

Thank You for purchasing the Pinnacle Fly Cutter “Ready to Run” R8 KIT.

In your package you will find the 11 inch Pinnacle Fly Cutter disc, an R8x1-1/2 arbor and a sealed bag containing; One RNM42 PCD insert, One RNM42 CBN insert, Two 3/8-24 x 5/8 set screws, Two 3/8-24 x 3/4 set screws, and two tool holders.



The RNM/RNG42 PCD insert is to be used on aluminum. This material will not cut Cast Iron or Steel; attempting to do so will result in a damaged insert.

The RNM/RNG42 CBN insert is to be used on Cast Iron.

The set screws are to keep the tool holders in place. Use the 3/4 long screws on the outside, the tool holders are pocketed to prevent ejection.

When machining be sure to use both tool holders for balance. Be sure to keep the tool holders at the same radius from center. Use only one insert.

The suggested starting feeds and speeds are as follows;

Spindle speed 900 rpm.
Feed rate 6 inches per min.
Typical depth of cut is <.010
Suggested lead .0015

Other tools that may be useful in setting up for a job...

This Starrett back plunger style indicator set is great for indicating in a work piece to be resurfaced.



A universal indicator holder and a test indicator or two may be helpful depending on the type of work that has to be completed.

