

TURNING FRONT HEAD WITH STATIONARY ANTI VIBRATION ADAPTOR

Serrated-Face Connection | Correct • Rigid • Repeatable

01 IDENTIFY COMPONENTS



Verify front head, anti vibration adaptor, serration size, hand/orientation and clamping screw are compatible.

02 CLEAN INTERFACES



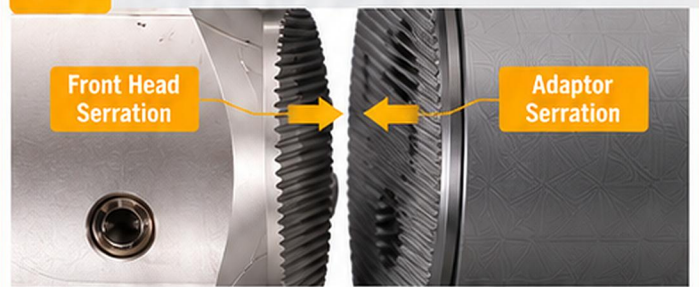
Remove chips, oil and dirt from both serrated faces, screw threads and seating surfaces. Use lint-free cloth, approved degreaser and clean dry air.

03 INSPECT PARTS



Inspect serrations, locating faces, screw threads and coolant passage. Do not assemble damaged components.

04 ALIGN FRONT HEAD



Align serration teeth, orientation and coolant passage. Place the front head squarely on the adaptor without forcing.

05 INSERT & HAND-TIGHTEN



Fit the correct clean clamping screw(s). Engage threads by hand and snug lightly while holding the head against the seating face.

06 TORQUE CLAMPING SCREW

Use a calibrated torque wrench/key. Tighten smoothly to the specified manufacturer torque. Do not use an impact tool or extension pipe.

Tool Ø (mm)	Clamping Thread	Recommended Torque (Nm) (Class 12.9, Dry)
25	M4	3 – 4
32	M5	6 – 8
40	M6	10 – 12
50	M6	10 – 12
60	M8	24 – 28

07 FINAL VERIFICATION



- ✓ Head is rigid and flush
- ✓ Coolant alignment OK
- ✓ No visible gap
- ✓ Free from runout (as required)
- ✓ Coolant flows correctly
- ✓ Perform a low-speed trial



SAFETY & QUALITY:

Stop the machine and isolate energy before work. Wear PPE. Never clamp over chips. Never exceed specified torque. Record inspection/torque where required.

