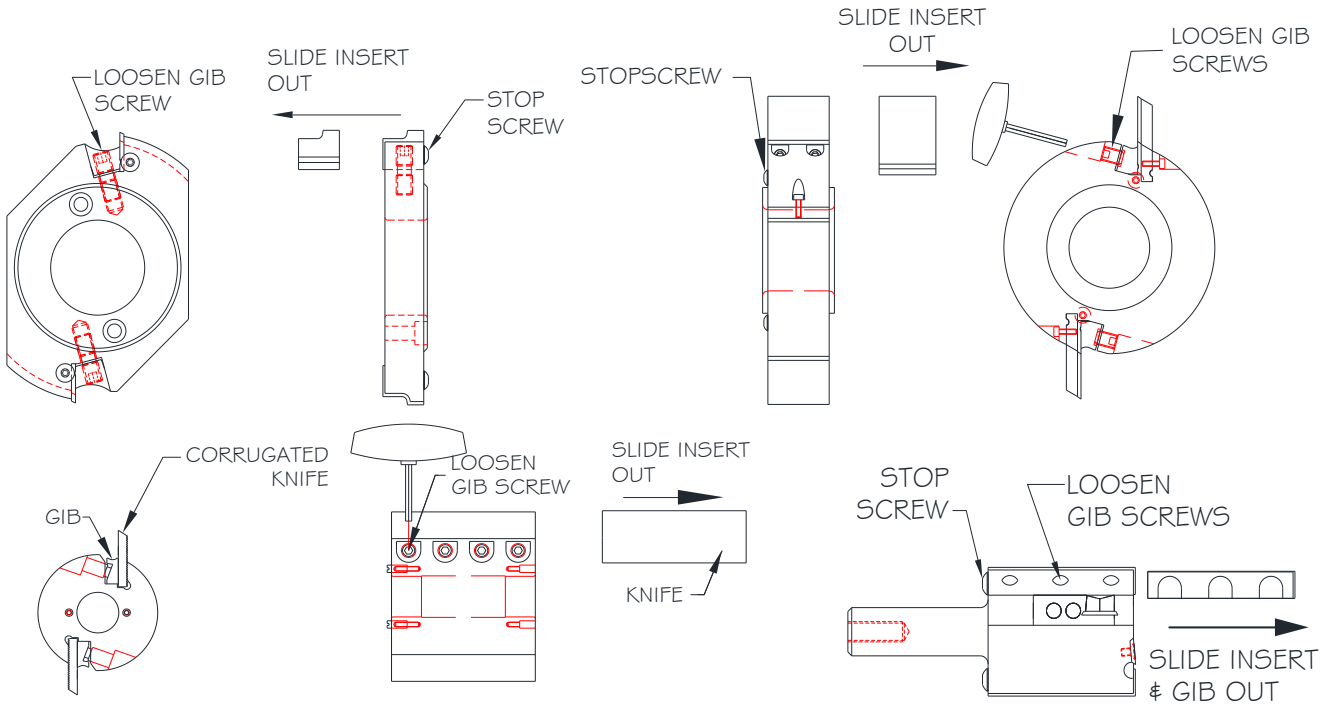
Great Lakes
Custom Tool Mfg., Inc.
Your American Cutting Tool Partner
Phone: 800-873-4528

Gib-Style Cutter – Insert Replacement Instructions

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

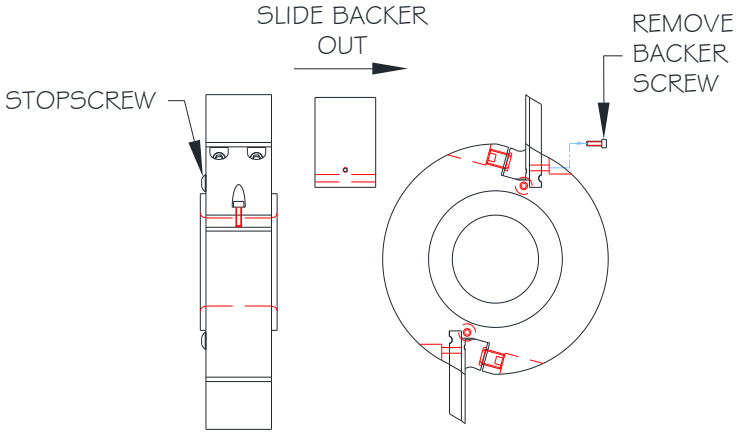
Insert Removal

Loosen the screws one revolution. Slide the insert out. It is recommended to remove the screws every other insert replacement to reapply anti-seize to the threads and under the head. If your cutter has differential screws, refer to **A00187 – Differential Screw Maintenance** on the removal and installation of differential screws.



SG Universal Tooling – Backer Plate Removal

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

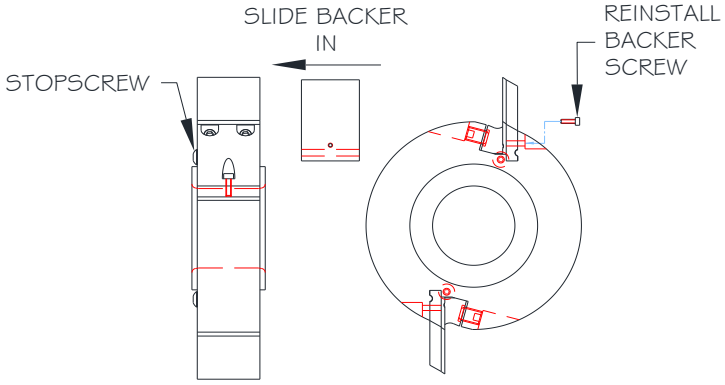


Clean the Tool

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.

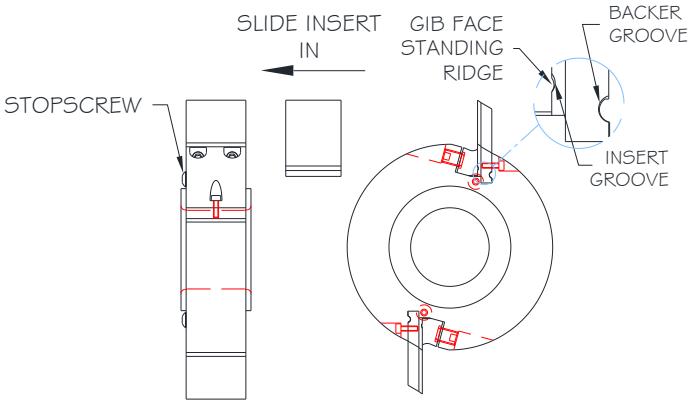
SG Universal Tools - Backer Plate Installation

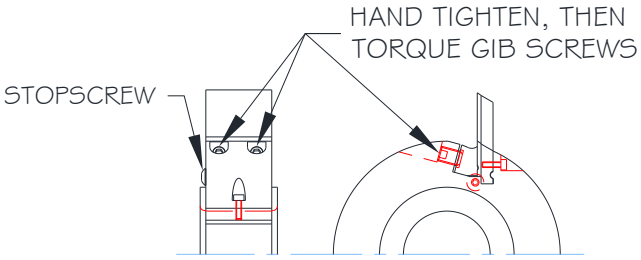
Slide backer plate into the slot, making sure the ridge and groove are nested, until holes in the tool align with the holes in the backer plate. Apply anti-seize to the threads and under the head of the backer screw(s). Reinstall the backer screw(s).

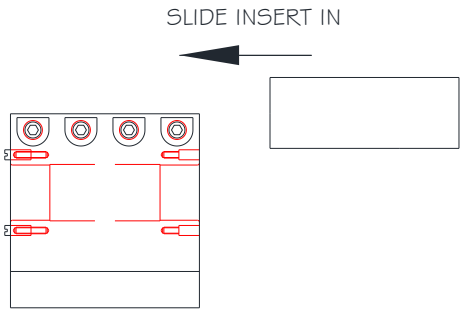


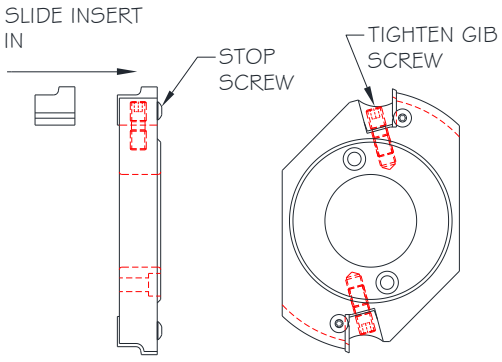
Insert Installation

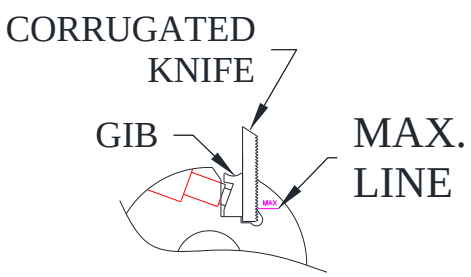
Slide the insert into the slot, making sure the standing ridge of the wedge is within the groove of the insert, until it contacts the stop screw. With the insert seated properly, tighten the gib screws enough to hold the insert in-place. Follow the Clamp Screws Tightening Instructions below to complete the installation of the inserts.

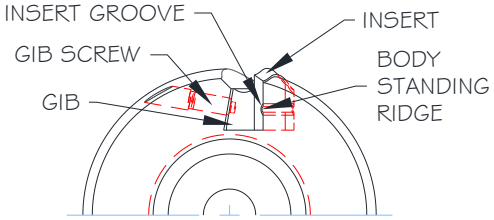












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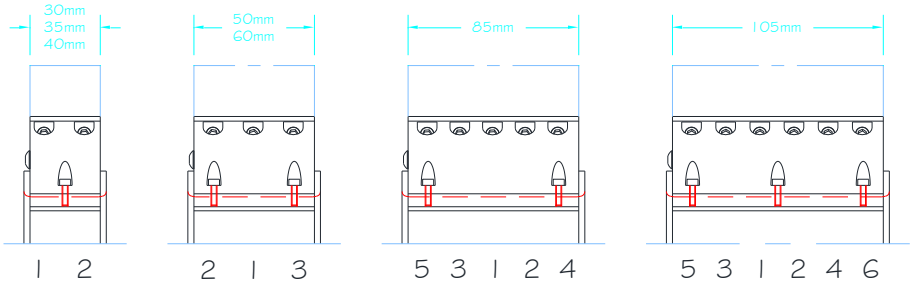
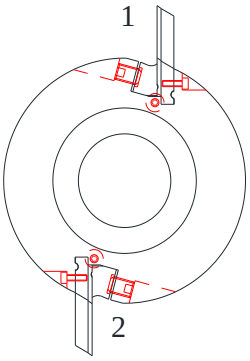
GIB SCREW TIGHTENING INSTRUCTIONS

1. After lightly hand tightening the gib 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 gib 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.)
2. After all the gib screws in one wing are fully tightened, move to the wing directly across the cutter body and tighten those gib screws. On a 3-wing cutter after tightening all the gib screws on one wing, move on to either one of the remaining 2 wings and tighten those gib screws. Follow this pattern until all the gib screws on all the wings are tight. Use the appropriate tightening sequence that represents the width of each gib section.

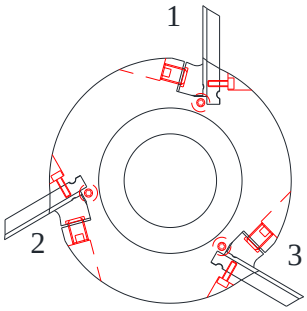


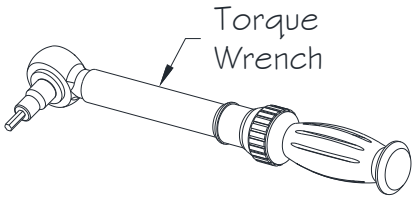
TIGHTENING SEQUENCE FOR GIB SCREWS

2 WINGS



3 WINGS





10 WINGS