

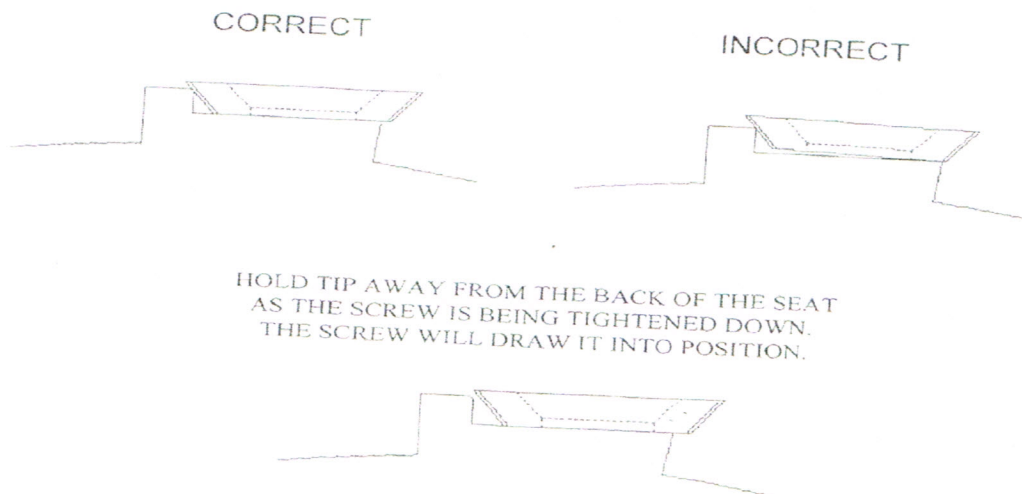
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## "SHELIX"

### REPLACING OR ROTATING INSERTS

When replacing or rotating inserts, the seat should be as clean as possible. Move the tip back and forth a few times on the seat to make sure there are no burs or dirt. This will prevent breakage of inserts and ensure proper insert alignment. Hold the tip away from the back of the seat (slightly pull toward yourself if facing the cutting edge) and let the screw pull the tip into position. When it's fully seated the front of the screw should pull down against the tips. A hard hand tightening is about 45 inch pounds

Don't try to place the tip directly over the screw hole, in doing so it can ride up on the back of the seat and cause it to not index properly; possibly cracking the insert. (a slight offset between the screw hole and the hole and the hole in the tip is normal) NOTE: if you've been having tips break, there could be some embedded pieces of carbide in the seat that could continue causing the replacement tips not to flat and also break. Bit is a TP25 torx plus...(some of the older heads use a TP20 torx plus)



We have two types of torque wrenches available:

Standard break over handle.....\$95.00  
Screwdriver type (torque limiter, calibrated and set) .....\$185.00