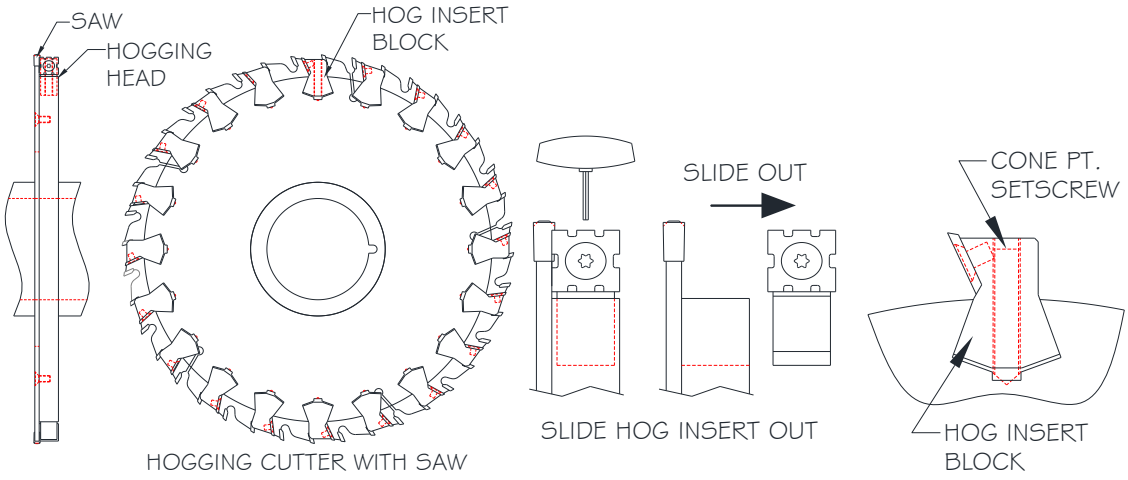
Great Lakes
Custom Tool Mfg., Inc.
Your American Cutting Tool Partner
Phone: 800-873-4528

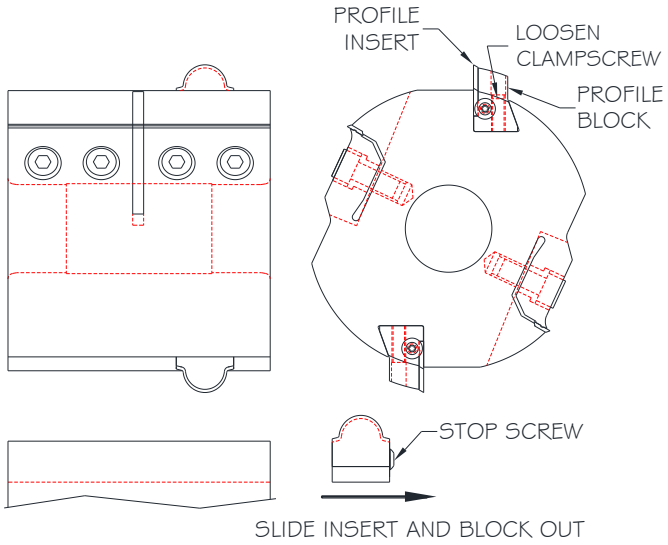
Cutters with Profile/Insert Blocks - Insert Replacement Instructions

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

Block Removal

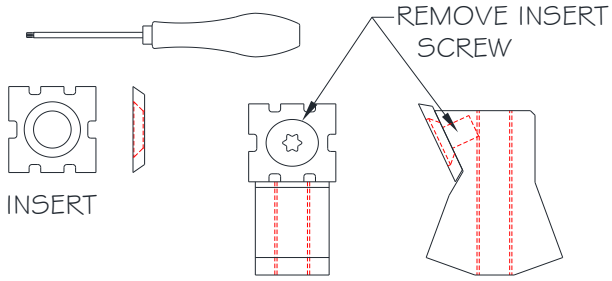
Loosen the screw(s) in the profile/insert block(s). Slide the profile/insert block(s) out of the slot. It is recommended to remove the screws every other insert replacement to reapply anti-seize to the threads and under the head. If your cutter has differential screws, refer to **A00187 – Differential Screw Maintenance** on the removal and installation of differential screws.





Insert Removal

Inserts will either be fastened with a screw or be able to slide out from the block once it is removed from the cutter. For screw face inserts, remove the screw holding the insert in place and remove the insert.



Clean the Tool

Once blocks and inserts are removed, clean the tool, blocks, 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 are damaged, it may be necessary to replace it.

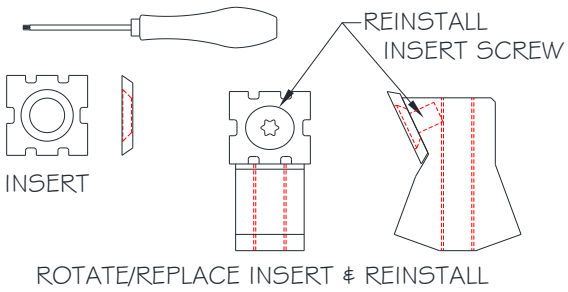
Insert Installation

For inserts without a screw, place the profile insert on the profile block with the bottom of the insert against the bottom of the machined surface and the end of the insert against the stop screw in the block.

For inserts with a screw, 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.**

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.



Block Installation

If screw(s) were removed, apply anti-seize to the threads and under the heads of the screw and reinstall them into the block. Slide the block into the slot of the cutter until it is flush with the cutter body or reaches the desired position. Tightne the screw(s) enough to hold the insert in-place. Using a torque screwdriver, torque the screw(s) to the required amount specified in ***A00182 – Torque Specifications***. **Note: Ensure you use the correct torque based on the cutter body material.**