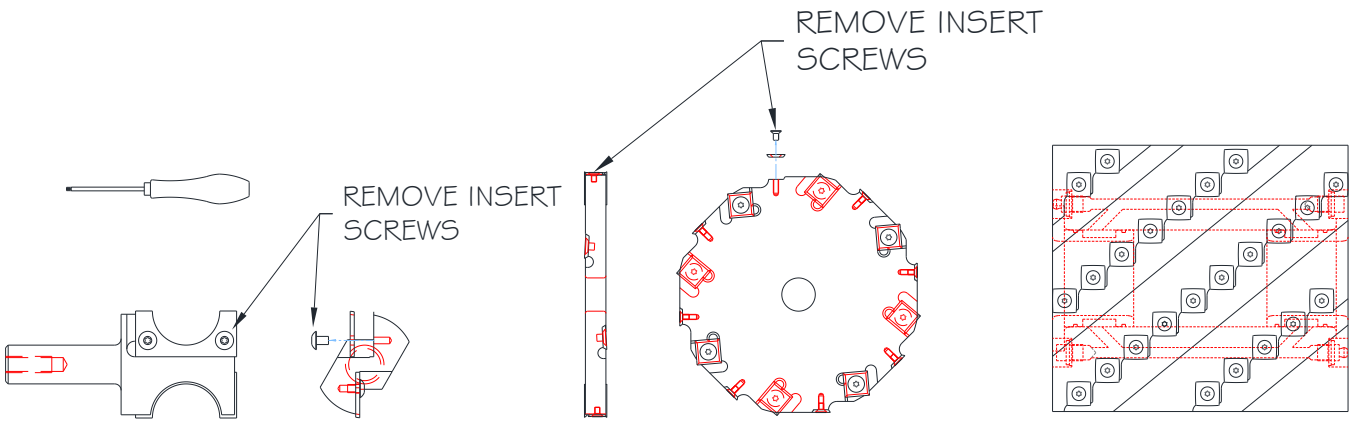
Great Lakes
Custom Tool Mfg., Inc.
Your American Cutting Tool Partner
Phone: 800-873-4528

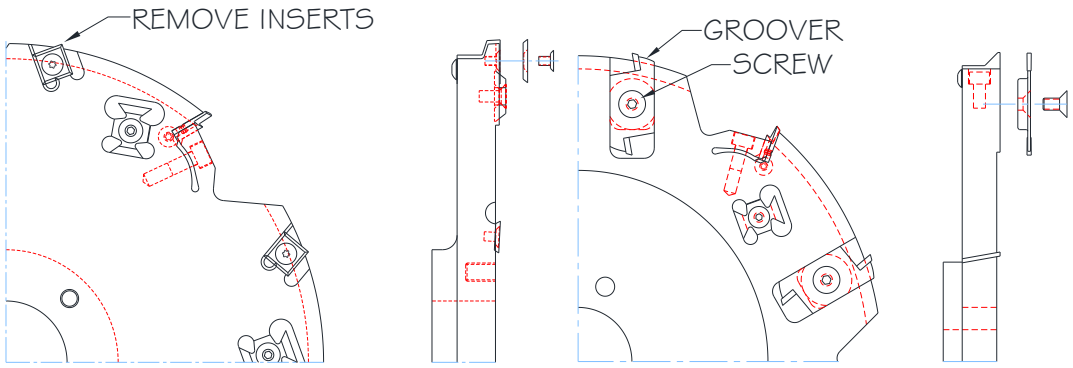
Cutters with Direct Screw Fastened Inserts
Insert Replacement Instructions

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

Insert Removal

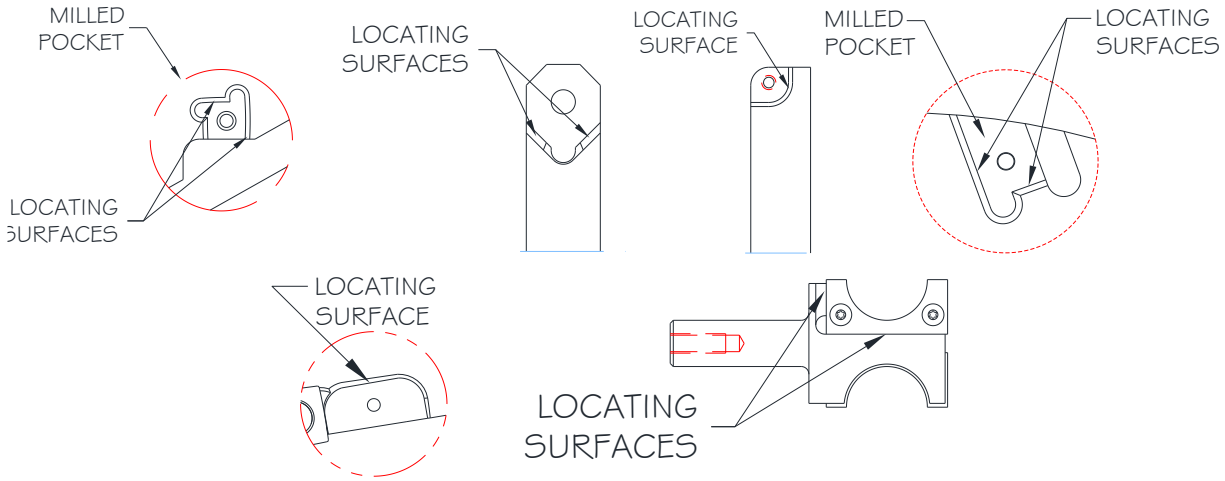
Remove the insert screws and the inserts. **Note:** The cutter may be part of a multiple cutter assembly and it may be necessary to disassemble the cutter sections to replace the inserts.





Clean the Tool & Inserts

Once inserts are removed, clean the tool and inserts with compressed air. If more cleaning is necessary to remove build-up, use hot water or a cleaning solvent. Once clean, visually inspect the insert seats in the tool body and the inserts themselves for damage on the seating surfaces. If inserts are damaged, it may be necessary for them to be replaced. If the seats in the tool body is damaged, it may be necessary to replace it.

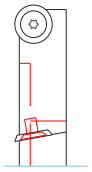


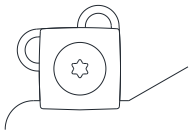
Insert Installation

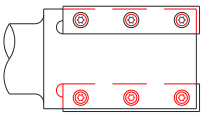
Note: Standard indexable inserts can be used more than once.

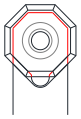
- Square inserts have 4 cutting edges, so it is possible to rotate the insert 90° 3 times after the initial cutter setup.
- Round inserts can be rotated until a new sharp cutting edge is shown.
- Knife inserts can be rotated 180° to provide a new sharp cutting edge. This can only be done 1 time.
- Octagon inserts have 4 cutting edges, so it is possible to rotate the insert 90° 3 times after the initial cutter setup.

The insert **cannot** be used if the worn (used) cutting edge is damaged, such that the insert will not seat properly. Remove any burrs on the angled surface. Replace it with a new insert if damaged.


ROUND


SQUARE


KNIFE


OCTAGON

Apply anti-seize to the threads and under the head of the screw. Place insert into seat making sure a new cutting edge is into the cut and hold the insert against the locating surface(s). Install screw to hold insert in-place and visually inspect to ensure the insert is seated properly. Use a torque screwdriver to torque the screws to the required amount specified in ***A00182 – Torque Specifications***. **Note: Ensure you use the correct torque based on the cutter body material.**