

Assembly Instructions

For DSSC, DASC, W & TSC Staggered Tooth Slotters

The simple wedge-lock design makes replacing worn or damaged inserts easy. Care must be taken, however, to make sure that the insert pocket is clean and the insert is properly seated. After a used insert has been removed, clean the pocket and visually inspect for burrs or damage sustained during use. Cutters with insert pockets that do not allow proper seating must be repaired or replaced.

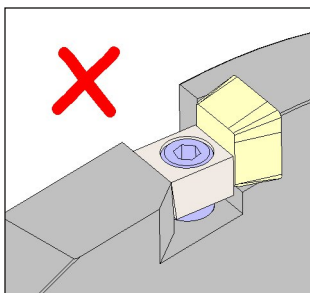
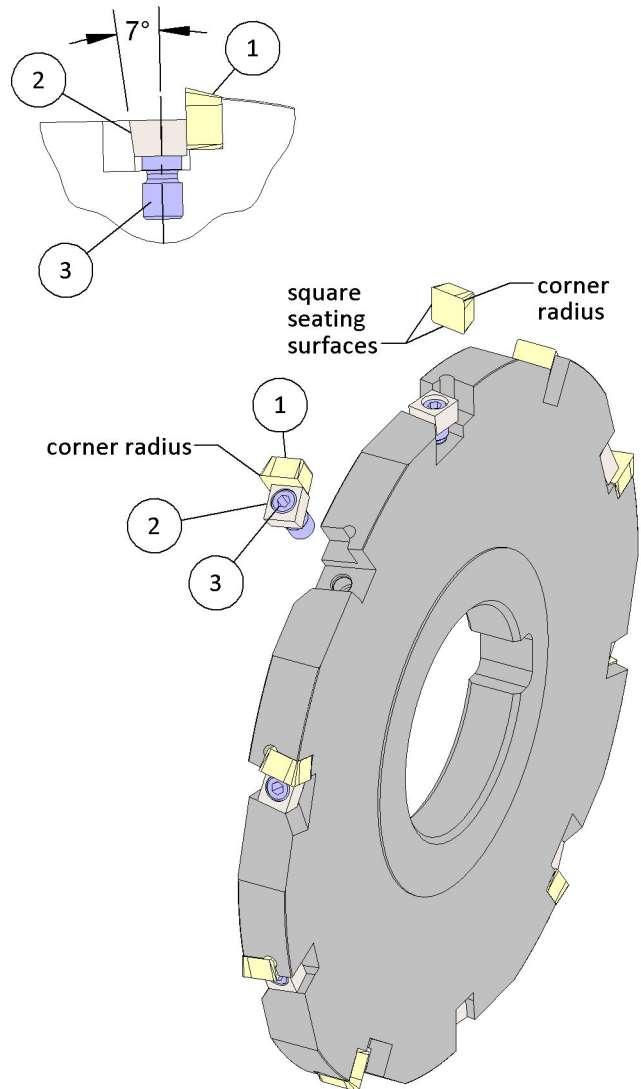
- ① Insert from series 1215, 1312, 1500, or 1750
- ② Differential screw
- ③ Clamping wedge

Mounting instructions

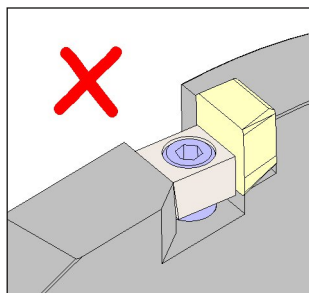
1. Find the corner radius on the insert and orient as shown. Slide the insert into a clean pocket. The wedge must be loose for the insert to fit in the pocket. If necessary, release the wedge using the differential screw until the insert can slide in.
2. Clamp the wedge lightly on the insert with the differential screw. While applying pressure on the insert toward the inside corner of the pocket, firmly tighten the screw.
3. Check proper orientation of wedge and insert. If the wedge sits too high it can impede chip flow. Check orientation and reinstall. If it sits too low it can fail to secure the insert and must be replaced. Call tech support for assistance.

Please note:

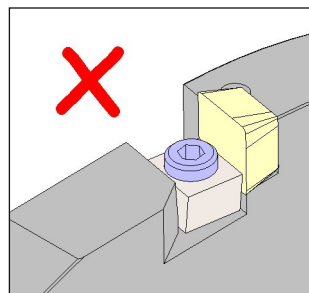
Interchanging inserts between opposite hand stations (before excessive wear occurs) can often improve insert life.



Insert is backwards with clearance in wrong direction



Insert is upside down



Insert is correct but wedge is askew

