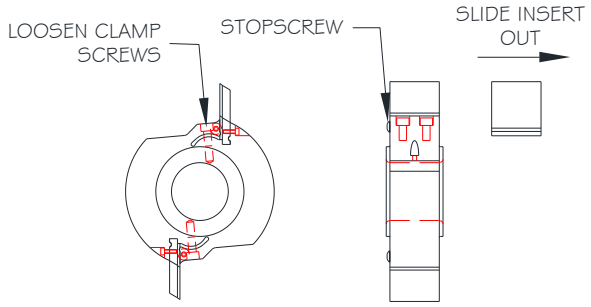
Great Lakes
Custom Tool Mfg., Inc.
Your American Cutting Tool Partner
Phone: 800-873-4528

Great-Loc® Dedicated & Great-Loc® SG Universal Clamping System
Insert Replacement Instructions

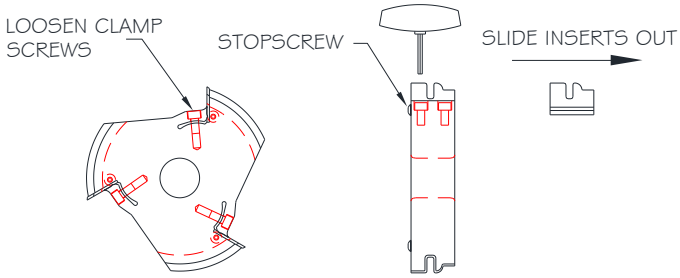
Note: Instructions are for a typical cutter. The cutter shown may not look identical to your cutter.

Great-Loc® Dedicated & Great-Loc® SG Universal - Insert Removal

Loosen the clamp screws. Slide the insert out of the slot. It is recommended to remove the clamp screws every other insert replacement to reapply anti-seize to the threads and under the head.



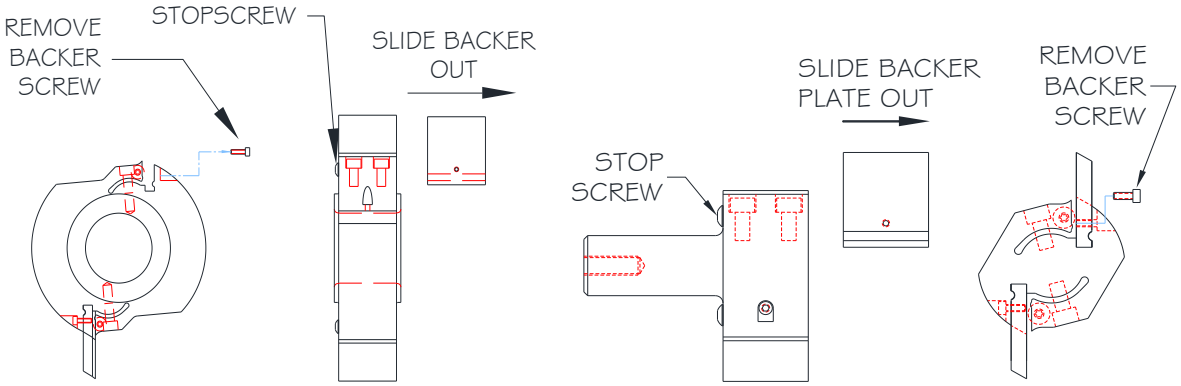
Great-Loc® SG Universal



Great-Loc® Dedicated

Great-Loc® SG Universal Tools - Backer Plate Removal

Remove the backer screw(s). Slide the backer plate out of the slot.

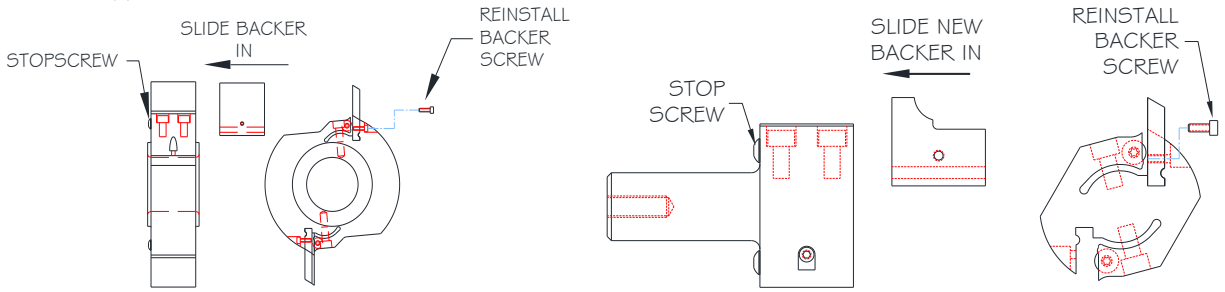


Clean the Tool

Once inserts and backer plates (if applicable) are removed, clean the tool and insert slots with compressed air. If more cleaning is necessary to remove build-up, use hot water or a cleaning solvent.

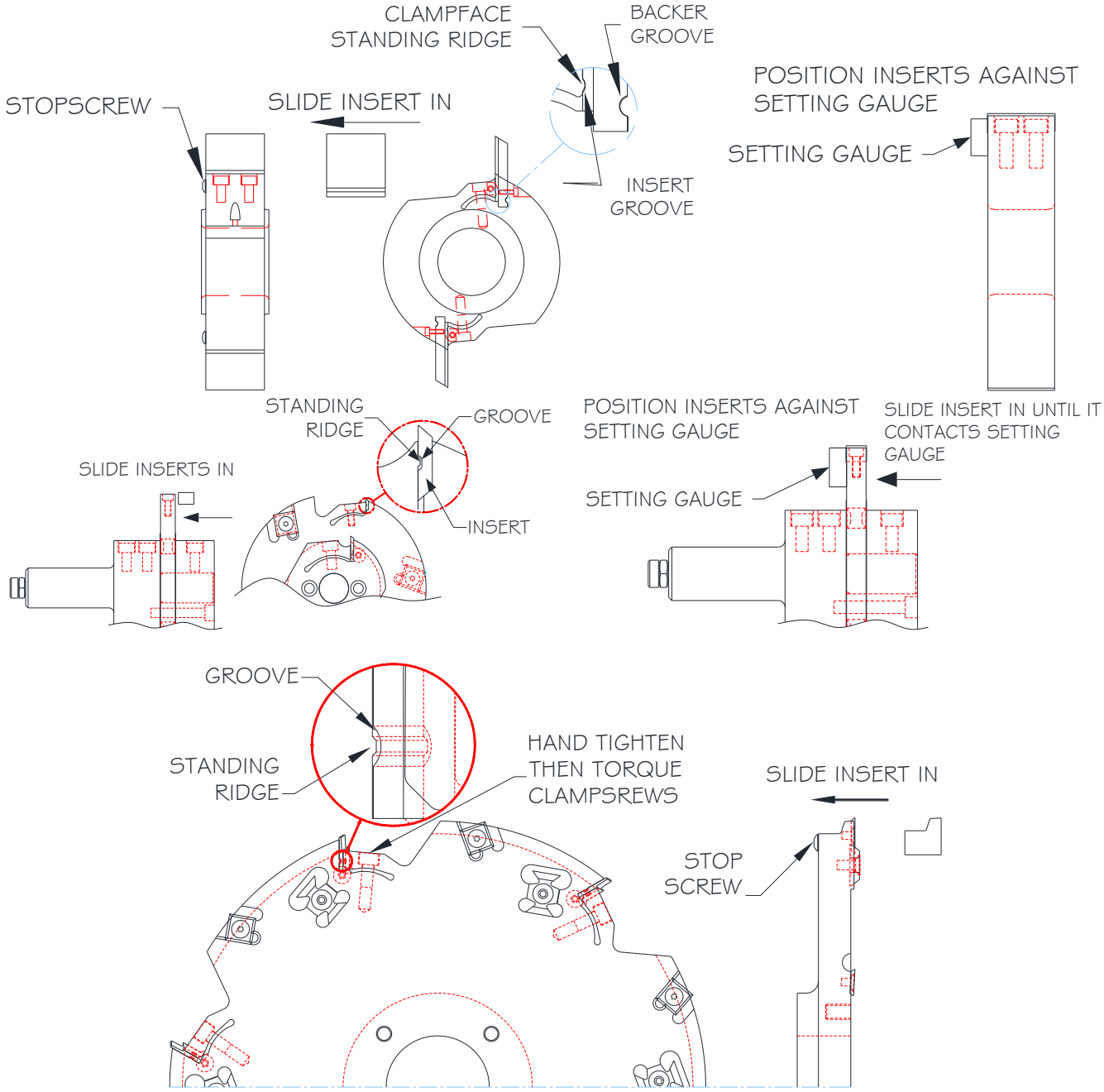
Great-Loc® SG Universal Tools - Backer Plate Installation

Slide backer plate into the slot, making sure the ridge and groove are nested, until holes in the tool align with the holes in the backer plate. Apply anti-seize to the threads and under the head of the backer screw(s). Reinstall the backer screw(s).



Great-Loc® Dedicated & Great-Loc® SG Universal – Insert Installation

Slide the insert into the slot, making sure the ridge and groove are nested, until it contacts the stop screw or setting gauge. With the insert seated properly, tighten the clamping screws enough to hold the insert in-place. Follow the Clamp Screws Tightening Instructions below to complete the installation of the inserts.



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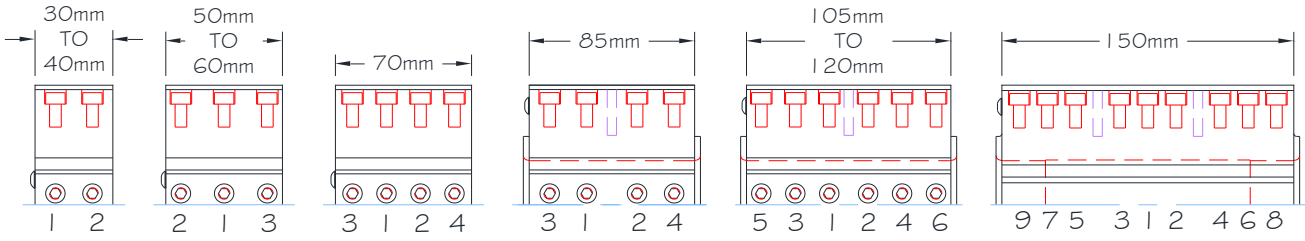
Clamp Screw Tightening Instructions

1. After lightly hand tightening the clamp screws with a T-handle Allen wrench, use a torque wrench to tighten each screw to the correct torque value as listed in ***A00182 – Torque Specifications***. **Note: Ensure you use the correct torque based on the cutter body material.** Tighten each screw a small amount at a time following the tightening sequence below. **Do not** tighten the screw directly to the torque value listed. Tightening each screw a small amount at a time applies equal pressure to the clamp and helps keep the insert precisely in place. (Note: The torque values listed are anti-seize lubricated torque values. Never torque a screw without Anti-Seize to this amount, false torque and/or failure could occur.)

2a. **For cutters with 2 - 3 wings** - After all the clamp screws in one wing are fully tightened, move to the wing directly across the cutter body and tighten those clamp screws. On a 3-wing cutter after tightening all the clamp screws on one wing, move on to either one of the remaining 2 wings and tighten those clamp screws. Follow this pattern until all the clamp screws on all the wings are tight. (Note: Cutters wider than 70mm typically have the clamp split into sections. Use the appropriate tightening sequence that represents the width of each clamp section.)

2b. **For cutters with more than 3 wings** - Follow a similar pattern to the process described and shown. Start with wing 1, torque the clamp screw to the proper torque, then rotate the cutter to wing 2 which will be located directly across from wing 1. Torque this clamp screw, then rotate the cutter to wing 3 and continue this procedure until all the clamp screws on all the wings are torqued. As a final check it is recommended to recheck the torque on all the clamp screws by starting at wing 1 and check the torque on each clamp screw in each successive wing as the cutter is rotated.



TIGHTENING SEQUENCE FOR CLAMP SCREWS
Use the appropriate tightening sequence that represents the width of each clamp section.