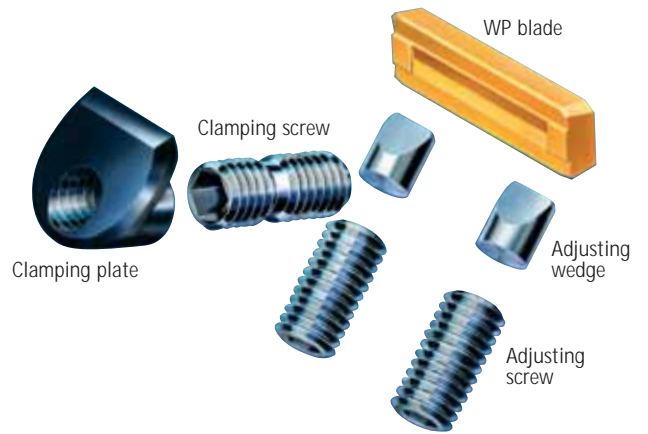


Setting Instructions for MAPAL WP Twin-Bladed Reamers:

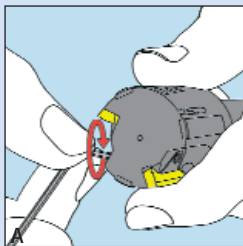
MN 2200, MN 2223
MN 2225, MN 2227
MN 2243



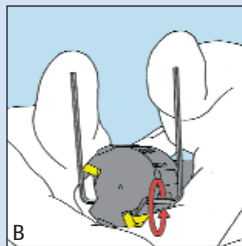
Accessories

Indexable blade	Torx screw/ Clamping screw MN 618	Clamping plate	Adjusting screw MN 620	Adjusting wedge MN 619
2 off	2 off	2 off	4 off	4 off

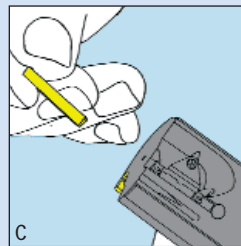
Changing and setting the blade



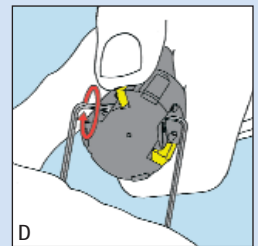
Turn the front and back adjusting screw 1/2 turn anti-clockwise.



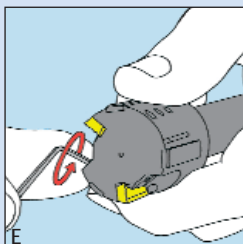
Turn torx screw or clamping screw anti-clockwise from the top and clockwise from the bottom. Two keys need to be used to open (as shown). The clamping plate will be loosened.



1. Remove blade.
2. Clean the blade and blade seat (do not use compressed air – note the adjusting wedge).
3. Turn the blade or insert new blade.



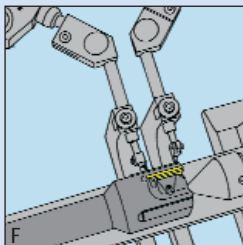
1. Press blade against back stop and adjusting wedge.
2. Turn torx screw or clamping screw clockwise from the top and anti-clockwise from the bottom. Two keys need to be used to open (as shown). The clamping plate will be tightened.



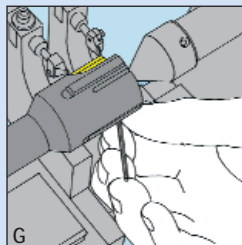
Note:
The same procedure (Fig. A-E) also applies for the second blade.

For rough adjustment, turn the front and back adjusting screw clockwise again 1/4 turn.

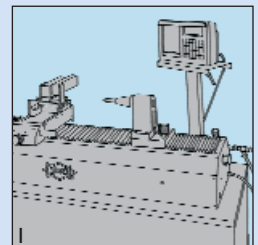
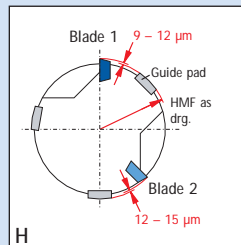
To make handling easier and ensure reliable setting, we recommend the use of a MAPAL setting device.



1. MAPAL MASTERSET: Set the spacing for the MASTERSET to the blade length.
2. Zero the dial indicator on the guide pad following the blade.



Setting Blade 1: Set the front and rear setting dimension for varying intervals with the adjusting screw.
Setting dimension: amount of the blade over the following guide pad as in setting instructions Fig. H. Back tapering to rear approx. 0,01 to 0,015 mm.
Setting Blade 2: Set the front and rear setting dimension for varying intervals with the adjusting screw.
Setting dimension: amount of the blade below the following guide pad as in setting instructions Fig. H. Back tapering to rear approx. 0,01 to 0,015 mm.



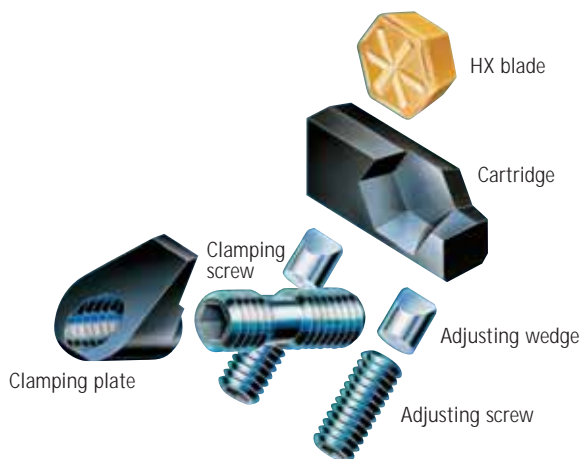
MAPAL UNISSET: For easy setting of reamers MAPAL supplies electronic setting devices in vertical and horizontal designs. Please ask for our special brochure on "Setting Devices". Detailed setting notes can be found in the equipment's operating instructions.

Setting Instructions for MAPAL HX Twin-Bladed Reamers:

MN 6200, MN 6223

MN 6225, MN 6227

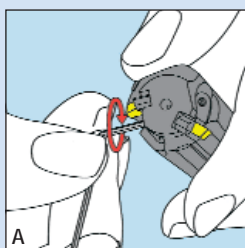
MN 6243



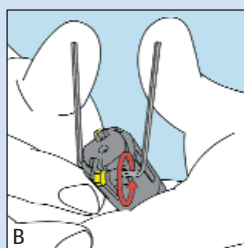
Accessories

Indexable blade	Cartridge	Torx screw/ Clamping screw MN 618	Clamping plate	Adjusting screw MN 620	Adjusting wedge MN 619
2 off	2 off	2 off	2 off	4 off	4 off

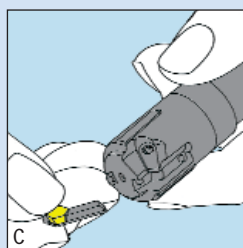
Changing and setting the blade



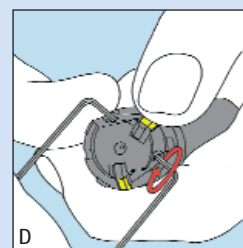
Turn the front and back adjusting screw 1/2 turn anti-clockwise.



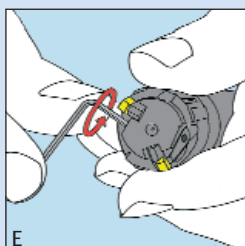
Turn clamping screw anti-clockwise from the top and clockwise from the bottom. Two keys need to be used to open (as shown). The clamping plate and cartridge will be loosened.



1. Remove blade and cartridge.
2. Clean blade, cartridge and blade seat (do not use compressed air – note the adjusting wedge).
3. Turn the blade 60° or insert new blade in cartridge.
4. Replace cartridge.



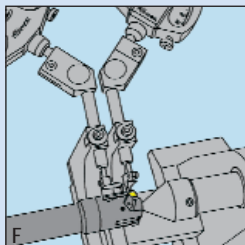
1. Press blade and cartridge against back stop and adjusting wedge.
2. Turn clamping screw clockwise from the top and anti-clockwise from the bottom. Two keys need to be used to open (as shown).



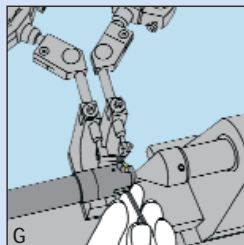
Note:
The same procedure (Fig. A-E) also applies for the second blade.

For rough adjustment, turn the front and back adjusting screw clockwise again 1/4 turn.

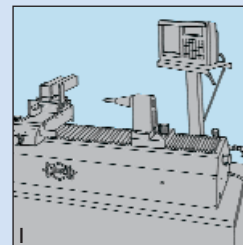
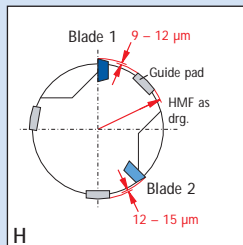
To make handling easier and ensure reliable setting, we recommend the use of a MAPAL setting device.



1. MAPAL MASTERSET: Set the spacing for the MASTERSET to the blade length.
2. Zero the dial indicator on the guide pad following the blade.



Setting Blade 1: Set the front and rear setting dimension for varying intervals with the adjusting screw.
Setting dimension: amount of the blade over the following guide pad as in setting instructions Fig. H. Back tapering to rear approx. 0,005 to 0,010 mm.
Setting Blade 2: Set the front and rear setting dimension for varying intervals with the adjusting screw.
Setting dimension: amount of the blade below the following guide pad as in setting instructions Fig. H. Back tapering to rear approx. 0,005 to 0,010 mm.



MAPAL UNISSET: For easy setting of reamers MAPAL supplies electronic setting devices in vertical and horizontal designs. Please ask for our special brochure on "Setting Devices". Detailed setting notes can be found in the equipment's operating instructions.