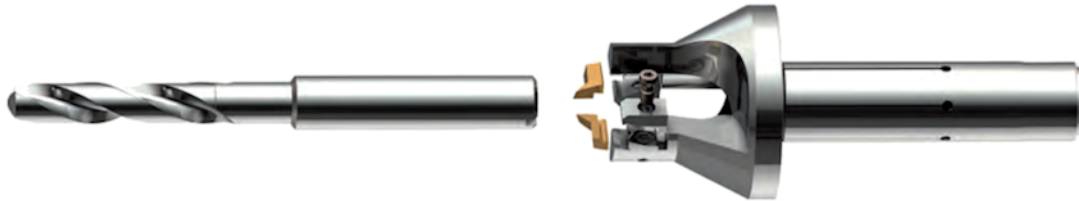




Drill / Chamfering Tools

Assembly instructions



Changing the insert

Disassembly

- Loosen clamp set (1 to 2 turns) and remove the worn insert
- Clean pocket seat

Assembly

- Put new insert into pocket seat
- Press insert into the pocket seat while slightly tightening the clamp set
- Push insert against the drill, therefore place 0.03 mm feeler gauge between insert and drill
- Hold insert in position and tight down clamp set with recommended torque

| Clamp set | Clamping set for | Tx | Torque (Ncm) |
|-----------|------------------|----|--------------|
| E4890 | H 2006-... .. | 6 | 70 |
| E4991 | H 3006-... .. | 8 | 140 |

Torque wrenches

| Drawing number | Version | Tx | Ncm |
|----------------|------------|----|---------|
| E5000 | adjustable | 6 | 20-120 |
| E5001 | adjustable | 8 | 100-600 |
| E5400-6 | fixed | 6 | 70 |
| E5400-8 | fixed | 8 | 140 |

We reserve the right to make technical changes.