



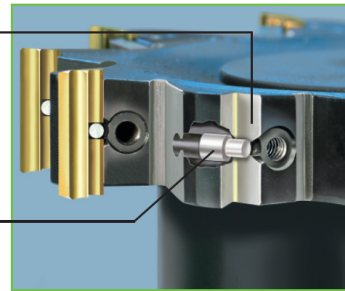
Adjustment instructions

for Hollfelder-Gühring milling cutters with eccentric adjustment

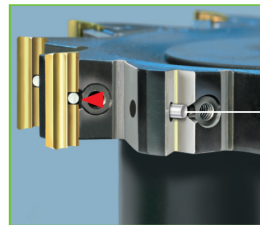
1. Insert replacement

- **Loosen the clamping set and remove the insert.**
- **Thoroughly clean the insert seat.**
The bore for the eccentric pin must have assembly paste (E 5162) applied evenly following cleaning
- **Position the new insert in the insert seat.**
The groove in the insert body must “engage” in the eccentric pin
- Lightly tighten the **clamping set** with a Torx screwdriver.
- **All inserts** must initially be brought to the largest possible dimension. Then tighten to the required torque.

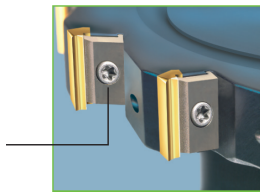
Highly exact insert pocket to attach the insert



Eccentric bolt for μm -accurate adjustment of the insert



Please see that the slot in the insert „hooks into“ the eccentric bolt in the insert pocket.



Tool type	Torque (Ncm)	Torx size	Torque wrench fixed DSF	
			Part nr.	Code
H 2080	45	Tx 5	20063	0.450
H 3108 / H 3120 / H 2006	70	Tx 6	20063	0.700
H 6120 / H 6121 / H 3006	140	Tx 8	20063	1.400
H 4006	345	Tx 15	20063	3.450
Torque wrench adjustable DS	20 - 120		20063	1.200
	100 - 600		20063	6.000

We reserve the right to make technical changes.

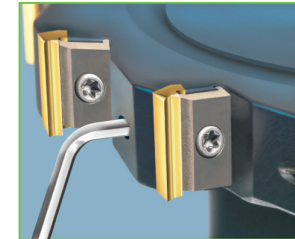


Adjustment instructions

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2. Adjusting the inserts

- **Adjust the inserts either towards each other and / or to a precise dimension using the adjustment key (hexagon key). The adjustment system allows an infinite adjustment. It is recommended to adjust the inserts “TO TENSION”.** This means that all inserts must be brought from this point adjusted to each other and / or to the desired dimension
- **Always make the adjustment only in one direction!** If the required dimension is exceeded or falls short, the eccentric pin must be rotated by one full turn again.
- **A re-tightening of the clamping set is not necessary!** The tool is now ready for application



Adjustment key
(hex key) to work
the eccentric bolt

Attention:

Different coating processes can change the friction coefficient between insert and insert seat. Should this be the case the clamping set should be tightened to a reduced value (approx. 80%), in order to enable the adjustment of the insert. Then the clamping set can be tightened to the recommended torque.

Safety note:

In the event of damage the tool must be returned to the manufacturer to be checked for technical safety reasons! The clamping sets must be checked for damage at regular intervals or replaced in the event of wear. Only original replacement parts must be used!

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