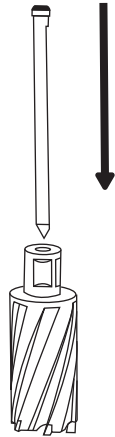


# TCT ANNULAR CUTTER OPERATING INSTRUCTIONS

①

Before using, insert pilot pin into TCT annular cutter.



Insert

②

Then insert into machine arbor.

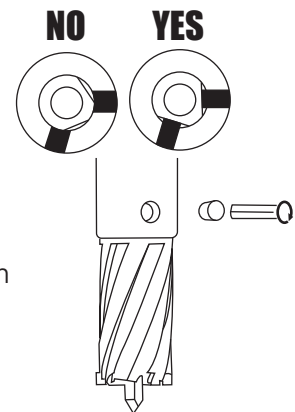


## CAUTION

Hex. socket screw must come directly on the flat surface without dimple (see arrow on the second sketch), for "side lock" type cutter holders.

③

Tighten set screw on cutter flat.



## SPEED RECOMMENDATION (R.P.M Table)

Diameter $\Phi$ mm	Steel Plate	Stainless Steel	Cast Iron
13~18mm	1190~800	1000~500	1790~1390
19~25mm	1160~710	890~440	1590~1240
26~30mm	960~640	800~400	1430~1110
31~35mm	870~570	720~360	1300~1010
36~40mm	760~510	640~320	1140~890
41~50mm	640~430	530~270	950~740
51~55mm	550~360	460~230	810~630
56~60mm	480~320	400~200	710~550
61~65mm	430~280	350~170	630~490
66~70mm	380~260	320~160	570~440
71~80mm	320~220	260~120	490~360
81~90mm	260~180	200~100	420~290
91~100mm	220~150	160~90	350~190