

IRU Tool Wear Inspection Guide

Want to know if your IRU components need to be repaired, re-sharpened or reconditioned? Use this guide to determine the best course of action.

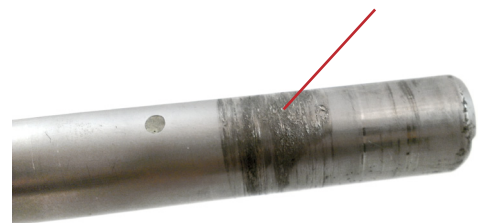
IRU cutters:

- Normal life of a cutter is 100 to 125 cutting minutes.
- Cutters should then be pulled and re-sharpened.
- Cutters can typically be re-sharpened 3-5 times, depending on the amount of material removed with each sharpening.

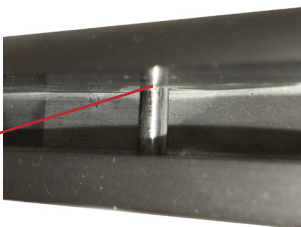
IRU pilots:

- The pilot should be inspected when the cutters are replaced.
- If the pilot is picking up material, it needs to be carefully polished without changing the diameter of the pilot.

Example of pilot picking up material



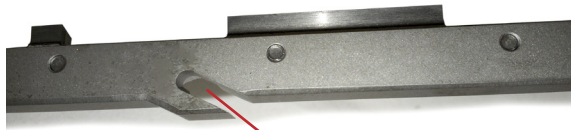
Flats on pin



- Inspect the pins to see if they are loose or if they have flats worn on them.
- If there is excess wear or if there is an issue with the pins, the pilot should be sent to us for evaluation.

IRU carrier arms:

- The carrier arm should be inspected when the cutters are replaced.
- Look for wear in the pin slots and the front ramp. Take the arm and insert it into a pilot and check to see if it stays secure when actuated.
- If there is too much movement that allows the arm to shift in the pilot, then it should be sent to us for evaluation.



Wear in pin slots



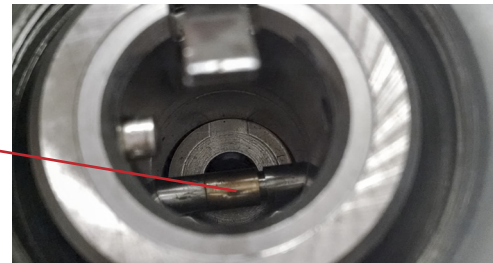
Wear on front ramp

IRU operating heads:

- The head should be inspected when the cutters are replaced
- It should be actuated to make sure that it moves freely and does not catch.
- The housing should be rotated to feel the bearings to make sure they move freely.
- Look inside the shank to inspect the “pull pin” and “pull pin carrier”. Actuate the operating head to see if there is excess wear in the ID of the shank.
- If the operating head does not actuate smoothly, the bearing feels rough or you see excessive wear in the ID, return the operating head for evaluation.



Wear/damage in ID of shank



Wear on pull pin assembly

When Sending a Tool To Us Becomes Necessary:

Please call or email us to get an RMA. This ensures that your parts are being tracked and will be repaired and returned in a timely manner. Once we receive your parts, we will evaluate them and provide you with a quote for the repairs.



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