

INSTRUCTION MANUAL

DATRON-MONOBLOCK

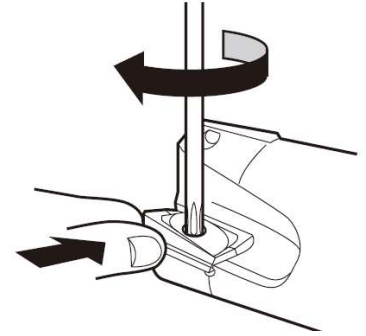
Read these operating instructions before use and keep them in a way, that the operator can access it when needed.

A DATRON machine is recommended for the use of the DATRON MONOBLOCK.

MOUNTING THE INSERTS

Before mounting the inserts:

- ➔ Free the insert seat from foreign particles with compressed air.
- ➔ Clean the lateral surfaces and the back of the insert seat carefully with a soft cloth.
- ➔ Tighten the screw while applying light pressure against the insert.
- ☞ There must be no clearance between the insert and the insert seat.



! WARNING

- Only use the accessory or original screws.
- There is a risk of cutting when changing the inserts.
- Replace the screws regularly as these are wearing parts.
- Do not use a screwdriver with a damaged tip or damaged clamping screws.

INFORMATION ON THE USE OF THE DATRON MONOBLOCK

- ☞ Refer to the table for recommended speeds.
- ➔ Never exceed the max. permissible speed.
- ➔ Start with lower cutting parameters and increase them step by step.
- ➔ Only use machine tools with guards.
- ➔ Wear safety goggles during work.

The milling tool can be used for plunging, as well as for trochoidal machining.

Observe the following recommendations during operation:

- The use of compressed air or coolant is required for machining.
- The pressure angle should be less than 3° when plunging or trochoidal machining.
- ➔ The maximum radial infeed results from the cutting diameter minus 1 mm.

☞ In case of vibrations, immediately reduce feed, speed and infeed.

Model	max. (rpm)
0068920	32.000
0068920L	32.000
0068924	30.000
0068924L	30.000
Warning: The max. permissible speed corresponds to the safety limit.	

! WARNING

- Do not work under unsuitable cutting conditions.
- Do not use the tool after the body has been dropped or damaged.
- The tool develops high temperatures during cutting. There is a risk of burns if touched.
- Only use machine tools with sufficient stiffness and drive power.
- Always use the cooling media recommended by DATRON.

INSERTS AND SPARE PARTS

Model	Insert	Clamping screw set	Torque (Nm)
0068920	0068920A	0068920Z	1,2
0068920L	0078920A		
0068924	0078920B		
0068924L	0078920C		

☞ The clamping screw set contains 10 screws and a corresponding angled screwdriver.

! WARNING

- Only use inserts recommended by DATRON. The use of non-recommended inserts can lead to problems.
- To avoid confusion, return each insert to its original box after use.