

Instruction manual for APX3000 arbor type(INCH)

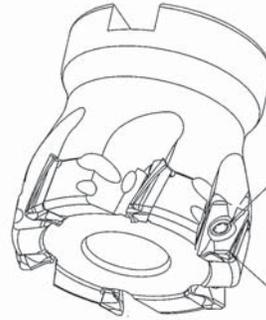
1. Possible setting the insert

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
(TPS25-1)
(Clamp Torque : 0.74Ft.Lb)

Insert
(AOMT1236**PE*R-*)

Fig1. Insert setting

3.How to attach the tool (arbor)

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 APX 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.1 Clamp torque of set bolt

Order No.	Clamp Torque [FtLb]	Holder
HSCU37513H	29.4	APX3000R0205A/B APX3000R0207A/B
HSCU50014H	59	APX3000R2506A/B APX3000R0306A/B APX3000R0309A/B

4.etc.

- 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 .
- 3.Please refer to tools-news about the cutting conditions.
4. If you use APX with long arbor, you must set the cutting condition low (feed, depth of cut, width of cut , etc..)
5. In ramping , you must use APX in low feed condition.