

# Tool Setup Guidelines



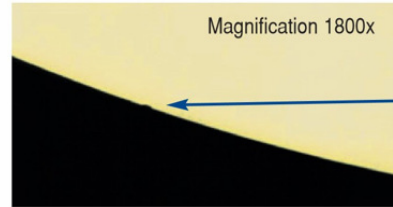
**CONTOUR**  
FINE TOOLING

**Diamond is hard but also very brittle!**



Always clean the diamond with a new tissue and spirits.

Never touch the diamond!  
It will damage the cutting edge!



Magnification 1800x

Chip of about 2µm in cutting edge = beginning of tool wear!

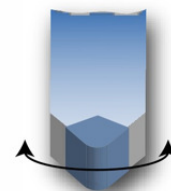
## Cleaning the Tool!

**To clean the top of the tool**



Only ever gently wipe from the front edge to the back

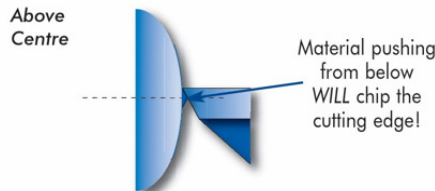
**To clean the front of the tool**



Gently wipe from side to side around the front edge

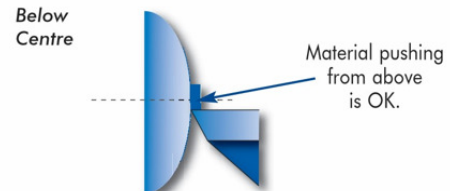
## Setting Tool Height

**Tool above centre WILL damage the cutting edge!**



Material pushing from below WILL chip the cutting edge!

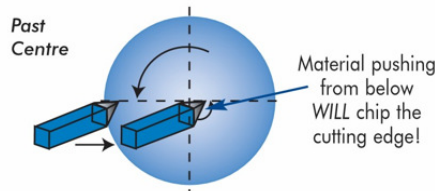
**Always start below centre and adjust up to centre.**



Material pushing from above is OK.

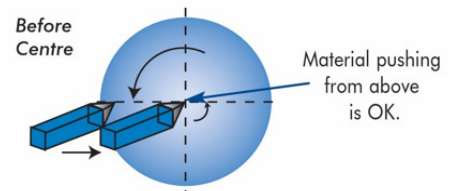
## Setting Tool Centre

**Running the tool past centre WILL damage the cutting edge!**




Material pushing from below WILL chip the cutting edge!

**Always start before centre and adjust up to centre.**



Material pushing from above is OK.

**Use the Cutting Height on the labels to set the tool!**


**Tool# V17402**  
 Type: SCQ0300mLFC/0.1  
 Radius: 0,301mm  
 Height: 4,191mm

Height used tool


**Tool# V17407**  
 Type: SQC0300mLFC/0.1  
 Radius: 0,275mm  
 Height: 4,147mm

Height used tool

**Brazil – England – Japan – The Netherlands – USA**  
<http://contour-diamonds.com/contact-us/>