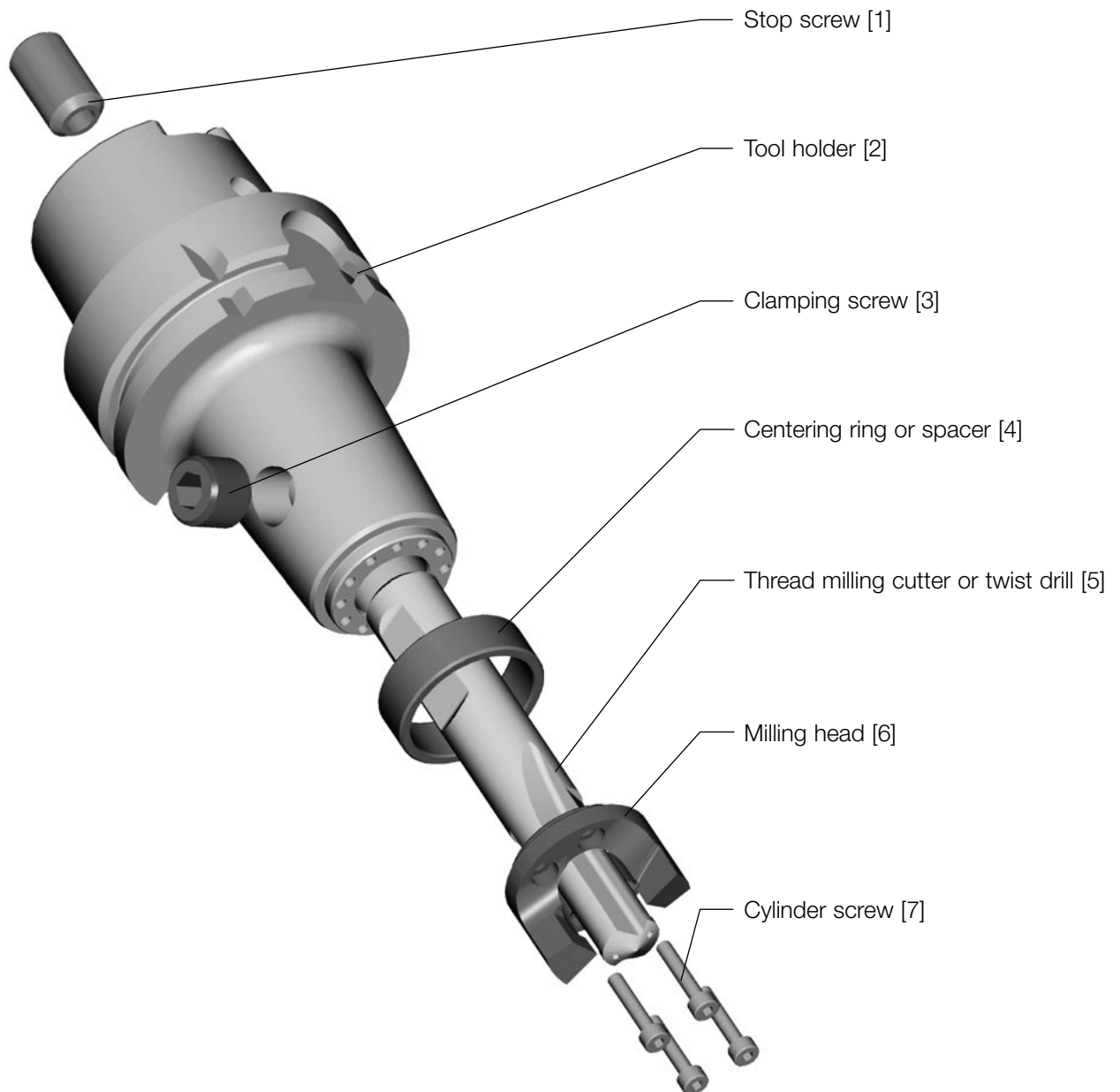


**Assembly and Operating Manual for
counterbore and stepped bore systems for free combination
“MoSys”**



Please keep for future use!

1 Assembly

1. Insert the thread milling cutter [5] into the tool holder [2] and fix it with the clamping screw [3] (Position the clamping flat correctly by turning the thread milling cutter [5]).
2. Fix the centering ring [4] on the collar of the tool holder [2].
3. Guide the milling head [6] over the thread milling cutter [5].



Please note:

Guide the cutting edges of the milling head carefully along the chip flute!

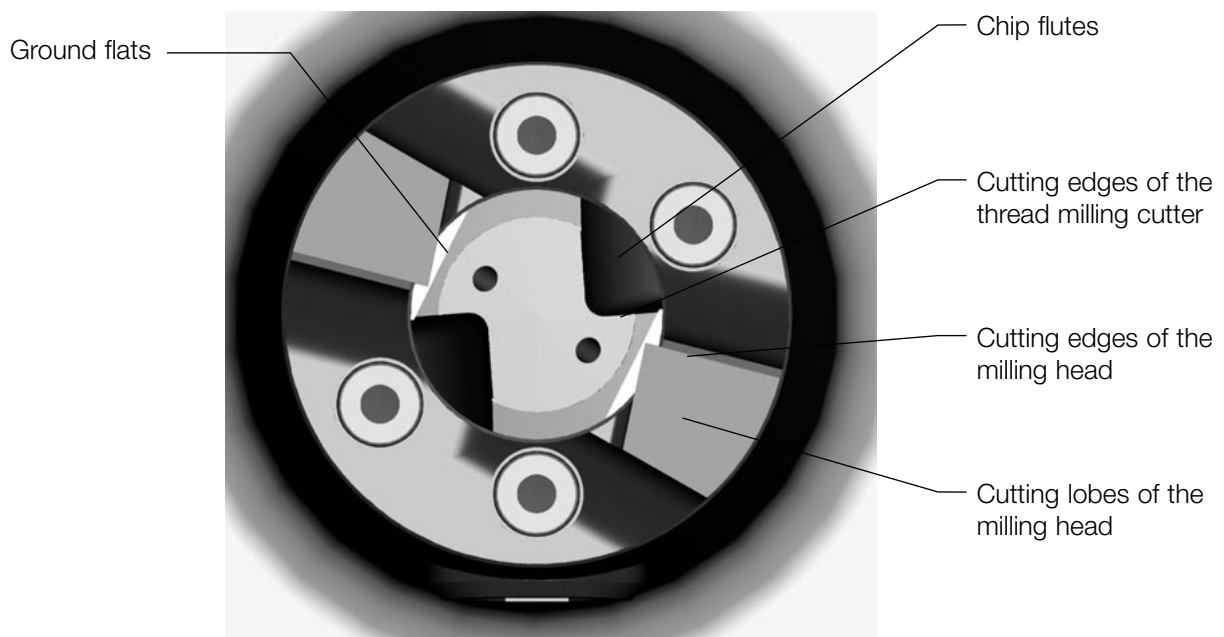
4. Turn the milling head [6] inside the centering ring [4] until you have found the best position in relation to the ground flats and/or the chip flutes.



Note:

Especially with **thrillers and drilling tools**, make sure that the cutting lobes of the milling head do not block the chip flow.

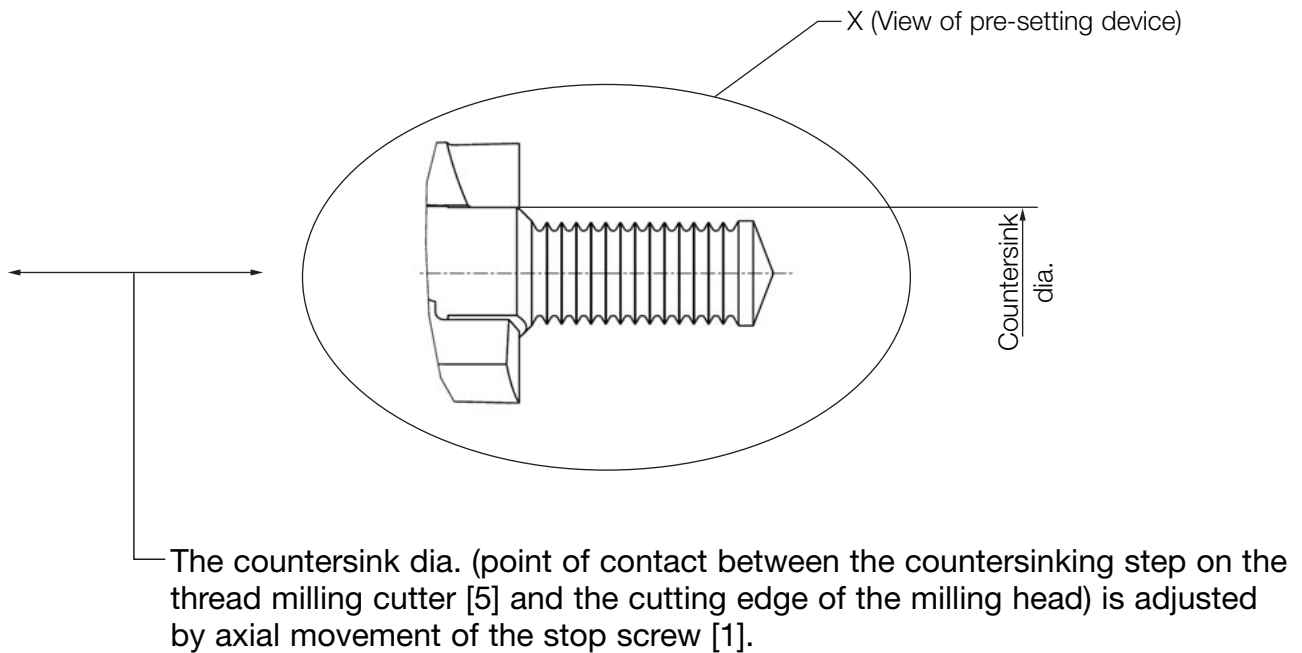
5. Fix the milling head [6] with the cylinder screws [7].



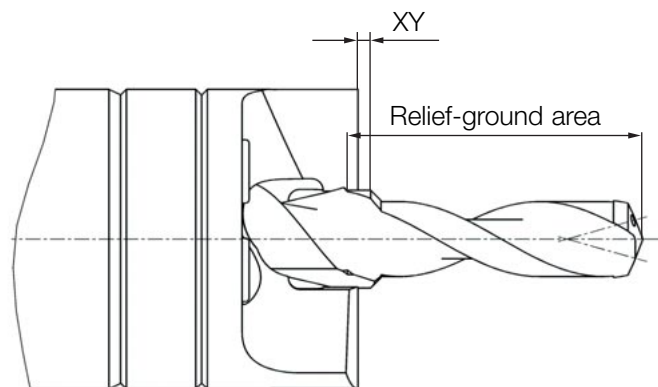
Note:

With special constructions where the shank is smaller than the cutting or drilling part, it may be necessary to attach the milling head before the tool shank is inserted into the tool holder.

2 Length adjustment of the countersinking contour



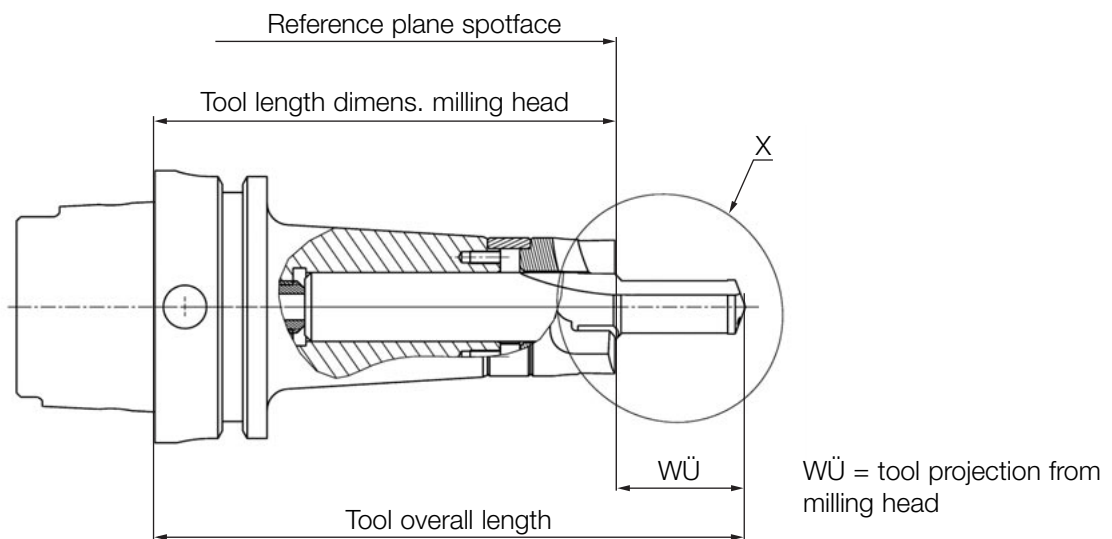
Special constructions, e.g. with cylindrical countersinking step (cf. dim. size XY) must be adjusted in accordance with the workpiece or tool drawing.



Note: Safety information!

After finishing the adjustment of the countersinking dia., check if all screws are properly tightened!

3 Reference dimensions (linear) for programming



Recommendations for programming:

- Positioning over the workpiece
2 mm safety distance + WÜ (tool projection from milling head)
- The drilling depth for reaching the spotface ends **absolutely** at “0” (= reference plane spotface) or **incremental** at “-” (WÜ + safety distance)



Note:

Depending on the application case, the reference of the tool length dimensions should be discussed with the operator/programmer!



Note:

You can download this operating manual as a PDF file from our server under www.emuge.de!