ARM Tooling Systems

Indexing
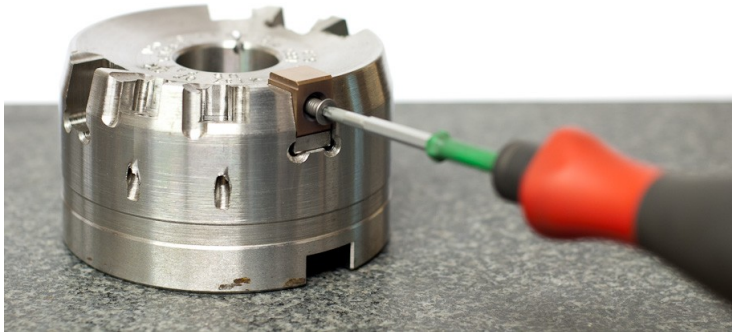## Vertical Wiper Inserts

Instructions for Indexing Vertical Wiper Inserts

I – Disassembly / Cleaning / Visual Inspection

1. Wash cutter before removing wiper inserts.

2. Remove screws from wiper inserts.

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

Instructions for Indexing Vertical Wiper Inserts

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

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 wiper inserts that can't be used again. Typically you should get four indexes regardless of cutter rotation.

Instructions for Indexing Vertical Wiper Inserts

<u>II – Assembly / Inspection</u>

1. Place wiper insert into the pocket with a new cutting edge in the correct direction. Slide the wiper insert up and down in the pocket to ensure that it is seated properly.

2. Once seated, using your thumb or finger, push down on the top of the wiper insert to keep it from moving while tightening the screw. 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.