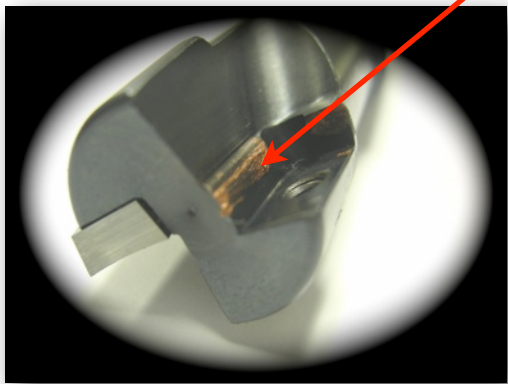


Freedom Cutter

Apply a light amount of anti-seize compound to the two insert seating surfaces. This helps the insert fit firmly and seat properly in the pocket.

Insert Seating Surface

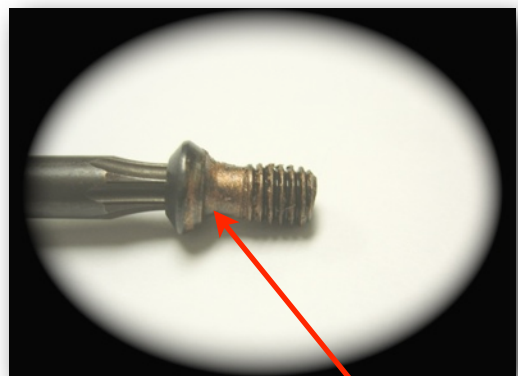


HV3HD & HV5HD

Tighten Inserts firmly, if using a torque wrench, use Mil-Tec recommendations. After initial tightening, unscrew a 1/4 to 1/2 turn and quickly re-tighten. This assures proper seating of the insert and screw.

CUTTER	INCH POUNDS
Freedom Cutter	28 to 30
HV3HD	12 to 15
HV5HD	16 to 20

Apply an even layer of anti-seize compound to the threads of the screw. Be sure to apply compound to the screw chamfer on the underside of the screw head. This helps the screw seat to the taper in the insert hole.



Screw Chamfer