

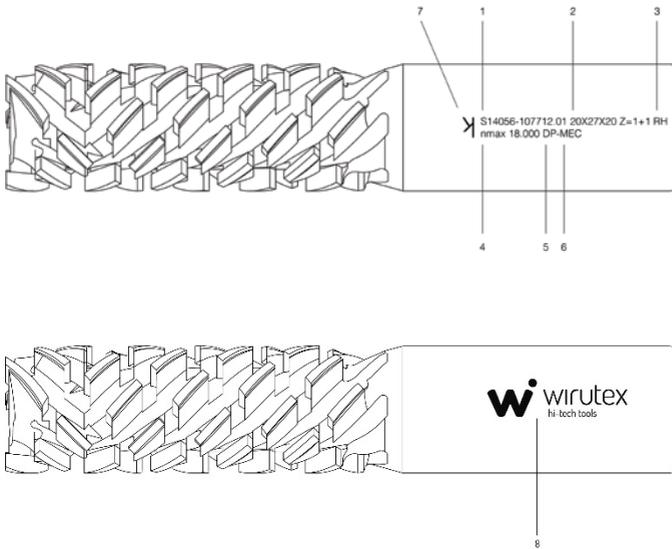
Tips for using the **DRILL** correctly.

Our tools are built using the best materials and pioneering, certified processes to ensure top quality, long-lasting products.

WIRUTEX guarantees that the tool is built in accordance with European Standard EN 847-1.

Before using the tool, read the User Manual carefully.

## A.1 Marking



1. Unique product code
2. Product description
3. Rotation direction in relation to the machine motor
4. Max. number of rotations per minute (nmax)
5. Cutting materials
6. Type of movement
7. Tightening length
8. Manufacturer

## B.1 Safe use

### B.1.1 General information

The tool must be used as explained in the User Manual section.

### B.1.2 Tool unpacking and handling



Use safety gloves to avoid the risk of injury due to sharp cutting edges.

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Pay attention while unpacking, packing and generally handling the tool. Risk of injury!

Always use the original packaging when transporting the tool.

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### **B.1.3 Maximum speed**



The maximum speed (indicated on the tool itself) must not be exceeded.  
The maximum number of rotations (shown by "N° max") must not be exceeded.

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### **B.1.4 Assembly**



The tools and tool bodies must be tightened in such a way that they cannot come loose while they are being used.

To do this, follow the machine manufacturer's instructions.

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It is absolutely forbidden to start up the machine while replacing the tool or inserts.

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Pay attention when assembling the tools: the tightening must be made on the body and the sharp parts must not come into contact with each other or with the tightening elements.

The tightening surfaces must be clean. Remove all traces of dust, grease, oil and water.

The screws and locknuts must be tightened using the right spanners and applying the torque values indicated by the manufacturer. See table 1, point C.1

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It is forbidden to use a spanner extension, or to tighten the parts by striking them with a hammer!

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### **B.1.5 Precautions**



Check the condition of the tools regularly. If you notice any clear cracks, do not use the tool.

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Check the cutting parts, locking elements, screws and tool body regularly for defects.

This must be done above all if the tool collides with machine parts.

Any damaged or worn elements (e.g. cutting parts, screws or locking elements) must be replaced with original spare parts.

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### B.1.6 Cleaning



The tools must be cleaned regularly.

The cutting parts in light alloy must be regularly cleaned to remove resin and glue. Use solvents or detergents that don't affect the mechanical characteristics of the materials.

Follow the instructions given by the solvent/detergent manufacturer.



Attention - risk of injury due to sharp edges.



Always use safety gloves.

### B.1.7 Maintenance, sharpening, repairs



The maintenance of the tools, along with sharpening and repairs, must be carried out exclusively by the manufacturer or by an authorised Assistance Centre.

## C.1 Tightening torques

Screw	Tightening torque value (N/m)		
	Quality 8.8	Quality 10.9	Quality 12.9
M2	0.4	0.5	0.6
M2.5	0.8	1.2	1.4
M3	1.3	1.8	2.2
M4	3	4.3	5.1
M5	6	8.5	10.2
M6	10.3	14.7	17.6
M7	17.2	24.5	28.4
M8	25.5	35.3	42.2
M10	50	70.6	85.3
M12	87.3	122.6	147.1

## D.1 Contacts and addresses

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