

# Instruction manual for APX3000 shank type (INCH)

## 1. Possible setting the insert

APX3000 has 2 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.

Type	Order No.	Nose radius size
A	APX3000****A	R0.008~R0.079
B	APX3000****B	R0.118~R0.126

## 2. 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. (Clamp Torque=0.74FtLb)
4. Ensure that there is no space between the insert and the insert seat.

Clamping screw	Adopted Diam.
TPS25	$\Phi 1/2'' \sim \Phi 3/4''$
TPS25-1	$\Phi 1'' \sim \Phi 1-1/2''$

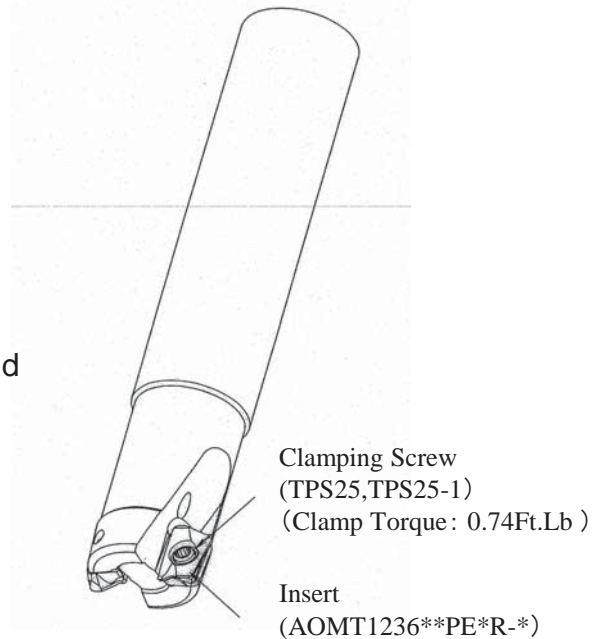


Fig1. Insert setting

## 3. Parts

1. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured .
2. 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

## 4. etc

1. Please refer to tools-news about the cutting conditions.
2. There is a danger of burn, if it is touched soon after cutting is done.
3. Don't touch the cutting edge of the insert with bare hand to prevent injury.
4. If you use APX with long shank, you must set the cutting conditions low ( feed, depth of cut, width of cut , etc..)
5. In ramping , you must use APX in a low feed condition.