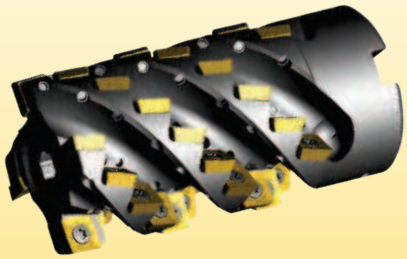
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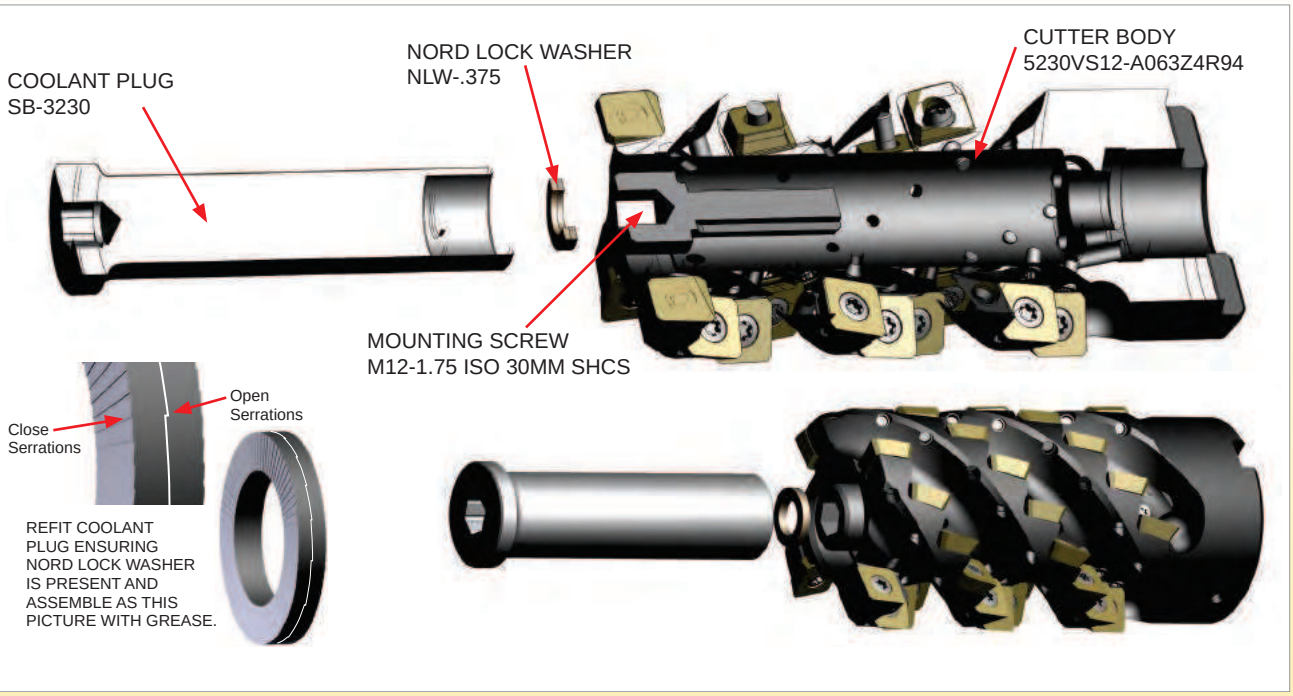
5230VS09 and VS12 Fitting Instructions for Shell Mill Cutters



NOTE: All Shell Mill 5230VS09 and VS12 Chevron Porcupine Cutters are supplied assembled with mounting bolt, nord lock washer and steel coolant plug.

Please follow the instructions below to disassemble the cutter, attach the cutter to a shell mill adapter and reassemble coolant plug. It is very important to use the proper torque when reassembling the cutter with the mounting bolt, nord lock washer and coolant plug.

Example of cutter: 5230VS12-A063Z4R94 assembly



1. Remove coolant plug. *(Note: Ensure the nord lock washer is retained to the bottom of the coolant plug.)*
2. Fit the cutter body to the shell mill adapter and secure using the mounting bolt supplied with the cutter.
   Note: The mounting bolt must be properly torqued to the specified torque setting shown in the above chart in (page A182) Detail 1.
3. Refit coolant plug ensuring nord lock washer is present and in the proper location on the bottom of the coolant plug.
   A small amount of grease can be used to hold the nord lock washer in place.
4. Tighten coolant plug with specified torque setting shown in the above chart in (page A182) Detail 2.
5. Note: If axial depth of cut (a_p) is less then maximum a_p of the cutter, then F3006T coolant control screws supplied separately can be used to block coolant holes forcing more coolant to the front of the cutter. If these screws are used, please secure with loctite or similar product.