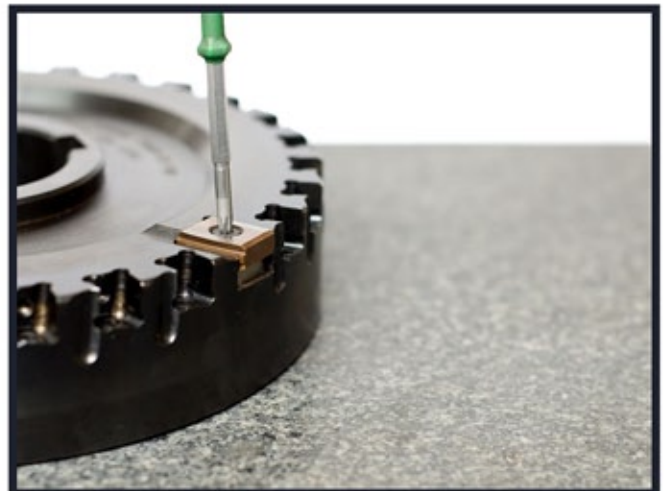
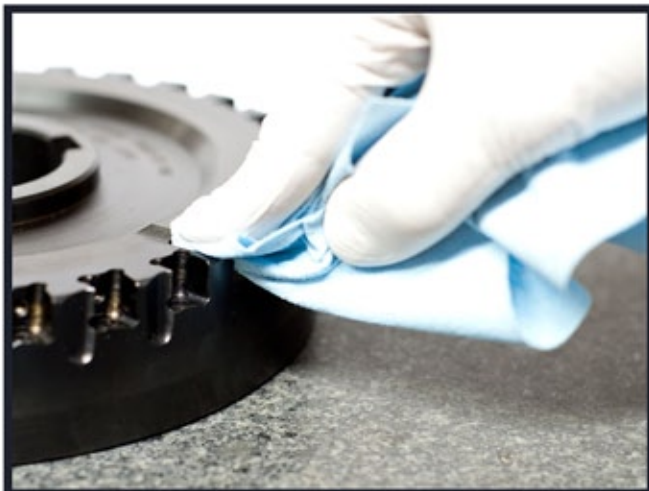
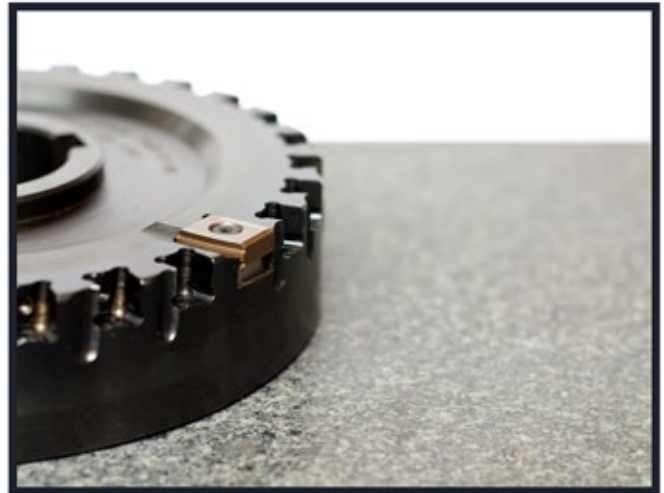




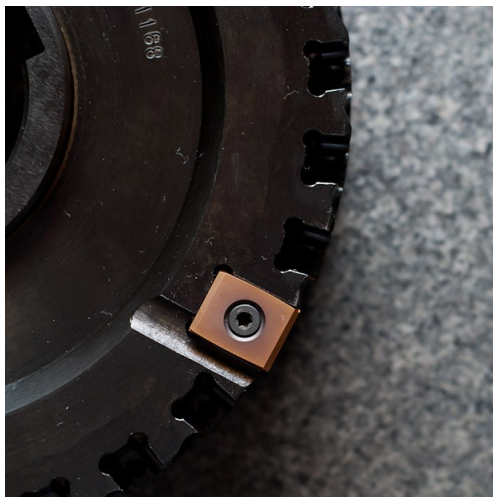
ARM Tooling Systems

Indexing Special Horizontal Wiper Inserts

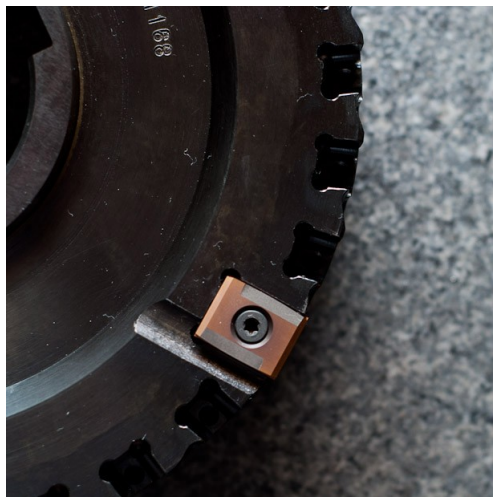


Instructions for Indexing Special Horizontal Wiper Inserts

(See below for comparison pictures between standard and special horizontal wiper inserts)



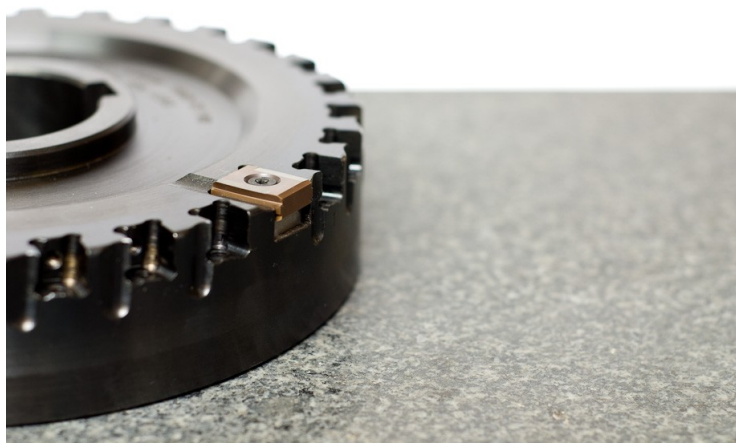
(Standard Horizontal Wiper)



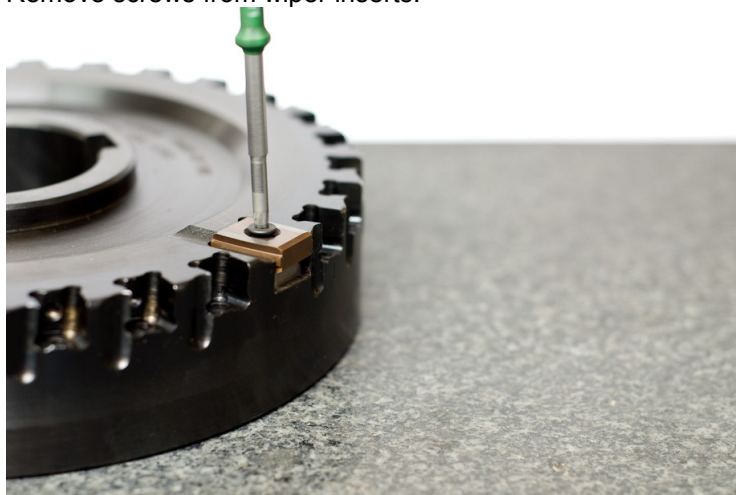
(Special Horizontal Wiper - LH)

I – Disassembly / Cleaning / Visual Inspection

1. Wash cutter before removing wiper inserts.



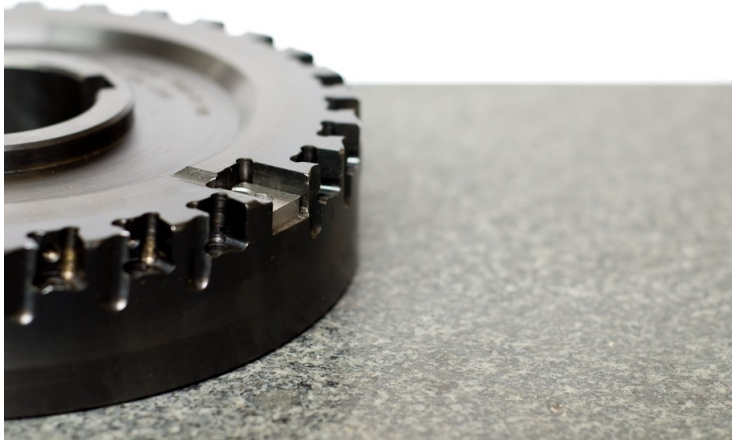
2. Remove screws from wiper inserts.



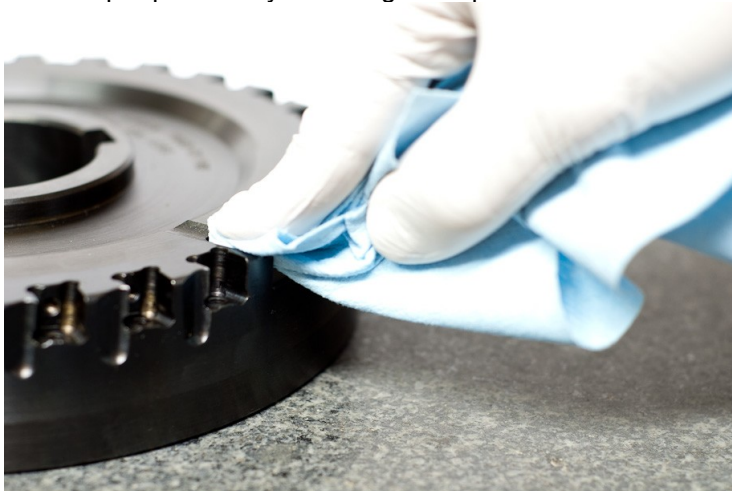
Instructions for Indexing Special Horizontal Wiper Inserts

(See below for comparison pictures between standard and special horizontal wiper inserts)

3. Remove wiper inserts from cutter body and clean them. **DO NOT** remove wiper shims from pockets.



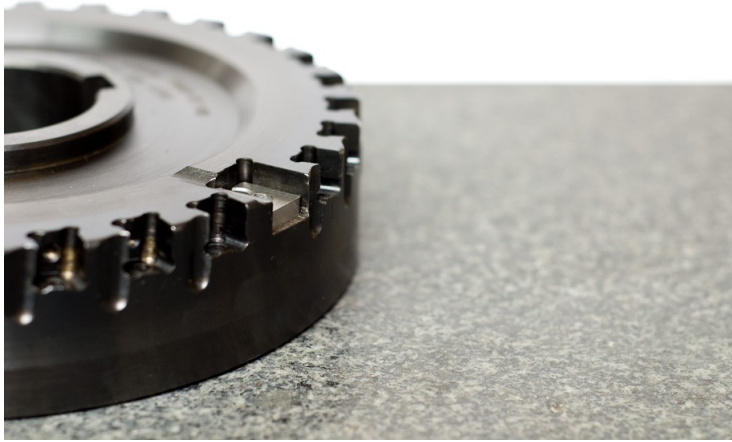
4. Clean wiper pockets by removing all chips and dirt.



Instructions for Indexing Special Horizontal Wiper Inserts

(See below for comparison pictures between standard and special horizontal wiper inserts)

5. Check wiper pockets for wear or any nicks/burrs that need to be removed.



6. Check and replace any screws that are damaged.
7. Check for broken or chipped wipers that can't be used again. Typically you should get four indexes regardless of cutter rotation.

Instructions for Indexing Special Horizontal Wiper Inserts

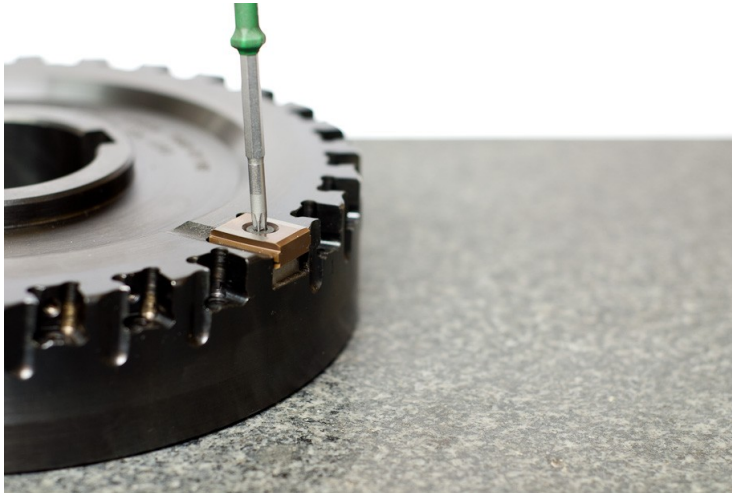
(See below for comparison pictures between standard and special horizontal wiper inserts)

II – Assembly / Inspection

1. Place wiper insert into the pocket. Slide the wiper insert back and forth in the pocket to ensure that it is seated properly. When using the special horizontal wiper inserts, be sure to use the correct wiper in the correct cutter. Refer to the comparison picture at the beginning of these steps, the cutter shown is a LH cutter, a RH cutter is opposite.



2. Place the screw into the wiper and torque it to the recommended spec for that wiper and screw.



3. Using an indicator, check the step from the wiper to the highest insert.

