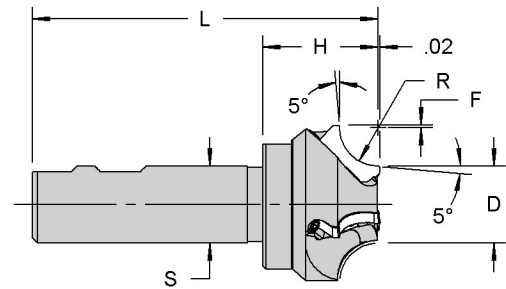


CVL Large Radius

- Designed for fast and smooth corner rounding
- Three flutes
- High positive rake
- Free cutting action for excellent surface finish
- 5° flares tangent to radius to avoid steps in workpiece
- End cutting
- Precision ground inserts
- Cutter bodies and inserts made in the USA



RADIUS R	PART NUMBER	DIMENSIONS (INCH)						INSERT*	STANDARD COMPONENTS		
		D	OD	S	L	H	F		WEDGE	LOCATOR	SCREW
0.188	CVL-030	0.750	1.15	1.00	4.25	1.25	0.03	CVL12188	6W100	-	6DS343
0.250	CVL-040	0.750	1.30	1.00	4.25	1.25	0.03	CVL12250	6W100	-	6DS343
0.313	CVL-050	0.750	1.43	1.00	4.25	1.25	0.03	CVL12313	6W200	-	6DS343
0.375	CVL-060	0.750	1.56	1.00	4.25	1.25	0.03	CVL12375	6W200	6W101C	6DS343
0.438	CVL-070	1.000	1.94	1.00	4.38	1.38	0.03	CVL16438	6W100	6W101C	6DS343
0.500	CVL-080	1.000	2.06	1.00	4.50	1.50	0.03	CVL16500	6W100	6W101C	6DS343
0.563	CVL-090	1.000	2.19	1.00	4.63	1.63	0.04	CVL16563	6W200	6W101C	6DS343
0.625	CVL-100	1.000	2.32	1.25	5.00	1.63	0.04	CVL16625	6W200	6W101C	6DS343
0.750	CVL-120	1.250	2.85	1.25	4.75	1.75	0.04	CVL18750	6W100	6W101C	6DS343

* Available in C2 uncoated and C2 TiAlN coated grades

SPECIALS

- Full radius forms
- Shell mill mounts
- Back corner rounders
- Extended lengths
- Metric sizes
- Non-standard radii



ASSEMBLY INSTRUCTIONS

- ① Insert
- ② Differential screw 6DS343
- ③ Locating wedge 6W101C
- ④ Clamping wedge 6W100/6W200



1. Clean all insert pockets and replace wedges and screws as necessary.
2. Loosen all wedges to provide clearance for installing the insert.
3. Orient the locating wedge (if equipped) as shown.
4. While pressing the insert down into the pocket, rotate the screw(s) until the clamping wedge applies light pressure to the insert.
5. Make sure that the insert is seated flat in the pocket and against the side seat at the nose of the tool.
6. Tighten the locating wedge with its flat against the side of the insert. Firmly tighten the clamping wedge(s).

