

# Instruction manual for BXD type (mm)

## 1. How to locate the insert

1. Prior to locating the insert, air blow the insert seat.
2. Press firmly down on the insert when tightening the clamping screw.
3. To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded. (Please refer the table.1)
4. Ensure that there is no space between the insert and the insert seat.

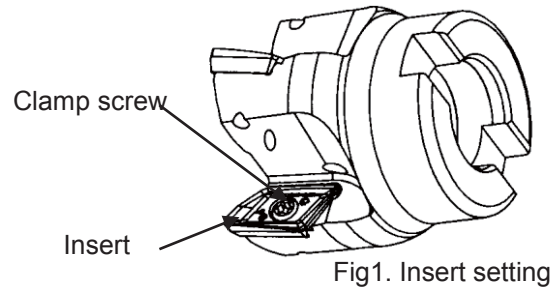


Table.1 Clamp torque

Type	Clamp screw	Torque size	Clamp torque[N·m]
BXD4000	TS4SL	T15	4.0~5.0
BXD7000	TS5S	T25	7.0~8.0
	TS5SL		

## 2.How to attach the tool (arbor type)

1. Before attaching to an arbor, ensure that all locating faces have been cleaned and are free of any obstructions.
2. Set the tool into the arbor, and locate using the setting screw provide with the tool.
3. The setting bolt provided with the BXD is specially designed for through coolant.
4. To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded.

Table.2 Set bolt

TYPE	Order No.	Clamp Torque [Nm]	Fig.	Diameter	
				BXD4000	BXD7000
①	HFF080043H	11	①	φ 40	
	HSC08030H	24			φ 50
②	HSC10030H	40	②	φ 50, φ 63	φ 63
	HSC12035H	80		φ 80	φ 80
	HSC16040H	150		φ 100	φ 100
	MBA20040H	320		φ 125	φ 125

## 3.etc.

1. BXD has two types of holder. A type is used for small nose R insert, and B type for large nose R insert.

Details are shown in the right table. Please use appropriate holder.

2. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured
3. Please replace the clamp screw periodically since they are consumption parts.

(Don't use the clamping screw whose TORX-Plus hole is damaged and wear progresses .)

5. Please refer to tools-news about the cutting conditions.

6. If you use BXD with long arbor or long shank holder , you must set the cutting condition low ( feed, depth of cut, width of cut , etc..)

7. In ramping , you must use BXD in low feed condition.

8. When using BXD at the speeds higher than max. allowable speed, inserts may disengage or parts may become damaged due to the strong centrifugal force generated. Regarding the Max. allowable RPM, please refer to tools-news. There are many cases that the arbor types are used at high speed. So max. allowable RPM as well as suitable tightening torque of the clamping screws are shown on it.

9. If you use BXD at higher speed than those in the table below, we will recommend that BXD is balanced with arbor.

TYPE	Order No.	Nose R size of insert
A	BXD*****A	0.4~3.2
B	BXD*****B	4.0~5.0

Dia.[mm]	φ 25	φ 32	φ 40	φ 50	φ 63	φ 80	φ 100	φ 125
Rev.[min-1]	12,000	9,500	7,600	6,000	4,800	3,800	3,000	2,400