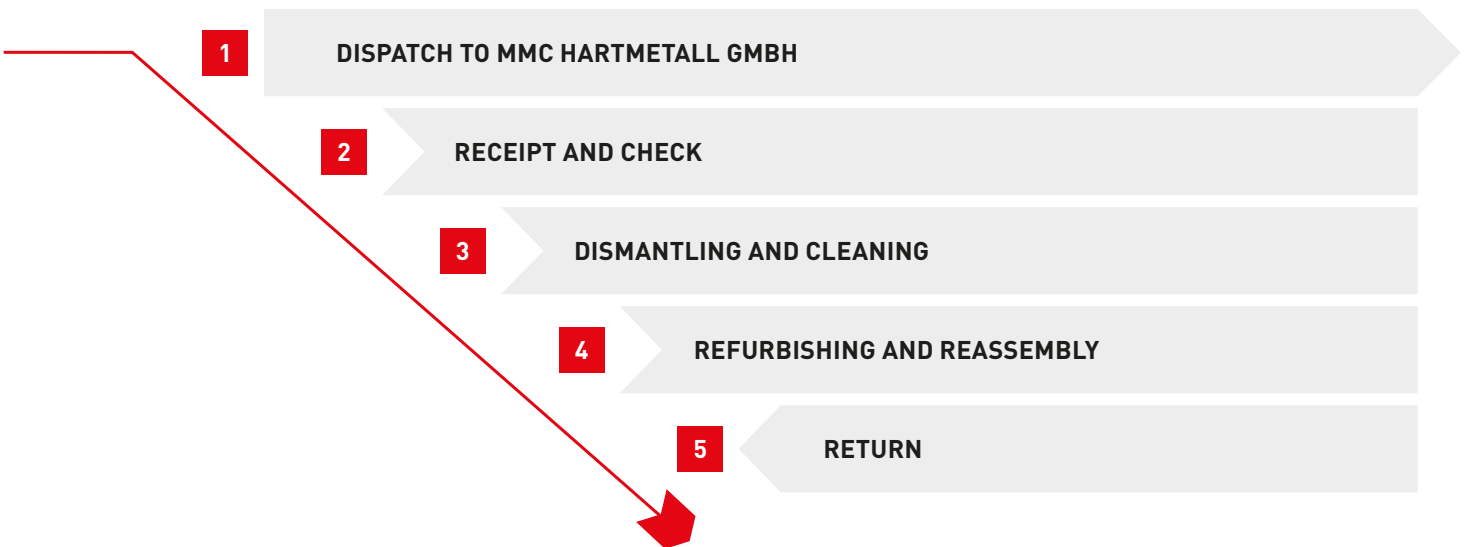


FMAX

SERVICE



REMANUFACTURING



1. Send the FMAX milling cutter in the transport box provided and specify the desired service required.
2. Upon receiving the cutter, the condition will be inspected and a report sent of any additional work that is required.
3. The inserts and any removable parts are dismantled. The FMAX cutter is then cleaned.
4. The refurbished inserts are re-mounted and adjusted ($\leq 5\mu$) and the cutter is re-balanced.
5. The refurbished FMAX milling cutter is then returned.



SERVICE CENTRE

MMC Hartmetall GmbH

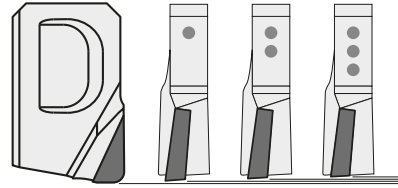
Technical Service Department
Service Group
Comeniusstr. 2
40670 Meerbusch
Germany

Phone +49 2159 9189 0
Fax +49 2159 9189 66
E-mail rem@mmchg.de

SERVICE NOTES

Each insert has a visible marking dependant on the number of refurbishments.

- 1st refurbishment: 0.2 mm - •
- 2nd refurbishment: 0.4 mm - ••
- 3rd refurbishment: 0.6 mm - •••



In order to achieve the best balance, we recommend all inserts to have been refurbished the same number of times.

Notes

- Inserts can be refurbished a maximum of three times with 0.2 mm material removed each time.
- The maximum amount of material removal during refurbishment must not exceed 0.6 mm.
- Inserts with wear greater than 0.6 mm must be replaced.

Additional costs

- If any additional costs are required, an approval will be asked for before proceeding.

Special inserts

- The price and delivery time may vary if special inserts are used. A corresponding offer will be sent.

FMAX KITS (NEW TOOLS)

Designation for FMAX Kits	No. of teeth	DC (Ø)	Price
FMAX-050A08R-ASM*	8	50	
FMAX-050A10R-ASM	10	50	
FMAX-063A10R-ASM*	10	63	
FMAX-063A12R-ASM	12	63	On request
FMAX-080B14R-ASM	14	80	
FMAX-100B18R-ASM	18	100	
FMAX-125B24R-ASM	24	125	

* Please request delivery date

For FMAX kits including holder

Please contact the local sales person or the service centre.
[See contact page 2]

TRANSPORT BOX

A high-quality transport box is included when ordering a kit for the first time.

Please contact your local agent or service centre if more boxes are required.
[See contact page 2]

FMAX KIT CONTENTS

- FMAX milling cutter
- Diamond inserts
(Specification of the desired insert type when ordering, e.g. GOER1400PXFR2 MD2030)
- Adjusted (<5µ) and balanced
(G2.5 at 20,000 min⁻¹)
- Axial run-out and balance figures recorded
- Transport box



SERVICE OVERVIEW

Service	Request	Action	Notes	Price
[RGOER1400PXFR2 MD2030]				
Level 1	Please send the inserts only. The inserts are refurbished and marked accordingly.	✓ Refurbishment of the inserts	The price depends on the number of inserts to be refurbished.	At cost/insert
• Inserts				
[FMAX-POCKET-SERVICE]				
Level 2	Please send the cutter and mounted inserts in the transport box provided.	✓ Dismantling ✓ Cleaning ✓ Refurbishment of the inserts ✓ Adjusting the axial run-out ✓ Balancing	The overall price depends on the number of teeth. Possible additional costs for:	At cost/tooth
• Milling cutter			• Replacement of individual components of the milling head	
• Inserts				
[FMAX-POCKET-SERVICE]				
Level 3	Send the FMAX cutter fitted on the tool holder, including the inserts in the transport box provided.	✓ Dismantling ✓ Cleaning ✓ Replacement of the plates ✓ Adjusting the axial run-out ✓ Balancing the cutter	The overall price depends on the number of teeth. Possible additional costs for:	At cost/tooth
• Holder			• Replacement of individual components of the milling head	
• Milling cutter			• Additional balancing of the tool holder	
• Inserts				
