Handling notes for milling cutter clamping screw

Clamping tool

Note:
Only for trained personnel.

1. Remove the driving ring from the milling cutter arbor.

2. Fit the parallel key to the milling cutter arbor.

Note:
The spacer rings are not included (see section "Accessories and spare parts" on page 279).

3. Fit the first spacer ring to the milling cutter arbor.

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4. Fit the second spacer ring to the first spacer ring and the milling cutter arbor.

5. Fit the tool flat on the milling cutter arbor.

Mounting and setting milling cutter clamping screw

6. Turn threaded bolt until it protrudes 1-2 mm in relation to the threaded ring.

7. Lightly screw the milling cutter clamping screw clockwise into the milling cutter arbor.

8. Continue to screw the milling cutter clamping screw clockwise with the aid of a hex-wrench and then tighten using a torque wrench (for tightening torque see table "Tightening torque for milling cutter clamping screw").

Result:
The milling cutter clamping screw has been tightened to the stipulated tightening torque and is flat against the tool.

Tightening torque for milling cutter clamping screw

Clamping screw Order No.	For milling cutter arbor ø [mm]	Dimensions	Wrench size	Tightening torque [Nm]
10041356	16	M8	SW 5	28
10009642	22	M10	SW 6	50
10006125	27	M12	SW 8	70
10009686	32	M16	SW 10	95
10006126	40	M20	SW 12	125

APPLICATION AREA

- Disc milling cutters with milling cutter arbor
- Higher cutting force during machining
- High torques

ADVANTAGES

- Very high clamping force
- Greater safety through the different pitch on the two threads on the threaded bolt
- Self-locking
- No risk of injury due to slipping wrench
- Higher cost-effectiveness thanks to greater radial and axial run-out accuracy of the milling cutter